TANK ARMOR® PRODUCT DATA SHEET

SERIES 391

PRODUCT PROFILE

GENERIC DESCRIPTION
Polyamine Epoxy

COMMON USAGE
An internal epoxy lining formulated for aggressive chemical immersion and corrosion control of chemical tanks. Contains micro-fiber reinforcement for improved film integrity. Series 391 exhibits superior resistance to a wide range of chemicals, acids, and fractionation blends with excellent physical properties for long term durability and service life of transport and storage tanks. Contact Tnemec for more information.

COLORS
1234 Blue
Note: Epoxies chalk and yellow with age, extended exposure to UV and artificial lighting.

FINISH
Semi-gloss

COATING SYSTEM

PRIMERS
Self-priming
Note: Series 61 can be used as a primer under Series 391 depending on service conditions. Contact Tnemec Technical Service for recommendations.

REPAIR/TOUCH-UP
Series G312-1234TK

SURFACE PREPARATION

STEEL
SSPC-SP5/NACE 1 White Metal Blast Cleaning or ISO Sa 3 Blast Cleaning to Visually Clean Steel with a minimum angular anchor profile of 3.0 mils.

ALL SURFACES
Must be clean, dry and free of oil, grease and other contaminants.

TECHNICAL DATA

VOLUME SOLIDS
100% (mixed)

RECOMMENDED DFT
20.0 to 40.0 mils (500 to 1,015 microns), one coat with multiple passes.
Note: Series 391 can be applied to an optional high build thickness of 50 mils (1270 microns) in a single coat to meet specific industry requirements.

CURING TIME

<table>
<thead>
<tr>
<th>Temperature</th>
<th>To Handle</th>
<th>Max. Recoat</th>
<th>Immersion</th>
</tr>
</thead>
<tbody>
<tr>
<td>75°F (24°C)</td>
<td>8 hours</td>
<td>24 hours</td>
<td>5 days</td>
</tr>
</tbody>
</table>

Note: If more than 24 hours have elapsed between coats, the Series 391 coated surface must be mechanically abraded before topcoating. Note: For high temperature service (>90°F, 35°C) consult your Tnemec representative or Tnemec Technical Services. Curing time will vary with surface temperature, air movement, humidity and film thickness.

VOLATILE ORGANIC COMPOUNDS
Unthinned: 0.09 lbs/gallon (10 grams/litre)

HAPS
Unthinned: 0.00 lbs/gal solids

THEORETICAL COVERAGE
1,604 mil sq ft/gal (39.4 m²/L at 25 microns). See APPLICATION for coverage rates.

NUMBER OF COMPONENTS
Two: Three Part A (epoxy) to One Part B (amine)

PACKAGING

<table>
<thead>
<tr>
<th>Large Kit †</th>
<th>3-55 gallon drums</th>
<th>1-55 gallon drum</th>
<th>Yield (mixed)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Medium Kit †</td>
<td>3-6 gallon pails</td>
<td>1-6 gallon pail</td>
<td>200 gallons</td>
</tr>
</tbody>
</table>

† Plural Component application only.

NET WEIGHT PER GALLON
13.56 ± 0.25 lbs (6.15 ± .11 kg) (mixed)

STORAGE TEMPERATURE
Minimum 20°F (-7°C) – Maximum 110°F (43°C)

Prior to application, the material temperature should be between 70°F and 80°F (21°C and 27°C). It is suggested the material be stored at these temperatures at least 48 hours prior to use.

TEMPERATURE RESISTANCE
Chemical resistance varies depending on chemical exposure and temperature. Refer to Tnemec’s Chemical Resistance Guide for further information.

SHELF LIFE
Part A: 24 months and Part B: 24 months at recommended storage temperature

FLASH POINT - SETA
>230°F (>110°C)

HEALTH & SAFETY
This product contains chemical ingredients which are considered hazardous. Read container label warning and Material Safety Data Sheet for important health and safety information prior to the use of this product.

Keep out of the reach of children.
**APPLICATION**

**COVERAGE RATES**

Before commencing, obtain and thoroughly read the Series 391 Application Guide.

<table>
<thead>
<tr>
<th></th>
<th>Dry Mils (Microns)</th>
<th>Wet Mils (Microns)</th>
<th>Sq Ft/Gal (m²/Gal)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Suggested</td>
<td>30.0 (762)</td>
<td>30.0 (762)</td>
<td>53 (5.0)</td>
</tr>
<tr>
<td>Minimum</td>
<td>20.0 (508)</td>
<td>20.0 (508)</td>
<td>80 (7.5)</td>
</tr>
<tr>
<td>Maximum</td>
<td>40.0 (1015)</td>
<td>40.0 (1015)</td>
<td>40 (3.7)</td>
</tr>
</tbody>
</table>

*Note:* Series 391 can be applied to an optional high build thickness of 50 mils (1270 microns) in a single coat to meet specific industry requirements. Allow for overspray and surface irregularities. Application of coating below minimum or above maximum recommended dry film thicknesses may adversely affect coating performance.

**MIXING**

Power mix contents of each container, making sure no pigment remains on the bottom.

**Pre-Heating:** Heat each component to 110°F-120°F (43°C-49°C) prior to spraying.

**THINNING**

DO NOT THIN. Thinning will adversely affect performance properties.

**PURGE TIME**

Less than 60 seconds.

**APPLICATION EQUIPMENT**

HEATED PLURAL COMPONENT AIRLESS EQUIPMENT ONLY. Please refer to the Series 391 Application Guide for instructions on equipment. Contact Tnemec Technical Service for recommended equipment modifications.

**Brush:** Recommended for small areas, repairs and weld seams.

**SURFACE TEMPERATURE**

Minimum 60°F (16°C)     Maximum 120°F (49°C)

The surface should be dry and at least 5°F (3°C) above the dew point.

**CLEANUP**

Clean and purge lines immediately after use with No. 4 Thinner or MEK.