



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 | Temperature | To Handle | Max. Recoat | Immersion |
|-------------|-------------|-----------|-------------|-----------|
| | 75°F (24°C) | 8 hours | 24 hours | 5 days |

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 | PART A (Partially filled) | PART B (Partially filled) | Yield (mixed) |
|--------------|---------------------------|---------------------------|---------------|
| Large Kit † | 3-55 gallon drums | 1-55 gallon drum | 200 gallons |
| Medium Kit † | 3-6 gallon pails | 1-6 gallon pail | 20 gallons |

† Plural Component application only.

Note: Series G312-1234 TK can be used for repair or touch-up. Reference the Series 312 product data sheet for packaging and mixing information.

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.

TANK ARMOR® | SERIES 391

APPLICATION

COVERAGE RATES

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

| | Dry Mils (Microns) | Wet Mils (Microns) | Sq Ft/Gal (m ² /Gal) |
|-----------|--------------------|--------------------|---------------------------------|
| Suggested | 30.0 (762) | 30.0 (762) | 53 (5.0) |
| Minimum | 20.0 (508) | 20.0 (508) | 80 (7.5) |
| Maximum | 40.0 (1015) | 40.0 (1015) | 40 (3.7) |

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.

THINNING

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

PURGE TIME

DO NOT THIN. Thinning will adversely affect performance properties.

APPLICATION EQUIPMENT

Less than 60 seconds.

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.

SURFACE TEMPERATURE

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

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.

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