



PRODUCT PROFILE

**GENERIC DESCRIPTION** Ultra High-Build Reinforced Novolac Epoxy

**COMMON USAGE** A thick-film reinforced epoxy internal lining formulated for corrosion control and abrasion resistance in milling and process environments, chemical plants and refineries. Allows for ultra high-build application of 125 mils DFT. Series 396 exhibits superior corrosion and abrasion resistance for pipelines and process and storage tanks.

**COLORS** 1232 Blue. **Note:** Epoxies chalk and yellow with age, extended exposure to UV and artificial lighting.

**FINISH** Semi-gloss

**PERFORMANCE CRITERIA** Contact your Tnemec representative for specific test results.

COATING SYSTEM

**SURFACER/FILLER/PATCHER** Series 351

**PRIMERS** Self-priming

**REPAIR/TOUCH-UP** Series G390-1232TK

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%

**RECOMMENDED DFT** 40.0 to 125.0 mils (1,016 to 3,175 microns) one coat with multiple passes.

CURING TIME	Temperature	To Touch	To Handle	Immersion
	75°F (24°C)	2 hours	4 hours	8 to 10 hours

These times are based on a 40 mil (1,016 micron) dry film thickness. Higher film thicknesses, insufficient ventilation or cooler temperatures will require longer cure times. This coating commonly develops an amine-blush during cure. While this condition will not adversely affect performance of the coating, this blush must be removed by aggressive sweep blasting before applying additional coats. During high humidity conditions, it is recommended that the application be done while the temperatures are increasing. Cure time to achieve a minimum Shore D Hardness of 80 or Barcol GYZJ 935 hardness of 65 for immersion service is 8 to 10 hours. In order to obtain an accurate reading, the minimum DFT must be 30 mils.

**VOLATILE ORGANIC COMPOUNDS** 0.23 lbs/gallon (27 grams/litre)

**HAPS** 0.11 lbs/gal solids

**THEORETICAL COVERAGE** 1,604 mil sq ft/gal (39.4 m<sup>2</sup>/L at 25 microns). See APPLICATION for coverage rates.

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

**PACKAGING** KITS CONSIST OF:

	PART A (Partially filled)	PART B (Partially filled)	Yield (mixed)
Large Kit	2-55 gallon drums	1-55 gallon drum	150 gallons (567.8 L)
Small Kit	1-5 gallon pail	1-3 gallon pail	4 gallons (15.1 L)

**Note:** Series G390-1232 TK can be used for repair or touch-up. Reference the Series 390 product data sheet for packaging and mixing information.

**NET WEIGHT PER GALLON** 11.60 ± 0.25 lbs (5.26 ± .11 kg) (mixed)

**STORAGE TEMPERATURE** Minimum 20°F (-7°C) Maximum 110°F (43°C)  
For optimal handling and application characteristics, both material components should be stored at a minimum of 70°F (21°C) or higher for 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** 24 months at recommended storage temperature.

**FLASH POINT - SETA** Part A: >200°F (95°C) Part B: N/A

**HEALTH & SAFETY** Paint products contain 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 396

## APPLICATION

**COVERAGE RATES** Before commencing, obtain and thoroughly read the Series 396 Application Guide.

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m <sup>2</sup> /Gal)
Minimum	40.0 (1016)	40.0 (1016)	40 (3.7)
Maximum	125.0 (3175)	125.0 (3175)	13 (1.2)

Allow for overspray and surface irregularities. Film thickness is rounded to the nearest 0.5 mil or 5 microns. 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°-120°F (43°-49°C) prior to spraying. Refer to the Series 396 Application Guide for details.

**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 396 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 50°F (10°C) Maximum 120°F (49°C)

The surface should be dry and at least 5°F (3°C) above the dew point. Do not apply when humidity exceeds 80%. For tanks, dehumidification equipment is recommended if humidity exceeds 80%.

**CLEANUP** Clean up and purge lines immediately after use with No. 4 Thinner.

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