



PRODUCT PROFILE

GENERIC DESCRIPTION Modified Phenolic Epoxy

COMMON USAGE A high-build tightly cross-linked high performance epoxy with excellent resistance to a broad range of chemicals, solvents and petroleum over a wide range of temperatures. Principally used as a lining in single coat applications ranging from 20 to 40 mils. Refer to the Tank Armor Chemical Resistance Chart.

COLORS 1232 Blue, 1214 White. **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 Tank Armor®

PRIMERS Self-priming

SURFACE PREPARATION

STEEL SSPC-SP5/NACE 1/ISO Sa 3 White Metal Blast Cleaning with a minimum angular anchor profile of 3.0 mils. Refer to the Series 350 Tank Armor® Surface Preparation and Application Guide.

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

TECHNICAL DATA

VOLUME SOLIDS 100%

RECOMMENDED DFT 20.0 to 40.0 mils (508 to 1,016 microns) one coat with multiple passes.

CURING TIME

Temperature	To Touch	To Handle	Immersion
75°F (24°C)	3 hours	4 hours	24 to 36 hours

These times are based on a 20.0 mil (500 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 77 or Barcol GYZJ 935 hardness of 55 for immersion service is 24 to 36 hours. In order to obtain an accurate reading, the minimum DFT must be 30 mils.

VOLATILE ORGANIC COMPOUNDS 0.19 lbs/gallon (23 grams/litre)

HAPS 0 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 KITS CONSIST OF:

	PART A (Partially filled)	PART B	Yield (mixed)
Large Kit	3-55 gallon drums	1-55 gal drum (partial fill)	200 gallons (757.0 L)
Small Kit	1-5 gallon pail	1-1 gallon can	4 gallons (15.1 L)

NET WEIGHT PER GALLON 12.1 ± 0.25 lbs (5.49 ± .11 kg) (mixed)

STORAGE TEMPERATURE Minimum 50°F (10°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 (Dry) Continuous 275°F (135°C) Intermittent 300°F (149°C)

SHELF LIFE 24 months at recommended storage temperature.

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

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 350

APPLICATION

COVERAGE RATES

Before commencing, obtain and thoroughly read the Series 350 Tank Armor® Surface Preparation and Application Guide.

	Dry Mills (Microns)	Wet Mills (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 (1016)	40.0 (1016)	40 (3.7)

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°-120°F (43°-49°C) prior to spraying. Refer to the Series 350 Tank Armor® Surface Preparation and Application Guide for details on the heating and mixing of the material.

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 350 Tank Armor® Plural Component Equipment Recommendations Guide for complete instructions on equipment.

Contact Tnemec Technical Service for guide and equipment recommendations.

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.

WARRANTY & LIMITATION OF SELLER'S LIABILITY: Tnemec Company, Inc. warrants only that its coatings represented herein meet the formulation standards of Tnemec Company, Inc. THE WARRANTY DESCRIBED IN THE ABOVE PARAGRAPH SHALL BE IN LIEU OF ANY OTHER WARRANTY, EXPRESSED OR IMPLIED, INCLUDING BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. THERE ARE NO WARRANTIES THAT EXTEND BEYOND THE DESCRIPTION ON THE FACE HEREOF. The buyer's sole and exclusive remedy against Tnemec Company, Inc. shall be for replacement of the product in the event a defective condition of the product should be found to exist and the exclusive remedy shall not have failed its essential purpose as long as Tnemec is willing to provide comparable replacement product to the buyer. NO OTHER REMEDY (INCLUDING, BUT NOT LIMITED TO, INCIDENTAL OR CONSEQUENTIAL DAMAGES FOR LOST PROFITS, LOST SALES, INJURY TO PERSON OR PROPERTY, ENVIRONMENTAL INJURIES OR ANY OTHER INCIDENTAL OR CONSEQUENTIAL LOSS) SHALL BE AVAILABLE TO THE BUYER. Technical and application information herein is provided for the purpose of establishing a general profile of the coating and proper coating application procedures. Test performance results were obtained in a controlled environment and Tnemec Company makes no claim that these tests or any other tests, accurately represent all environments. As application, environmental and design factors can vary significantly, due care should be exercised in the selection and use of the coating.