



## SELECTION & SPECIFICATION DATA

<b>Type</b>	Cycloaliphatic Amine-Cured Novolac Epoxy
<b>Description</b>	Densely cross-linked, fiber reinforced, 100% solids epoxy novolac coating that provides superior long-term chemical resistance and corrosion protection against a wide range of acids, salts and strong caustics. The outstanding adhesion properties of Novocoat SC3300-50 Novolac Epoxy Lining make it ideal for use on marginally-prepared substrates while delivering maximum performance. Outstanding adhesion to previously epoxy-coated substrates provides extended recoat window.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Excellent thermal compatibility with steel and concrete</li> <li>• Fiber reinforced</li> <li>• Low permeation rate for tank lining service</li> <li>• Solvent free – 100% solids</li> <li>• Plural component spray application</li> <li>• Quick return-to-service – 24 hours at 77°F (25°C) for hydrocarbon immersion service</li> <li>• Single-coat application</li> </ul>
<b>Uses</b>	<ul style="list-style-type: none"> <li>• High-temperature immersion tank lining</li> <li>• Crude oil storage to 350°F (177°C)</li> <li>• Floor and chemical trenches in process areas</li> <li>• Secondary containment areas</li> <li>• Bulk petroleum storage tank lining</li> <li>• Process equipment supports and pads</li> <li>• Truck loading and unloading pads</li> <li>• Internal pipeline and vessel linings</li> </ul>
<b>Color</b>	Putty
<b>Finish</b>	Gloss
<b>Dry Film Thickness (DFT)</b>	18 – 50 mils (maximum 60 mils) per coat
<b>Solids Content</b>	99 – 100% by volume

## SUBSTRATES & SURFACE PREPARATION

<b>All</b>	Substrate must be clean, dry and free of contaminants.
<b>Steel</b>	<p>Immersion: SSPC-SP 10/NACE 2 Near White Metal Blast with angular profile of 2.5 – 3.5 mils.</p> <p>Non-immersion: SSPC-SP 6/NACE 3 Commercial Blast with angular profile of 1.5 – 3.0 mils, SSPC-SP 2 Hand Tool or SSPC-SP 3 Power Tool Cleaning are suitable for mild environments.</p> <p>Self-priming on steel.</p>
<b>Concrete or Concrete Masonry Units (CMU)</b>	Concrete must be cured 28 days at 75°F (24°C) and 50% relative humidity or equivalent. Prepare surfaces in accordance with SSPC-SP 13/NACE 6. Required surface profile is CSP 3-5. Voids in concrete surfaces may require filling. Mortar joints should be cured a minimum of 15 days. Prime with Novocoat SC1100 Primer/Sealer.

**Previously Painted Surfaces** Consult with ErgonArmor Technical Service.

## MIXING & THINNING

<b>Ratio</b>	3A:1B by volume
<b>Mixing</b>	Power mix separately, then combine and power mix.
<b>Thinning</b>	<p>Spray: Up to 6.5 oz/gal (5%) with Novocoat TH1710 Thinner</p> <p>Brush: Up to 16 oz/gal (12%) with Novocoat TH1710 Thinner</p> <p>Roller: Up to 16 oz/gal (12%) with Novocoat TH1710 Thinner</p>
<b>Pot Life</b>	35 minutes at 75°F (24°C)
	Pot life is shorter at higher temperatures. A larger volume of mixed material will have a shorter pot life than a smaller volume.
<b>Cleanup</b>	MEK or Acetone

## APPLICATION GUIDANCE

<b>Spray Application</b>	The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.
<b>Airless Spray Plural Component</b>	<p>Tip Size: 0.025 – 0.029-inch reversible type</p> <p>Part A Fluid Line: 1/2-inch ID</p> <p>Part B Fluid Line: 3/8-inch ID</p> <p>Spray Line: 1/2-inch ID x 50 feet maximum</p> <p>Diameter of Whip: 1/4-inch – 3/8-inch ID</p> <p>Whip Length: 6 ft</p> <p>Pump Size: 56:1 or greater</p> <p>Output: 4,000 – 5,500 psi output, filter removed</p> <p>Static Mixer: 2 x 1/2-inch ID x 12-inch long (24-inches total) behind mixing valve</p> <p>Part A Temperature: 130°F – 145°F (54°C – 63°C)</p> <p>Part B Temperature: 90°F – 95°F (32°C – 35°C)</p>

**Brush & Roller** Multiple coats may be required to obtain desired appearance, recommended dry film thickness and adequate hiding when using a brush or roller for touch-up or stripe coating. Avoid excessive re-brushing or re-rolling. For best results, tie in within 10 minutes at 75°F (24°C).

**Brush** Use a medium bristle brush.

**Roller** Use a short-nap synthetic roller cover with phenolic core.

## CURE SCHEDULE & RECOAT WINDOW

SUBSTRATE TEMPERATURE	MINIMUM RECOAT	MAXIMUM RECOAT	RETURN TO SERVICE (IMMERSION)
50°F (10°C)	8 hours	14 days	7 days
77°F (25°C)	3 hours	14 days	7 days
140°F (60°C)	1 hour	1 hour	4 hours
Dry-to-touch: 4 hours at 77°F (25°C)			

Return-to-service varies with chemical exposure. Consult ErgonArmor Technical Service for guidance.



# ErgonArmor™

## Novocoat SC3300-50 Novolac Epoxy Lining

### SAFETY

#### Safety

Mixes and applications of this product present a number of hazards. Read and follow the hazard information, precautions and first aid directions on the individual product labels and safety data sheets before using.

#### Ventilation

Provide thorough air circulation during and after application until the material has cured when used in enclosed areas.

### PACKAGING, ESTIMATING & HANDLING

#### Package Sizes

Putty, 200-gal (757 L) Kit  
 - Part A Resin Beige, 3 x 50-gal (189 L) Drums  
 - Part B Hardener Black, 1 x 50-gal (189 L) Drum  
 Item #: M-EL3470-200GLKT-1

#### Theoretical Coverage

89 square feet per gallon at 18 mils  
 53 square feet per gallon at 30 mils  
 32 square feet per gallon at 50 mils  
 Allow for loss in mixing and application.

#### Storage & Shelf Life

Maintain product in original packaging and sealed until ready for use. Estimated shelf life is 12 months when stored in a dry area at 75°F (24°C). Actual shelf life may vary with storage conditions. Do not store below 40°F (4°C) or above 110°F (43°C).

If there is any question with respect to the quality of the components, check reactivity prior to use. Consult ErgonArmor Technical Service for assistance.

### TYPICAL PHYSICAL PROPERTIES

PROPERTY	SYSTEM	VALUE
Dry adhesion ASTM D4541	Blasted steel 1 coat	>3,000 psi (20 MPa)
Wet adhesion ASTM D4541 5 days 158°F (70°C) water	Blasted steel 1 coat	>3,000 psi (20 MPa)
Abrasion resistance ASTM D4060	1000 cycles, CS17 wheel 1000 g load	0.51 mils loss of DFT 1,960 cycles per mil
Compressive strength ASTM C109	Blasted steel 1 coat	10,000 – 13,000 psi (69 – 90 MPa)
Hardness ASTM D2240	Blasted steel 1 coat	83 – 90 Shore "D"

### SERVICE TEMPERATURE

SERVICE	MAXIMUM TEMPERATURE
Dry, continuous	350°F (177°C)
Under insulation, continuous	300°F (149°C)

Temperature limitations will vary with chemical exposure. Consult ErgonArmor Technical Service for guidance.

Discoloration and loss of gloss occur above 200°F (93°C) but do not affect performance.

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