



SELECTION & SPECIFICATION DATA

Generic Type	Polyamide Epoxy
Description	A thin-film epoxy internal lining formulated for corrosion control and restoration of petroleum storage tanks. Flexibilized to reduce coating stress resulting from mechanical and physical forces exerted on the tank bottom. Lining may also be used for chemical storage tanks providing good chemical resistance to organic acids, alkali and salts. Known for its forgiving application characteristics in adverse and varied conditions.
Features	<ul style="list-style-type: none"> • 100% Solids, No VOCs • Excellent immersion resistance • Long term wear protection • ANSI/NSF 61 Certified
Recommended Uses	<ul style="list-style-type: none"> • Tank linings • Secondary Containment • Multi-Purpose Epoxy
Color/Part #	Light Gray (SP2310), Dark Gray (SP2320), Black (SP2330), Red (SP2340), Blue (SP2350), White (SP2360)
Finish	Gloss
Primer	Self-priming
Dry Film Thickness	8 – 12 mils per coat
Solids Content	By Volume 100% +/- 1%
Theoretical Coverage Rate	1604 ft ² at 1 mil 106 ft ² at 15 mils 64 ft ² at 25 mils Allow for loss in mixing and application.
Dry Temp. Resistance	Continuous: 220°F (104°C) Non-Continuous: 250°F (121°C) Discoloration and loss of gloss occurs above 200°F (93°C) but does not affect performance.
Under Insulation Resistance	Continuous: 175°F (79°C)

SUBSTRATES & SURFACE PREPARATION

General	Surfaces must be clean and dry. Remove all dirt, dust, oil and all other contaminant.
Steel	Immersion: SSPC-SP10 Near White with jagged profile of 2.5 – 3.5 mils. Non-immersion: SSPC-SP6 1.5 – 3.0 mils SSPC-SP2 or SP3 are suitable cleaning methods for mild environments.

Concrete or CMU

Concrete must be cured 28 days at 75°F (24°C) and 50% relative humidity or equivalent. Prepare surfaces in accordance with ASTM D4258 Surface Cleaning of Concrete and ASTM D4259 Abrading Concrete. Voids in concrete may require surfacing. Mortar joints should be cured a min of 15 days. Prime with Novocoat SC1100 Concrete Primer

Previously Painted Surfaces

Consult with ErgonArmor Technical Service Department

MIXING & THINNING

Mixing	Power mix separately, then combine and power mix. DO NOT MIX PARTIAL KITS.
Thinning	Spray: Up to 6.5 oz/gal (5%) w/ TH1710 Brush: Up to 16 oz/gal (12%) w/ TH1710 Roller: Up to 16 oz/gal (12%) w/ TH1710 Use of thinners other than those supplied or recommended by ErgonArmor may adversely affect product performance and void product warranty, whether expressed or implied.
Ratio	3:1 Ratio (A to B) by Volume
Pot Life	8 hours 20 minutes at 5°C (41°F) 2 hours at 25°C (77°F) 50 minutes at 33°C (92°F)

Do not keep the blended coating in the original container unless immediate use is planned. Otherwise, exothermic heat created during the curing process will considerably shorten the pot life. Pour the coating into a rolling tray or large aluminum-basting pan. Try to keep the depth of the coating in the tray below ¾".

APPLICATION EQUIPMENT GUIDELINES

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.

Spray Application (General)	This is a 100% solids coating and may require adjustments in spray techniques. Wet film thickness is easily and quickly achieved. The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.
Airless Spray Plural Component	Tip Size: .025 – .029 reversible type Diameter of Part A Fluid Line: 1/2" ID Diameter of Part B Fluid Line: 3/8" ID Spray Line: 1/2" ID x 50 feet maximum Diameter of Whip: 1/4 – 3/8" ID Length of Whip: 20 feet Power Ratio Pump: 56:1 or greater Static Mixer: 2 x 1/2" ID x 12" in length behind mixing valve Part A Temperature: 130 – 135°F in reservoir tank Part B Temperature: 90 – 95°F in reservoir tank

**Airless Spray
Single Leg or
Hot Pot**

Pump Size: 56:1 or greater
 Hose Length/Diameter: 50 ft x 3/8"
 Whip Length/Diameter: 10 ft x 1/4"
 Work Life, 4 gallons at 32°C (90°F):
 No Thinner: 25 minutes
 3 – 5% Thinner: 35 – 40 minutes

Part A resin and Part B hardener should be heated individually to 75 – 85°F before mixing so product will atomize properly in delivering paint to the substrate. Mixed product should be sprayed within 20 minutes after mixing.

**Brush & Roller
(General)**

Brush/Roller Application
 This material may be applied with brush or roller. Be aware of working life when using brush or roller application.

Brush

Use a medium bristle brush.

Roller

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

CLEANUP & SAFETY
Cleanup

Use MEK or Acetone. In case of spillage, absorb and dispose of in accordance with local applicable regulations.

Safety

Read and follow all caution statements on this product data sheet and on the MSDS for this product. Wear protective clothing, gloves and use protective cream on face, hands and all exposed areas.

Ventilation

When used as a tank lining or in enclosed areas, thorough air circulation must be used during and after application until the coating is cured. User should test and monitor exposure levels to insure all personnel are below guidelines.

PACKAGING, HANDLING & STORAGE
Shelf Life

Part A: 12 months at 75°F (24°C)
 Part B: 12 months at 75°F (24°C)
 *When kept at recommended storage conditions and in original unopened containers.

**Shipping
Weight
(Approximate)**

1 Gallon Kit: 12 lbs (5.45 kg)
 4 Gallon Kit: 50 lbs (22.73 kg)
 5 Gallon Bulk pails: Part A 70 lbs/Part B 44 lbs
 50 Gallon Drums: Part A 700 lbs/Part B 450 lbs

**Storage
Temperature &
Humidity**

40° – 110°F (4° – 43°C)
 0 – 100% Relative Humidity

Storage

Store Indoors.
 This product is not affected by excursions below these published storage temperatures, down to 10°F, for a duration of no more than 14 days. Always inspect the product prior to use to make sure it is smooth and homogeneous when properly mixed.

PERFORMANCE DATA

TEST METHOD	SYSTEM	RESULTS
ASTM D-4541 Dry	Blasted Steel 1 ct.	>2,500 psi
ASTM D-4541 Dry	Scuffed FBE 1 ct.	>2,000 psi
ASTM D-4541 Wet 5 days 70 °C water	Blasted Steel 1 ct.	>2,500 psi
ASTM D 4060 Abrasion 1000 cycles, CS17 wheel 1000 gm. load	Blasted Steel 1 ct.	80 mg. loss 770 cycles per mil
ASTM C-109 Compressive Strength	Blasted Steel 1 ct.	10,000 – 13,000 psi
ASTM D-2240 Hardness	Blasted Steel 1 ct.	83 – 90 Shore D
Meets the performance requirements of AWWA C210 and FDA requirement 21 CFR 175.300 for food contact.		

CURE SCHEDULE & RE-COAT WINDOW

TEMPERATURE	MINIMUM RE-COAT	MAXIMUM RE-COAT	RETURN TO SERVICE (AQUEOUS/ HYDROCARBON IMMERSION)
10°C (50°F)	8 hours	14 days	7 days
25°C (77°F)	4 hours	14 days	72 hours
60°C (140°F)	1 hour	Not recommended	4 hours

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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 material safety data sheets before using. While all statements, technical information, and recommendations contained herein are based on information our company believes to be reliable, nothing contained herein shall constitute any warranty, express or implied, with respect to the products and/or services described herein and any such warranties are expressly disclaimed. We recommend that the prospective purchaser or user independently determine the suitability of our product(s) for their intended use. No statement, information or recommendation with respect to our products, whether contained herein or otherwise communicated, shall be legally binding upon us unless expressly set forth in a written agreement between us and the purchaser/user. Please contact ErgonArmor for further information at 877.982.7667 or FAX 601-933-3381. For all Terms and Conditions of Sale see ergonarmor.com.

ORDERING INFORMATION

For additional information, prices, or to place an order, please contact your ErgonArmor sales representative. If you do not know the name of your sales representative, call 877-98ARMOR.