

## SELECTION & SPECIFICATION DATA

<b>Type</b>	Polyamide Epoxy
<b>Description</b>	Novocoat SG2500 Lining is a high build, high flexural strength epoxy lining for concrete, steel, or ductile iron. Damp surface tolerant and resistant to hydrogen sulfide attack, it is also well suited for municipal wastewater sewers, manholes, and wet wells.
<b>Features</b>	<ul style="list-style-type: none"> <li>• 100% solids, no VOCs</li> <li>• H<sub>2</sub>S resistant</li> <li>• Moisture tolerant</li> <li>• Long-term wear protection</li> <li>• 125 mils in a single coat</li> <li>• Meets AWWA C210 performance requirements</li> </ul>
<b>Uses</b>	<ul style="list-style-type: none"> <li>• Tank linings</li> <li>• Secondary containment</li> <li>• Manholes</li> <li>• Lift stations</li> <li>• Pipe coatings and linings</li> </ul>
<b>Color</b>	Light green
<b>Finish</b>	Gloss
<b>Dry Film Thickness (DFT)</b>	30 – 125 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-SP2 Hand Tool or SSPC-SP3 Power Tool Cleaning are suitable for mild environments.</p> <p>Self-priming on steel.</p>
<b>Concrete or Concrete Masonry Unit (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 4-7. Voids in concrete surfaces may require filling. Mortar joints should be cured a minimum of 15 days. Prime with Novocoat SC1100 Concrete Primer.
<b>Previously Painted Surfaces</b>	Consult with ErgonArmor Technical Service Department.

## MIXING & THINNING

<b>Ratio</b>	2A:1B by volume
<b>Mixing</b>	Power mix separately, then combine and power mix.
<b>Thinning</b>	<p>Spray: Do not thin</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>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 reversible type</p> <p>Part A Fluid Line: 1/2 in ID</p> <p>Part B Fluid Line: 3/8 in ID</p> <p>Spray Line: 1/2 in ID x 50 feet maximum</p> <p>Whip: 1/4 in – 3/8 in ID</p> <p>Whip Length: 20 feet</p> <p>Pump Size: 56:1 or greater</p> <p>Output: 4,000 - 6,000 psi, filter removed</p> <p>Static Mixer: 2 x 1/2 in ID x 12 in (24 inches total length) behind mixing valve</p> <p>Part A Temperature: 130°F – 135°F (54°C – 57°C)</p> <p>Part B Temperature: 90°F – 95°F (32°C – 35°C)</p>

**Brush & Roller** This material may be applied with brush or roller. Be aware of work life when using brush or roller application.

**Brush** Medium bristle brush.

**Roller** Short-nap synthetic roller cover with phenolic core.

## CURE SCHEDULE & RECOAT WINDOW

TEMPERATURE	MINIMUM RECOAT	MAXIMUM RECOAT	RETURN TO SERVICE (HYDROCARBON IMMERSION)
50°F (10°C)	35 minutes	24 hours	4 days
77°F (25°C)	15 minutes	24 hours	12 hours
140°F (60°C)	Not recommended		4 hours

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

## SAFETY

<b>Safety</b>	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.
<b>Ventilation</b>	Provide thorough air circulation during and after application until the material has cured when used in enclosed areas.

## ESTIMATING & PACKAGING

<b>Theoretical Coverage</b>	53 square feet per gallon at 30 mils 12.8 square feet per gallon at 125 mils Allow for loss in mixing and application.
<b>Package Sizes</b>	<p>Light Green, 15-gal (57 L) bulk unit Order 2 pails Part A and 1 pail Part B separately - Part A Resin Light Gray, 2 x 5 gal (19 L) pails Item #: M-SG2510A-5GLB-01 - Part B Hardener Green, 1 x 5 gal (19 L) pail Item #: M-SG2508B-5GLB-01</p> <p>Light Green, 150-gal (568 L) bulk unit Order 2 drums Part A and 1 drum Part B separately - Part A Resin Light Gray, 2 x 50 gal (189 L) drums Item #: M-SG2510A-DRUM-01 - Part B Hardener, Green 50 gal (189 L) drum Item #: M-SG2508B-DRUM-01</p>
<b>Storage &amp; Shelf Life</b>	<p>Maintain products in original packaging and sealed until ready for use. Estimated shelf life is 12 months when stored in a dry area at 70°F (21°C). Actual shelf life may vary with storage conditions.</p> <p>If there is any question with respect to the quality of the components, check reactivity prior to use. For assistance consult with ErgonArmor.</p>

## TYPICAL PHYSICAL PROPERTIES

TEST METHOD	SYSTEM	RESULTS
Dry adhesion ASTM D4541	Blasted steel 1 coat	>3,000 psi
Dry adhesion ASTM D4541	Concrete 1 coat	>400 psi concrete failure
Wet adhesion ASTM D4541 5 days 158°F (70°C) water	Blasted steel 1 coat	>2,500 psi
Abrasion ASTM D4060 1000 cycles, CS17 wheel 1000 gm load	Blasted steel 1 coat	80 mg loss 770 cycles per mil
Compressive strength ASTM C109	Blasted steel 1 coat	12,000 – 15,000 psi
Hardness ASTM D2240	Blasted steel 1 coat	83 – 85 Shore D
Elongation ASTM D638		5%
Meets the performance requirements of AWWA C210		

## TEMPERATURE RESISTANCE

SERVICE	MAXIMUM TEMPERATURE
Dry, continuous	220°F (104°C)
Dry, intermittent	250°F (121°C)
Under insulation	175°F (79°C)

Temperature limitations will vary with cargo. 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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