



SELECTION & SPECIFICATION DATA

Type	Epoxy Paste/Caulk
Description	Novocoat SC3900 Adhesive Paste/Caulk is a two-component 100% solids trowel-grade epoxy novolac caulk for use as a chime repair or lap weld feathering product for steel tanks. It is often used in conjunction with chemical resistant topcoats such as Novocoat SC3300 Novolac Epoxy Lining or Novocoat SC5400 Lining. Excellent chemical resistance to a wide range of petrochemicals, fuels, organic/inorganic acids and alkalis. Long recoat window allows it to be top-coated up to 14 days, depending on temperatures.
Features	<ul style="list-style-type: none"> • 100% solids, no VOCs • Application and cure at room temperature • Multipurpose durable repair composite • No shrinkage, expansion or distortion • Quick return-to-service • Fully machinable using conventional tools
Uses	<ul style="list-style-type: none"> • Tank chime repair • Lap weld feathering • Anchor adhesive • Resurface pitted metal surfaces • Leak repair • Plate bonding • Resurface pump casings • High strength structural adhesive for metal bonding
Color	Gray
Finish	Matte
Solids Content	100% by volume

SUBSTRATES & SURFACE PREPARATION

All	Substrate must be clean, dry and free of contaminants.
Steel	<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>
Weld Repair	Use a flame to sweat out oil from deeply impregnated surfaces. Stabilize cracks by drilling the extremities. Long cracks should be drilled, tapped and bolted every few inches. Vee-out all cracks using a file. Degrease using clean rags.
Substrate Temperature	Surface should be at least 50°F (10°C) and relative humidity not to exceed 90%. Maximum substrate temperature should be kept to 140°F (60°C). Contact ErgonArmor for conditions where the substrate temperature exceeds 140°F (60°C).

MIXING & THINNING

Mixing	DO NOT MIX PARTIAL KITS. Transfer the entire contents of the Resin and Hardener onto the plastic mix board. Mix together thoroughly until color of material is uniform and free of streaks.
Thinning	Do not thin.
Pot Life	45 minutes in 8 fl oz mass at 77°F (25°C)
	Pot life is shorter at higher temperatures. A larger volume of mixed material will have a shorter pot life than a smaller volume.
Cleanup	MEK or Acetone

APPLICATION GUIDANCE

Application	Apply directly onto the prepared surface with the plastic applicator or spatula provided. Press down firmly to remove entrapped air, fill all cracks, and ensure maximum contact with the surface. Use reinforcement cloth over holes and cracks. Fully machinable using conventional tools once cured.
Brush & Roller	Brush or roller can be used to smooth uncured surface with solvent if desired.

CURE SCHEDULE & RECOAT WINDOW

TEMPERATURE	MINIMUM RECOAT	MAXIMUM RECOAT	RETURN-TO-SERVICE (AQUEOUS/HYDROCARBON IMMERSION)
50°F (10°C)	12 hours	14 days	7 days
77°F (25°C)	3 hours	14 days	24 hours
140°F (60°C)	1 hour	7 days	4 hours

Return-to-service will vary with chemical service. Consult with ErgonArmor Technical Service for guidance.

Tack free at 77°F (25°C) ASTM D1640	3.5 hours for 25 – 30 mil DFT
Dry hard at 77°F (25°C) ASTM D1640	8 hours for 25 – 30 mil DFT

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.



ESTIMATING & PACKAGING

Theoretical Coverage	12.8 square feet per gallon at 125 mils Allow for loss in mixing and application.
Package Sizes	Light Gray, 1 gal (3.8 L) Kit -Part A Resin, Light Gray, 10.4 lbs (4.7 kg) Pail -Part B Hardener, Clear, 2.1 lbs (0.95 kg) Pail Item #: M-SC3910-1GLKT-01 Light Gray, 4 x 2.5 lb (1.1 kg) Kit Case Each 2.5 lb (1.1 kg) kit includes - Part A Resin, Light Gray, 2.1 lbs (0.95 kg) Can - Part B Hardener, Clear, 0.43 lbs (0.2 kg) Jar - Mixing knife, spreader Each case includes a mixing board. Item #: M-SC3910-QTCS-01
Storage & Shelf Life	Maintain products in original packaging and sealed until ready for use. Estimated shelf life is 24 months for part A and 12 months for part B when stored in a dry area at 75°F (24°C). Actual shelf life may vary with storage conditions. If there is any question with respect to the quality of the components, check reactivity prior to use. For assistance consult with ErgonArmor.

TYPICAL PHYSICAL PROPERTIES

METHOD	RESULTS
Dry adhesion ASTM D4541 Blasted steel 1 coat	>2,850 psi
Flash point	>250°F (121°C)
Specific gravity, mixed	1.47
VOC	0 grams/liter
Density	12.2 lbs/gal

TEMPERATURE RESISTANCE

SERVICE	TEMPERATURE
Dry	400°F (204°C)
Splash/spill	Up to 360°F (182°C) depending upon chemical service
Immersion	Up to 300°F (149°C) depending upon chemical service. For immersion service over 150°F (66°C), consult ErgonArmor Technical Service for guidance.

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