# Novocoat™ SC6300 Epoxy

## SELECTION & SPECIFICATION DATA

**Type**
Novolac Epoxy

**Description**
Novocoat SC6300 Epoxy is a two-component, 100% solids, novolac epoxy coating system, engineered for extreme temperature and corrosive conditions.

**Features**
- Excellent chemical resistance to wide range of acids and caustics
- Low permeation rate for tank lining service
- Solvent free - 100% solids

**Uses**
- Pipe wraps
- Secondary containment areas
- Chemical process equipment supports and pads
- Heat exchangers and tube sheets
- Internal bulk storage tank, pipe and vessel lining

**Color**
Clear

**Finish**
Gloss

**Dry Film Thickness (DFT)**
2 or 3 coats at 8 or 12 mils each
3 or 4 coats at 8 or 12 mils each for high temperatures or severe chemical service

**Solids Content**
99 - 100% by volume

## SUBSTRATES & SURFACE PREPARATION

**All**
Substrate must be clean, dry and free of contaminants.

**Steel**
Immersion: SSPC-SP 10/NACE 2 Near White Metal Blast with angular profile of 2.5 - 3.5 mils.

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.

Self-priming on steel.

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

## MIXING & THINNING

**Ratio**
3A:1B by volume

**Mixing**
Except for plural spray applications, do not mix partial kits. Power mix parts A and B separately then combine and power mix.

**Thinning**
Spray: Up to 6.5 oz/gal (5%) with Novocoat TH1710 Thinner
Brush: Up to 8 oz/gal (6%) with Novocoat TH1710 Thinner
Roller: Up to 8 oz/gal (6%) with Novocoat TH1710 Thinner

**Pot Life**
30 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.

**Cleanup**
MEK or Acetone

## APPLICATION GUIDELINES

**Spray Application**
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: 0.015-inch to 0.025-inch, reversible type
Part A Fluid Line: 1/2-inch ID
Part B Fluid Line: 3/8-inch ID
Spray Line: 1/2-inch ID x 50 feet maximum
Whip: 1/4 to 3/8-inch ID x 20 feet maximum
Pump Size: 56:1 or greater
Output: 1,500 - 3,500 psi
Static Mixer: 2 x 1/2-inch ID x 12 inches (24-inch total length) behind mixing valve
Part A Temperature: 115°F - 125°F (46°C - 52°C)
Part B Temperature: 90°F - 95°F (32°C - 35°C)

**Airless Spray Single Leg or Hot Pot**
Pump Size: 56:1 or greater
Hose: 3/8-inch ID minimum x 50 feet maximum
Whip: 10 ft x 1/4-inch to 3/8-inch ID (minimum)
Tip Size: 0.027-inch – 0.029-inch
Output: 5600 to 7000 psi, filter removed

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

**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 ) | 3 hours | 12 hours | 7 days |
| 77°F (25°C) | 1.5 hours | 6 hours | 7 days |
| 140°F (60°C) | 10 minutes | Not recommended | 4 hours |

Dry-to-touch: 4 hours at 77°F (25°C)

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

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## PACKAGING, ESTIMATING & HANDLING

| ITEM# | PRODUCT | PACKAGING |
|---|---|---|
| M-SC6300-1GLKT-01 | Novocoat SC6300 Epoxy | 0.89 gal (3.4 L) Kit |
| | - Part A Resin | 6.4 lbs (2.9 kg) Pail |
| | - Part B Hardener | 2 lbs (0.91 kg) Bottle |

**Theoretical Coverage**

200 square feet per gallon at 8 mils
133 square feet per gallon at 12 mils
Allow for loss in mixing and application.

**Storage & Shelf Life**

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. 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. For assistance consult with Armor.

## 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.

## TYPICAL PHYSICAL PROPERTIES

| PROPERTY | SYSTEM | VALUE |
|---|---|---|
| Dry adhesion<br>ASTM D4541 | Blasted steel 1 coat | >3,000 psi (21 MPa) |
| Wet adhesion<br>ASTM D4541<br>5 days 158°F (70°C) water | Blasted steel 1 coat | >2,500 psi (17 MPa) |
| Abrasion<br>ASTM D4060 | 1000 cycles, CS17 wheel 1000 gm load | <40 mg |
| Compressive strength<br>ASTM C109 | | 11,000 - 14,000 psi<br>(75 - 96 MPa) |
| Hardness<br>ASTM D2240 | Blasted steel 1 coat | 84 Shore D |

## TEMPERATURE RESISTANCE

| SERVICE | MAXIMUM TEMPERATURE |
|---|---|
| Dry, continuous | 450°F (232°C) |
| Dry, non-Continuous | 550°F (288°C) |
| Under insulation | 300°F (149°C) |

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

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

Rev. 12/2025