

## SELECTION & SPECIFICATION DATA

<b>Type</b>	Epoxy Paste/Caulk
<b>Description</b>	Novocoat SP2900 Paste is a two-component 100% solids trowel-grade epoxy novolac metal repair paste commonly used to repair tank chimes, fill pitted surfaces and feather lap welds before top-coating with Novocoat SC3300 Novolac Lining or Novocoat SP2000 Series coatings. Excellent 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.
<b>Features</b>	<ul style="list-style-type: none"> <li>• 100% solids, no VOCs</li> <li>• Application and cure at room temperature</li> <li>• Multipurpose durable repair composite</li> <li>• No shrinkage, expansion or distortion</li> <li>• Quick return-to-service</li> <li>• Fully machinable using conventional tools</li> </ul>
<b>Uses</b>	<ul style="list-style-type: none"> <li>• Anchor adhesive</li> <li>• Resurface of pitted metal surfaces</li> <li>• Leak repair</li> <li>• Plate bonding</li> <li>• Pump casing</li> <li>• High strength structural adhesive for metal bonding</li> </ul>
<b>Color</b>	Light gray
<b>Finish</b>	Matte
<b>Primer</b>	Self-priming
<b>Solids Content</b>	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 2 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>
<b>Weld Repair</b>	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.

## MIXING & THINNING

<b>Mixing</b>	Do not mix partial kits. To mix small kits, transfer the entire contents of resin and hardener onto the plastic mix board. Mix thoroughly together until color of material is uniform and free of any streaks. To mix large kits, combine resin and hardener and mix with a mechanical mixer.
<b>Thinning</b>	Do not thin.
<b>Pot Life</b>	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.
<b>Cleanup</b>	MEK or Acetone

## APPLICATION GUIDELINES

<b>Conditions</b>	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 Armor for conditions where the substrate temperature exceeds 140°F (60°C).
<b>Application</b>	Apply directly onto the prepared surface with the spreader or mixing knife 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.
<b>Brush &amp; Roller</b>	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 (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 exposure. Consult with Armor 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	

## **PACKAGING, ESTIMATING & HANDLING**

ITEM#	PRODUCT	PACKAGING
M-SP2910-QTCS-01	Novocoat SP2900 Paste, Light Gray Case includes 1 mixing board Each kit includes: - Part A Resin, Light Gray - Part B Hardener - Mixing knife, spreader	4 x 2.1 lbs (0.95 kg) Kit Case  1.8 lbs (0.8 kg) Jar 5.6 oz (159 g) Jar
M-SP2910-1GLKT-01	Novocoat SP2900 Paste, Light Gray - Part A Resin, Light Gray - Part B Hardener	10.6 lbs (4.8 kg) Kit 8.8 lbs (4.0 kg) Pail 1.8 lbs (0.8 kg) Jar

**Theoretical Coverage** 12.8 square feet per gallon at 125 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 24 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	VALUE
Dry adhesion ASTM D4541 Blasted steel 1 coat	>2,850 psi (20 MPa)
Flash point	Greater than 250°F (121°C)
Specific gravity	Part A: 1.36 Part B: 0.82
VOC	0 lb/gal (0 g/L)
Density	Part A: 11.3 lbs/gal (1.35 kg/L) Part B: 6.8 lbs/gal (0.81 kg/L)

## **TEMPERATURE RESISTANCE**

SERVICE	TEMPERATURE
Dry	250°F (121°C)
Splash/spill	200°F (93°C)
Immersion	150°F (65°C)
Temperature limitations will vary with chemical exposure. Consult Armor Technical Service for guidance.	

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