Novocoat EP3300 Paste/Caulk SG

SELECTION & SPECIFICATION DATA

Type Epoxy Paste/Caulk

Description Novocoat EP3300 Paste/Caulk SG is a two-component 100% solids trowel applied epoxy novolac caulk formulated for use in warm conditions. This summer grade formula provides longer pot life in higher temperatures. It is commonly used to repair tank chimes or feather lap welds prior to applying Novocoat chemical resistant topcoats. It has excellent resistance to a wide range of petrochemicals, fuels, organic and inorganic acids, and alkalis.

Features
- 100% solids, no VOCs
- Longer pot life in warm conditions
- Multipurpose, durable repair composite
- No shrinkage, expansion, or distortion
- Quick return-to-service under suitable conditions
- Fully machinable using conventional tools

Uses
- Fill pitted metal surfaces
- Repair leaks
- Rebuild pumps
- Bond metal parts

Color Light Gray

Finish Matte

Solids Content 100% solids 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.

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.

MIXING & THINNING

Ratio 1A:1B by volume

Mixing Mix equal parts of the resin and hardener thoroughly until color of material is uniform and free of streaks.

Thinning Do not thin.

Pot Life 25 minutes in a 150g mass at 86°F (30°C)
16 minutes in a 150g mass 122°F (50°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

Conditions Substrate surface temperature 70°F - 140°F (21°C - 60°C) and at least 5°F (3°C) above the dew point and rising. If surface temperature is above 140°F (60°C), consult Armor Technical Service for guidance.

Application 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.

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 (HYDROCARBON IMMERSION)
86°F (30°C)	1 hour	48 hours	7 days
104°F (40°C)	1 hour	24 hours	48 hours
122°F (50°C)	30 minutes	8 hours	24 hours

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

Tack free at 86°F (30°C) ASTM D1640	65 minutes for 125 mil DFT film
Tack free at 122°F (50°C) ASTM D1640	23 minutes for 125 mil DFT film
Dry hard at 86°F (30°C) ASTM D1640	180 minutes for 125 mil DFT film
Dry hard at 122°F (50°C) ASTM D1640	30 minutes for 125 mil DFT film

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PACKAGING, ESTIMATING & HANDLING

ITEM#	PRODUCT	PACKAGING
M-EP3310S-2GLKT-01	Novocoat EP3300 SG Paste/Caulk Kit, Light Gray	24 lb (10.88 kg) Kit
	- Part A Resin, White	12.4 lb (5.62 kg) Pail
	- Part B Hardener, Black	11.6 lb (5.26 kg) Pail

Theoretical Coverage

53.3 square feet per 2-gallon kit at 60 mils.
25.6 square feet per 2-gallon kit at 125 mils.

Coverage will vary depending on application. 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 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. 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
Pull-off adhesion, dry ASTM D4541 Blasted steel 1 coat	>2,850 psi (20 MPa)
Flash Point	Greater than 250°F (121°C)
Specific gravity	Part A: 0.53 Part B: 1.40
VOC	0 lb/gal (0 g/L)
Density	Part A: 12.7 lbs/gal (1.5 kg/L) Part B: 11.7 lbs/gal (1.4 kg/L) Mixed: 12.2 lbs/gal (1.5 kg/L)

SERVICE TEMPERATURE

SERVICE	MAXIMUM TEMPERATURE
Dry	350°F (176°C)
Splash/spill	293°F (145°C)
Immersion	194°F (90°C)

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

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