

## SELECTION & SPECIFICATION DATA

<b>Type</b>	Epoxy Paste/Caulk
<b>Description</b>	Novocoat EP3300 Paste/Caulk is a two-component 100% solids trowel-grade epoxy novolac caulk commonly used to repair tank chimes or feather lap welds prior to top-coating with chemical resistant topcoats, such as Novocoat SC3300 Novolac Epoxy Lining or Novocoat SP2000 Series coatings. It has excellent resistance to a wide range of petrochemicals, fuels, organic/inorganic acids and alkalis. The long recoat window allows it to be top-coated up to 21 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 under proper cure conditions</li> <li>• Fully machinable using conventional tools</li> </ul>
<b>Uses</b>	<ul style="list-style-type: none"> <li>• Resurface pitted metal surfaces</li> <li>• Leak repair</li> <li>• Pump rebuilding</li> <li>• High strength structural adhesive for metal bonding</li> </ul>
<b>Color</b>	Light gray
<b>Finish</b>	Matte
<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 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>
<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>Ratio</b>	1:1 by volume
<b>Mixing</b>	Mix equal parts of the resin and hardener thoroughly until color of material is uniform and free of streaks.
<b>Thinning</b>	Do not thin.

<b>Pot Life</b>	30 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 GUIDANCE

<b>Conditions</b>	Substrate surface temperature 50°F – 140°F (10°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 ErgonArmor Technical Service for guidance.
<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)	1 hour	48 hours	7 days
77°F (25°C)	1 hour	24 hours	24 hours
140°F (60°C)	15 minutes	45 minutes	4 hours

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

Tack free at 75°F (21°C) ASTM D1640	1.5 hours for 25 – 30 mil DFT film
Dry hard at 75°F (21°C) ASTM D1640	3 hours for 25 – 30 mil DFT film

## 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.

## PACKAGING, ESTIMATING & HANDLING

ITEM #	PRODUCT	PACKAGING
M-EP3310-2GLKT-01	Novocoat EP3300 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** 25.6 square feet per 2 gallon kit 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 12 months 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 ErgonArmor.

## 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	490°F (255°C)
Splash/spill	293°F (145°C)
Immersion	194°F (90°C)

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

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