



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.

MIXING & THINNING

Mixing	Do not mix partial kits. For small units, empty the entire contents of the resin and hardener onto the mixing board. For large units, completely empty the hardener container into the resin container, scraping it clean. 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

Conditions	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.
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. 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 exposure. 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.

PACKAGING, ESTIMATING & HANDLING

ITEM #	PRODUCT	PACKAGING
M-SC3910-QTCS-01	Novocoat SC3900 Adhesive Paste/Caulk, Light Gray Case includes 1 mixing board. Each kit includes: - Part A Resin, Light Gray - Part B Hardener - Mixing knife, spreader	4 x 2.5 lb (1.1 kg) Kits 2.1 lb (0.95 kg) Can 0.43 lb (0.2 kg) Jar
M-SC3910-1GLKT-01	Novocoat SC3900 Adhesive Paste/Caulk, Light Gray - Part A Resin, Light Gray - Part B Hardener	1 gal (3.8 L) Kit 10.4 lb (4.7 kg) Pail 2.1 lb (0.95 kg) Pail

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 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 ErgonArmor.

TYPICAL PHYSICAL PROPERTIES

PROPERTY	VALUE
Dry adhesion ASTM D4541 Blasted steel 1 coat	>2,850 psi (20 MPa)
Flash point	>250°F (121°C)
Specific gravity, mixed	1.47
VOC	0 lb/gal (0 g/L)
Density	12.2 lbs/gal (1.5 kg/L)

SERVICE TEMPERATURE

SERVICE	TEMPERATURE
Dry	400°F (204°C)
Splash/spill	Up to 360°F (182°C)
Immersion	Up to 300°F (149°C)

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

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