

## Epoxy Novolac

### PRODUCT DESCRIPTION

Enviroline 376F-30LT is a low temperature cure version of Enviroline 376F-30 specifically designed to cure at temperatures down to 20°F (-7°C) and provide resistance to a wide range of chemicals and solvents.

### INTENDED USES

To provide corrosion protection, with cure down to 20°F (-7°C), for the internals of steel storage tanks, vessels, spools and pipes for a range of products, including (but not limited to); crude oil, refined oil products (including unleaded gasoline blends and solvents) and biofuels.

Enviroline 376F-30LT is also suitable as an external coating for buried pipes.

### PRACTICAL INFORMATION FOR ENVIROLINE 376F-30LT

<b>Color</b>	Limited color range available
<b>Gloss Level</b>	Not applicable
<b>Volume Solids</b>	100%
<b>Typical Thickness</b>	20-40 mils (500-1000 microns) dry equivalent to 20-40 mils (500-1000 microns) wet
<b>Theoretical Coverage</b>	53 sq.ft/US gallon at 30 mils d.f.t and stated volume solids 1.33 m <sup>2</sup> /liter at 750 microns d.f.t and stated volume solids
<b>Practical Coverage</b>	Allow appropriate loss factors
<b>Method of Application</b>	Plural Component Airless Spray

### Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
20°F (-7°C)	5 hours	8 hours <sup>1</sup>	8 hours	28 days <sup>2</sup>
32°F (0°C)	2 hours	4 hours <sup>1</sup>	4 hours	28 days <sup>2</sup>
50°F (10°C)	1 hour	2 hours <sup>1</sup>	2 hours	28 days <sup>2</sup>

<sup>1</sup> Sufficient coating film strength has developed to permit the handling and movement of coated steelwork. A Shore D hardness reading of 75-80 is a recommended guideline to indicate suitability for return to service.

<sup>2</sup> If the maximum overcoating interval is exceeded it will be necessary to thoroughly abrade the surface of the lining with coarse emery paper, followed by solvent wash.

### REGULATORY DATA

<b>Flash Point (Typical)</b>	Part A 183°F; Part B 219°F		
<b>Product Weight</b>	12.4 lb/gal (1.49 kg/l)		
<b>VOC</b>	0.25 lb/gal (31 g/l) 88 g/kg	EPA Method 24 EU Solvent Emissions Directive (Council Directive 1999/13/EC)	

See Product Characteristics section for further details

## Protective Coatings

## Epoxy Novolac

### SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. Prior to application, all surfaces should be assessed and treated in accordance with ISO 8504:2000

Where necessary, remove weld spatter and where required smooth weld seams and sharp edges.

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

### Steel Substrates

Best performance will always be achieved when Enviroline 376F-30LT is applied to surfaces prepared by abrasive blast cleaning to Sa3 (ISO 8501-1:2007) or SSPC-SP5. Where Enviroline 376F-30LT is not to be used in high heat and/or aggressive service, preparation to an absolute minimum of Sa2½ (ISO 8501-1:2007) or SSPC-SP10 at time of coating application may be acceptable. Contact International Protective Coatings for further information.

A sharp, angular surface profile of 75-125 microns (3-5 mils) is recommended.

Enviroline 376F-30LT must be applied before oxidation of the steel occurs. If oxidation does occur the entire oxidized area should be reblasted to the standard specified above. Surface defects revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner.

The preferred method of holding the blast standard is by dehumidification. Alternatively, an approved holding primer may be used.

### Concrete Substrates

Refer to International Protective Coatings' Concrete Surface Preparation Guidelines for further information.

### APPLICATION

<b>Mixing</b>	Material is supplied in two containers as a unit. Complete units should be stored, mixed and applied in accordance with the Enviroline Application Guidelines.	
<b>Mix Ratio</b>	2 part(s) : 1 part(s) by volume	
<b>Working Pot Life</b>	95°F (35°C) 10 minutes	
<b>Plural component airless spray</b>	Recommended	Refer to Enviroline Application Guidelines for more details.
<b>Airless Spray</b>	Not suitable	
<b>Brush</b>	Suitable	Can be used for the touch-up of small areas or for stripe coating of welds and edges.
<b>Thinner</b>	Not normally required	Refer to Enviroline Application Guidelines for specific advice.
<b>Cleaner</b>	Enviroline 71C (or International GTA203)	
<b>Work Stoppages</b>	Do not allow material to remain in hoses, guns or spray equipment. Thoroughly flush all equipment with Enviroline 71C or International GTA203. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units.	
<b>Clean Up</b>	Clean all equipment immediately after use with Enviroline 71C or International GTA203. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, temperature and elapsed time, including any delays.	

# Enviroline® 376F-30LT



**Epoxy Novolac**

All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

## Epoxy Novolac

### PRODUCT CHARACTERISTICS

The detailed Enviroline Application Guidelines should be consulted prior to use.

This datasheet provides general guidance on the use of Enviroline 376F-30LT. Specific project requirements will be dependent upon the service end use and operating conditions of the tank or vessel. Always consult International Protective Coatings to confirm that Enviroline 376F-30LT is suitable for contact with the product to be stored.

The detailed project coating specification provided by International Protective Coatings must be followed at all times.

Stripe coating is an essential part of good working practice and as such should form part of any lining specification.

For heavily pitted or porous steel, spray apply approximately 50% of the required film thickness and follow immediately with a short nap roller or squeegee to work material into the bottom of pitted areas.

For plural component application, viscosity of the Part A and Part B varies. For best results, heat Part A side to maximum of 130°F (54°C) and heat Part B side to a maximum of 105°F (41°C).

Use the following chart for preferred temperature conditions. These conditions plus adequate ventilation must be maintained throughout the curing cycle.

	<u>Substrate Temperature</u>	<u>Air Temperature</u>
<b>Preferred</b>	30-65°F (-1 to 18°C)	30-65°F (-1 to 18°C)
<b>Minimum</b>	20°F (-7°C)	20°F (-7°C)

For low temperature applications, typical full cure times are;

20°F (-7°C)	7 days
32°F (0°C)	3 days
50°F (10°C)	1 day

After the coating system has cured hard, the dry film thickness should be measured using a suitable non-destructive magnetic gauge to verify the minimum applied system thickness. The coating system should be free of all pinholes or other holidays. The cured film should be essentially free of runs, sags, drips, inclusions or other defects. All deficiencies and defects should be corrected. The repaired areas shall be retested and allowed to cure as specified before placing the finished lining into service.

Maximum continuous dry temperature resistance for Enviroline 376F-30LT is 350°F (177°C).

Note: VOC values are typical and are provided for guidance purpose only. These may be subject to variation depending on factors such as differences in color and normal manufacturing tolerances.

### SYSTEMS COMPATIBILITY

Enviroline 376F-30LT is designed as a single coat system. It must only be overcoated with itself should re-coats or touch-up be required.