

## Epoxy Novolac

### PRODUCT DESCRIPTION

Enviroline 399PTFE is a high solids, thick-film single coat advanced hybrid epoxy system that reduces the coefficient of friction to allow smoother, easier loading of slurry and dry products.

### INTENDED USES

Designed as a high abrasion resistant coating for hopper cars, potash mines, exterior pipelines and slurry tanks.

Enviroline 399PTFE offers the following features;

- Superior abrasion resistance
- Thick-film, single coat application
- Fast return to service - 18-24 hours
- Excellent corrosion resistance
- Reduces coefficient of friction
- Reduces heels left in tanks & hoppers
- High temperature resistance to 300°F (149°C)
- Teflon distributed throughout the film thickness

### PRACTICAL INFORMATION FOR ENVIROLINE 399PTFE

<b>Color</b>	Limited color range available
<b>Gloss Level</b>	Not applicable
<b>Volume Solids</b>	96%
<b>Typical Thickness</b>	40-80 mils (1000-2000 microns) dry equivalent to 41.7-83.3 mils (1042-2083 microns) wet
<b>Theoretical Coverage</b>	19 sq.ft/US gallon at 80 mils d.f.t and stated volume solids 0.50 m <sup>2</sup> /liter at 2000 microns d.f.t and stated volume solids
<b>Practical Coverage</b>	Allow appropriate loss factors
<b>Method of Application</b>	Airless Spray, Plural Component Airless Spray

### Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
77°F (25°C)	3 hours	6 hours <sup>1</sup>	3 hours	6 hours <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

**REGULATORY DATA** **Flash Point (Typical)** Mixed 151°F (66°C)

**Product Weight** 12.9 lb/gal (1.54 kg/l)

**VOC** 49 g/lit (0.41 lb/gal) Calculated

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 paint 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 399PTFE is applied to surfaces prepared by abrasive blast cleaning to Sa3 (ISO 8501-1:2007) or SSPC-SP5. Where Enviroline 399PTFE 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 399PTFE 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) 17 minutes	
<b>Plural component airless spray</b>	Recommended	Refer to Enviroline Application Guidelines for more details.
<b>Airless Spray</b>	Recommended	Tip Range 27-31 thou (0.68-0.78 mm) Refer to Enviroline Application Guidelines for more details.
<b>Brush</b>	Suitable	Only for small areas or touch ups
<b>Thinner</b>	Not normally required	If necessary, use Enviroline 76T. Refer to Enviroline Application Guidelines for more details.
<b>Cleaner</b>	Enviroline 71C	
<b>Work Stoppages</b>	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with Enviroline 71C. 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. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency should depend upon amount sprayed, temperature and elapsed time, including any delays.  All surplus material and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.	

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### PRODUCT CHARACTERISTICS

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

This datasheet provides general guidance on the use of Enviroline 399PTFE. Specific project requirements will be dependent upon the service end use and operating conditions of the tank or vessel.

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

**Caution:** Enviroline 399PTFE contains fillers that can be very abrasive to pumps and spray equipment. International Protective Coatings is not responsible for damage caused to application equipment.

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.

Surface temperature must always be a minimum of 5°F (3°C) above dew point.

For airless spray application, best results will be achieved when each component of the product is heated prior to application to 95-100°F (35-37°C). For plural component airless spray application, best results will be achieved when the product is heated prior to application; Part A (Resin) to a maximum of 140°F (60°C) and Part B (Hardener) to a maximum of 105°F (40°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>	70-120°F (21-49°C)	70-100°F (21-38°C)
<b>Minimum</b>	55°F (13°C)	55°F (13°C)

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 399PTFE is 300°F (149°C).

Post-curing is not necessary for most applications, but Enviroline 399PTFE may be post-cured to expedite curing or increase chemical resistance for extremely aggressive environments. Post-cure for a minimum of 2 hours at 250°F (121°C) or 6-8 hours at 150°F (66°C) for maximum resistance.

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 399PTFE should always be applied to correctly prepared substrates. When a primer is required as part of the coating specification, consult International Protective Coatings for specific advice.

Enviroline 399PTFE is designed as a single coat system. It must only be overcoated with itself should re-coats or touch-up be required.

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### ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at [www.international-pc.com](http://www.international-pc.com):

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage
- Enviroline Application Guidelines

Individual copies of these information sections are available upon request.

### SAFETY PRECAUTIONS

This product is intended for use only by professional applicators in industrial situations in accordance with the advice given on this sheet, the Material Safety Data Sheet and the container(s), and should not be used without reference to the Material Safety Data Sheet (MSDS) which International Protective Coatings has provided to its customers.

All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety & Environmental standards and regulations.

In the event welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

If in doubt regarding the suitability of use of this product, consult International Protective Coatings for further advice.

**Warning: This product contains liquid epoxies and modified polyamines and may cause skin sensitization if not used correctly.**

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	4 US gal	2.67 US gal	5 US gal	1.33 US gal	2 US gal
For availability of other pack sizes contact International Protective Coatings					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	4 US gal	35.5 lb		20 lb	
STORAGE	Shelf Life	24 months minimum at 77°F (25°C). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.			

### Disclaimer

*The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local representative that this data sheet is current prior to using the product.*

*This Technical Data Sheet is available on our website at [www.international-marine.com](http://www.international-marine.com) or [www.international-pc.com](http://www.international-pc.com), and should be the same as this document. Should there be any discrepancies between this document and the version of the Technical Data Sheet that appears on the website, then the version on the website will take precedence.*

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