

Novocoat EP3300 Paste/Caulk

SELECTION & SPECIFICATION DATA

Type	Epoxy Paste/Caulk
Description	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.
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 under proper cure conditions • Fully machinable using conventional tools
Uses	<ul style="list-style-type: none"> • Resurface pitted metal surfaces • Leak repair • Pump rebuilding • High strength structural adhesive for metal bonding
Color	Light 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-SP2 Hand Tool or SSPC-SP3 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.
Temperature	Surface should be at least 50°F (10°C) and relative humidity not to exceed 90%. Maximum substrate temperature should not exceed 140°F (60°C). Contact ErgonArmor if the substrate temperature exceeds 140°F (60°C).

MIXING & THINNING

Ratio	1:1 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	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.
Cleanup	MEK or Acetone

APPLICATION GUIDANCE

Application	Apply directly onto the prepared surface with the plastic applicator or spatula 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

Tack free: 1.5 hours
 Dry hard: 3 hours
 25 – 30 mil DFT film, 77°F (25°C), per ASTM D1640

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 cargo. Consult with ErgonArmor Technical Service for guidance.

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.

ESTIMATING & PACKAGING

Theoretical Coverage	25.6 square feet per 2 gallon kit at 125 mils. Allow for loss in mixing and application.
Package Sizes	Light Gray, 24 lbs (10.88 kg) Kit - Part A Resin White, 12.4 lbs (5.62 kg) Pail - Part B Hardener Black, 11.6 lbs (5.26 kg) Pail Item #: M-EP3310-2GLKT-01

TYPICAL PHYSICAL PROPERTIES

TEST METHOD	RESULTS
Pull-off adhesion, dry ASTM D4541 Blasted steel 1 coat	>2,850 psi
Flash point	Greater than 250°F (121°C)
Specific gravity	Part A: 0.53 Part B: 1.40
VOC	0 grams/liter
Density	Part A: 12.7 lbs/gal Part B: 11.6 lbs/gal Mixed: 12.15 lbs/gal

SERVICE TEMPERATURE

SERVICE	MAXIMUM TEMPERATURE
Dry	490°F (255°C)
Splash/spill	293°F (145°C)
Immersion*	194°F (90°C)

*Immersion with solvents, mineral acids, or alkalis, or if over 150°F (66°C), consult ErgonArmor Technical Service.

STORAGE & SHELF LIFE

Shelf Life 12 months at 75°F (24°C) when stored under recommended conditions.

Storage Conditions 40°F – 110°F (4°C – 43°C)
0 – 100% relative humidity

Store in a dry area out of direct sunlight. Maintain product in original packaging and sealed until ready for use.

Rev 06/2020

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