

SELECTION & SPECIFICATION DATA

Generic Type	Epoxy Paste/Caulk
Description	SC3910 is a two-component 100% solids trowel-grade epoxy novolac caulk for use as a chine repair or lap weld feathering product for steel tanks. It is often used in conjunction with chemical resistant topcoats such as SC3300 or SC5400. Excellent chemical resistance to a wide range of petrochemical products, fuels, organic/inorganic acids & alkalis. Long re-coat window allows it to be top-coated up to 14 Days, depending on temperatures.
Features	<ul style="list-style-type: none"> • 100% solids, No VOC's • Application and cure at room temperature • Multi-purpose durable repair composite • No shrinkage, expansion or distortion • Quick return-to-service • Fully machinable using conventional tools
Recommended Uses	<ul style="list-style-type: none"> • Anchor Adhesive • Resurface of pitted metal surfaces • Leak repair • Plate bonding • Pump casing • High strength structural adhesive for metal bonding
Color	Gray (SC3910-1GLKT)
Finish	Matte
Primer	Self-priming
Solids Content	By Volume 100%
Theoretical Coverage Rate	12.8 sq ft at 125 mils 2 sq ft at 800 mils Allow for loss in mixing and application.
Dry Time	Dry Times (ASTM D1640), 25 – 30 mils DFT Tack Free Time: 3.5 hours at 25°C (77°F) Dry Hard Time: 8 hours at 25°C (77°F)

SUBSTRATES & SURFACE PREPARATION

General	Surfaces must be clean and dry. Remove all dirt, dust, oil and all other contaminant.
Steel	Immersion: SSPC-SP10 Near White with jagged profile of 2.5 – 3.5 mils. Non-immersion: SSPC-SP6 1.5 – 3.0 mils SSPC-SP2 or SP3 are suitable cleaning methods for mild environments.

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. De-grease using clean rags.
Substrate Temperature	Surface should be at least 10°C (50°F) and relative humidity not to exceed 90%. Maximum substrate temperature should be kept to 140°F (60°C). Contact ErgonArmor for conditions where the substrate temperature exceeds 140°F (60°C).

MIXING & THINNING

Mixing	DO NOT MIX PARTIAL KITS. Transfer the entire contents of the Resin and Hardener on to the plastic mix board. Mix thoroughly together until color of material is uniform and free of any streaks.
Thinning	No Thinning Use of thinners other than those supplied or recommended by ErgonArmor may adversely affect product performance and void product warranty, whether expressed or implied.
Ratio	3A:1B by volume
Pot Life (25°C) (77°F)	45 minutes in 8 fl oz mass

APPLICATION EQUIPMENT GUIDELINES

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.

Application (General)	This is a 100% solids coating and may require adjustments in application techniques. Apply directly on to 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 tape over holes and cracks. Fully machinable using conventional tools once cured.
Brush & Roller (General)	Brush or roller can be used to smooth uncured surface with solvent if desired.

CLEANUP & SAFETY

Cleanup	Use MEK or Acetone. In case of spillage, absorb and dispose of in accordance with local applicable regulations.
Safety	Read and follow all caution statements on this product data sheet and on the SDS for this product. Wear protective clothing, and gloves.
Ventilation	When used in enclosed areas, thorough air circulation is recommended during and after application until the coating is cured.

PACKAGING, HANDLING & STORAGE

Shelf Life	Part A: 12 months at 75°F (24°C) Part B: 12 months at 75°F (24°C)
Shipping Weight (Approximate)	1 Gallon Kit 12 lbs (5.45 KG)
Storage Temperature & Humidity	40° – 110°F (4° – 43°C) 0 – 100% Relative Humidity
Storage	Store in a dry, well-ventilated area. Maintain products in original packaging and sealed until ready for use. Avoid exposure to direct sunlight or any adverse environmental conditions that would cause contamination. Refer to Safety Data Sheet for additional information.

PERFORMANCE DATA

ASTM D-4541 Dry	Blasted Steel 1 ct.	>2,850 psi
Flash Point	Greater than 250°F (121°C)	
Specific Gravity, mixed		1.47
VOC lbs/gallon	0 grams/liter	
Weight per gallon, mixed		12.19 lbs
Dry Service	400°F (204°C)	
Splash/Spill	360°F (182°C)	
Immersion Service*	300°F (149°C)	

*Immersion with solvents, mineral acids, or alkalines, or if over 150°F, contact factory.

CURE SCHEDULE & RE-COAT WINDOW

TEMPERATURE	MINIMUM RE-COAT	MAXIMUM RE-COAT	RETURN TO SERVICE (AQUEOUS/ HYDROCARBON IMMERSION)
10°C (50°F)	12 hour	14 days	7 days
25°C (77°F)	3 hours	14 days	24 hours
60°C (140°F)	1 hour	7 Days	4 hours

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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 material safety data sheets before using. While all statements, technical information, and recommendations contained herein are based on information our company believes to be reliable, nothing contained herein shall constitute any warranty, express or implied, with respect to the products and/or services described herein and any such warranties are expressly disclaimed. We recommend that the prospective purchaser or user independently determine the suitability of our product(s) for their intended use. No statement, information or recommendation with respect to our products, whether contained herein or otherwise communicated, shall be legally binding upon us unless expressly set forth in a written agreement between us and the purchaser/user. Please contact ErgonArmor for further information at 877.982.7667 or FAX 601-933-3381. For all Terms and Conditions of Sale see ergonarmor.com.

ORDERING INFORMATION

For additional information, prices, or to place an order, please contact your ErgonArmor sales representative. If you do not know the name of your sales representative, call 877-98ARMOR.