TNEMEC

PRODUCT DATA SHEET

BRIDGEPORT GLASS ARMOR 300 SERIES 330

PRODUCT PROFILE

GENERIC DESCRIPTION Modified Amine Epoxy

COMMON USAGE A thick-film reinforced modified epoxy internal lining formulated for corrosion control and restoration of petroleum storage tanks. Spray applied at 20 to 40 mils depending on extent of bottom plate corrosion, and is flexibilized to reduce coating stress resulting from mechanical and physical forces exerted on the tank bottom. Lining may also be used for chemical storage tanks. Refer to the Glass Armor Chemical Resistance Chart. **Manufactured and distributed under license from Bridgeport Chemical.**

COLORS 1232 GA Blue. **Note:** Epoxies chalk and yellow with age, extended exposure to UV and artificial lighting.

FINISH Semi-gloss

PERFORMANCE CRITERIA Contact your Tnemec representative for specific test results.

COATING SYSTEM

PRIMERS Self-priming

SURFACER/FILLER/PATCHER Series 351 Glass Armor 510

SURFACE PREPARATION

STEEL SSPC-SP5/NACE 1/ISO SA 3.0 White Metal Blast Cleaning with a minimum angular anchor profile of 3.0 mils. Refer to the Series 330 Glass Armor Surface Preparation and Application Guide.

ALL SURFACES Must be clean, dry and free of oil, grease and other contaminants.

TECHNICAL DATA

VOLUME SOLIDS 100%

RECOMMENDED DFT 20.0 to 40.0 mils (508 to 1,016 microns) one coat with multiple passes.

CURING TIME

Temperature	To Touch	To Handle	Immersion
75°F (24°C)	6 hours	8 hours	24 to 36 hours

These times are based on a 20.0 mil (500 micron) dry film thickness. Higher film thicknesses, insufficient ventilation or cooler temperatures will require longer cure times. This coating commonly develops an amine-blush during cure. While this condition will not adversely affect performance of the coating, this blush must be removed by aggressive sweep blasting before applying additional coats. During high humidity conditions, it is recommended that the application be done while the temperatures are increasing. Cure time to achieve a minimum Shore D Hardness of 77 or Barcol GYZJ 935 hardness of 55 for immersion service is 24 to 36 hours. In order to obtain an accurate reading, the minimum DFT must be 30 mils.

VOLATILE ORGANIC COMPOUNDS 0.22 lbs/gallon (26 grams/litre)

HAPS .02 lbs/gal solids

THEORETICAL COVERAGE 1,604 mil sq ft/gal (39.4 m²/L at 25 microns). See APPLICATION for coverage rates.

NUMBER OF COMPONENTS Two: Two Part A (epoxy) to One: Part B (amine)

PACKAGING KITS CONSIST OF:

	PART A (Partially filled)	PART B (Partially filled)	Yield (mixed)
Large Kit	2-55 gallon drums	1-55 gallon drum	150 gallons (567.8 L)
Medium Kit	2-6 gallon pails	1-6 gallon pail	15 gallons (56.7 L)
Small Kit	1-5 gallon pail	1-3 gallon pail	4 gallons (15.1 L)

NET WEIGHT PER GALLON 12.11 ± 0.25 lbs (5.49 ± .11 kg) (mixed)

STORAGE TEMPERATURE Minimum 50°F (10°C) Maximum 100°F (38°C)

TEMPERATURE RESISTANCE (Dry) Continuous 275°F (135°C) Intermittent 300°F (149°C)

SHELF LIFE 24 months at recommended storage temperature.

FLASH POINT - SETA Part A: >200°F (95°C) Part B: >200°F (95°C)

HEALTH & SAFETY Paint products contain chemical ingredients which are considered hazardous. Read container label warning and Material Safety Data Sheet for important health and safety information prior to the use of this product.
Keep out of the reach of children.

BRIDGEPORT GLASS ARMOR 300 | SERIES 330

APPLICATION

COVERAGE RATES

Before commencing, obtain and thoroughly read the Series 330 Glass Armor Surface Preparation and Application Guide.

	Dry Mils (Microns)	Wet Mils (Microns)	Sq Ft/Gal (m²/Gal)
Suggested	30.0 (762)	30.0 (762)	53 (5.0)
Minimum	20.0 (508)	20.0 (508)	80 (7.5)
Maximum	40.0 (1016)	40.0 (1016)	40 (3.7)

Allow for overspray and surface irregularities. Application of coating below minimum or above maximum recommended dry film thicknesses may adversely affect coating performance.

MIXING

Power mix contents of each container, making sure no pigment remains on the bottom.
Pre-Heating: Heat each component to 110°-120°F (43°-49°C) prior to spraying. Refer to the Series 330 Glass Armor Surface Preparation and Application Guide for details on the heating and mixing of the material.

THINNING

Do Not Thin. Thinning will adversely affect performance properties.

PURGE TIME

Less than 60 seconds.

APPLICATION EQUIPMENT

PLURAL COMPONENT AIRLESS EQUIPMENT ONLY.

Plural Component Proportioning Pump	Primary Heat Part A	Primary Heat Part B	Hose Heat	Material Temp at Gun	Integration Line
Graco 68:1 or larger Xtreme Mix	110°F-120°F (43°C-49°C)	110°F-120°F (43°C-49°C)	140°F-160°F (60°C-71°C)	100°F-110°F (38°C-43°C)	50' 3/8" ID

Static Mixers	Whip Line	Gun	Tips	Dynamic Pressure
2-12" L x 3/8" ID 12 Fold Stainless 1-9" L x 1/4" ID 12 Fold Stainless	2-6' or 10' 1/4" ID	Graco XTR-7 or WIWA 500F	Graco HD RAC 0.025"-0.029" without diffuser bar	3400-3800 psi (234-262 bar)

Note: Products under continual testing and equipment recommendation may change. Contact Tnemec Technical Services Dept. for the most current Bridgeport Glass Armor plural component equipment recommendation guide.
Brush: Recommended for small areas, repairs and weld seams.
Note: Refer to the Series 330 Glass Armor Surface Preparation and Application Guide for specific instructions.

SURFACE TEMPERATURE

Minimum 50°F (10°C) Maximum 120°F (49°C)
The surface should be dry and at least 5°F (3°C) above the dew point. Do not apply when humidity exceeds 80%. For tanks, dehumidification equipment is recommended if humidity exceeds 80%.

CLEANUP

Clean up and purge lines immediately after use with No. 4 Thinner.