

Revised on April 2012

EP 3920 MACHINABLE GRADE

PRODUCT PROFILE:

Novocoat Protective Coatings consistently produces products of exceptional chemistry delivering the best in corrosion protection, while being safe for our environment and totally user friendly.

EP3920 is a synthetic rebuild material for metal parts and surfaces, and is machinable. It has a smooth spreadable consistency which makes it easy to apply. EP3920 is most often used in steel tank repair but is also well suited to rebuilding tube sheets, shafts, bearing housings, etc.

PRODUCT FEATURES and BENEFITS:

- 100% Solids, No VOCs
- Excellent UV stability
- Excellent impact resistance and corrosion protection

CHEMICAL RESISTANCE

- | | | |
|---------------------------------|---------------------------|---------------------------|
| • Acetic Acid up to 10% | • Mineral Acids | |
| • Ammonium Hydroxide* | • Nitric Acid up to 45% | |
| • Aromatic & Aliphatic Solvents | • Mild Organic Acids | • 1,1,1-Trichloromethane |
| • Black Liquor | • Most Phosphates | • Urea Solutions |
| • Butyl Acetate | • Phosphoric Acid | • White Liquor |
| • Butyl Carbitol | • Potassium Hydroxide* | *Ambient temperature only |
| • Most Chlorides | • Sodium Hydroxide* | |
| • Hydrogen Sulfide | • Most Sulfides | |
| • Isopropyl Alcohol | • Sulfuric Acid up to 80% | |

PHYSICAL PROPERTIES

Color	Dark Gray
Coverage per gallon (Theoretical)	12.8 sq. ft. @ 1/8" thickness
Mix Ratio by Volume/Weight	3:1/5:1 (Resin:Hardener)
Flash Point	greater than 250°F (121°C)
Pull-Off Adhesion Test ASTM D 4541	Minimum adhesion is 2850psi
Coefficient of Thermal Expansion (10-6/per °F)	1.1

Thermal Stability (weight loss after 48 hours @ 300°F)	0.0003 grams
Specific Gravity	Resin: 2.12; Hardener: 1.59
Volatile Organic Compounds (VOC)	0 grams/liter
Weight per gallon	13.37 lbs
Pot Life @ 40°F (4°C)	1 hour 20 minutes
75°F (24°C)	50 minutes
92°F (33°C)	30 minutes
Cure Time @ 70°F (21°C): Re-coat Window	1/2 to 2 hours
Light Loading	12 hours
Immersion (Aqueous) Service	48 hours
Full or Chemical Service	5 days

Note: Do not keep the blended coating in the original container unless immediate use is planned. Otherwise, exothermic heat created during the curing process, will considerably shorten the pot life. Pour the coating into a rolling tray or large aluminum-basting pan. Try to keep the depth of the coating in the tray below 3/8".

SERVICE TEMPERATURE

Dry Service	490°F (255°C)
Spill/Splash	293°F (145°C)
Immersion Service*	194°F (90°C)

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

TOP-COATING & JOINING ADJACENT SECTIONS:

If the compound is to be coated, apply the coating within the re-coat window (see table below). If this is not possible, allow the compound to cure, then brush-blast, wire-brush or sand to create a mechanical profile on the surface before coating.

When it is necessary to join multiple sections of the compound to create a continuous protective layer over a large area, do not attempt to feather and overlap adjoining sections. If adjoining sections cannot be applied within the re-coat window (see table below), continue the full thickness of the compound up to the joint between sections. Allow the first section to cure, then create a mechanical profile, using one of the means listed above, on the edge that will be joined to the next section to ensure a satisfactory bond.

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.

