

BIO-CHEM™ 330

HIGH PERFORMANCE,
100% SOLIDS EPOXY
COATING FOR
AGGRESSIVE CHEMICAL
EXPOSURES



PRODUCT DATA SHEET

BIO-CHEM™ 330 is a Novolac® resin based coating designed for applications where resistance to aggressive chemical exposure is of paramount importance. The sophisticated resin formula has excellent resistance to acids, acid fumes and a wide variety of solvents.

BIO-CHEM™ 330 cures to a very tough, abrasion and impact resistant film. Use as a hopper car lining exposed to impact, abrasion and chemical fumes is particularly recommended.

The high heat resistance of BIO-CHEM™ 330 makes it very attractive for down-hole applications exposed to high ambient temperatures and hydrocarbons.

Application is by heated plural 1/1 airless spray with easy touch up by brush or roller.

RECOMMENDED USES

DOWN-HOLE TUBULAR COATING: ID and OD coating, especially suitable for “Ruffcoat” OD treatment.

TANK LINING: High hydrocarbon chemical resistance and early return to service make **BIO-CHEM™ 330** an ideal high build tank lining.

HOPPER CAR LINING: Excellent physical and chemical resistance properties.

CONCRETE CONTAINMENT: Excellent adhesion to concrete and chemical resistance

TECHNICAL INFORMATION

VEHICLE TYPE	Epoxy/Aliphatic amines
PIGMENTATION	Color/Inert
COLORS	Standard Off-White – others available
FINISH	Smooth, satin gloss
THINNER	Not normally required
CLEANER	MEK or lacquer thinner
MIXING RATIO	1.0/1.0 v/v
INDUCTION TIME	Not required
POT LIFE	Approx. 40' / 77°F
FLASH POINT	Over 200°F
SOLIDS BY VOLUME	100%
SPREADING RATE/GAL.....	53 sq. ft./gal @ 30 mils
DRY TIME, (to touch)	8 hours at 77°F
DRY TIME, (recoat).....	12 hrs. min – 5 days max @ 77°F, (25°C)
APPLICATION METHOD.....	Brush, roller, plural heated airless spray, (pref.)
STORAGE CONDITIONS.....	Normal
HARDNESS, (Shore “D”).....	80

APPLICATION NOTES

SURFACE PREPARATION: Surface must be free of oil, grease, dirt etc. For steel in atmospheric service an SSPC-SP-6 Commercial blast is the minimum acceptable standard of surface preparation.

For steel in immersion service an SSPC-SP-5 “white metal” blast standard is required. An angular surface profile of 2 – 3 mils, (50 – 75 microns), is recommended. Substrate temperature should be 40°F or above with RH below 85%.

Concrete is best prepared by brush blasting at a reduced pressure in order to yield a “medium sandpaper” texture free of gross surface deposits or contamination.

MIXING PROCEDURE: BIO-CHEM™ 330 is supplied in 10 gallon kits of two 5-gallon containers of epoxy base and curing agent respectively. When applied premixed the components must be intimately mixed before application taking special care to incorporate components from the walls and base of the mixing vessels, *Note: unmixed components will never cure.*

APPLICATION BY HEATED PLURAL AIRLESS SPRAY:

Pump:	45:1 King (Graco) or similar with the ability to maintain 3,000 psi during application
High Pressure Filter:	60 mesh
Fluid Hose:	3/8”, 100’ max
Fluid temp:	140°F, (60°C) recommended
Spray Tips:	0.019” – 0.027”
Substrate temp:	40°F, (4.5°C), minimum

CURING BEFORE SERVICE: Allow 72 hours curing at 77°F before immersion service in hydrocarbon service – check with TFT before scheduling return to service.

CHEMICAL RESISTANCE CHART: (AC is Atlas Cell, BJ is Bell Jar, tests at 77°F unless otherwise noted)

CHEMICAL	TEST	TIME	RESULT	CHEMICAL	TEST	TIME	RESULT
Sweet Crude	AC @ 100°F	8 Mo.	Pass	Acetone	BJ	3 Mo.	Pass
Sour Crude	AC @ 100°F	8 Mo.	Pass	Hexane	BJ	3 Mo.	Pass
Diesel Fuel	AC @ 100°F	8 Mo.	Pass	MAK	BJ	3 Mo.	Pass
Gas (unleaded)	AC	6 MO.	Pass	MEK	BJ	3 Mo.	Pass
Ethanol	35°F & 100°F	6 Mo.	Pass	MIBK	BJ	3 Mo.	Pass
Gasohol	AC	6 Mo.	Pass	Toluene	AC	3 Mo.	Pass
Jet Fuel	AC	4 Mo.	Pass	Xylene	AC	3 Mo.	Pass
Kerosene	AC	8 Mo.	Pass	Tetrahydrofuran	BJ	2 Mo.	Fail

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