

SELECTION & SPECIFICATION DATA

Type	Cycloaliphatic Amine-Cured Novolac Epoxy
Description	Novocoat SC5400 Lining is a high functionality, densely cross-linked, rapid cure, 100% solids novolac epoxy coating, developed as a high-performance solution for severe service.
Features	<ul style="list-style-type: none"> Resistant to wide range of acids and caustics Very low permeation & low moisture rate for demanding tank lining service Excellent performance in abrasive slurries, hot brine, hot vapors & gas streams Solvent Free - 100% solids Quick return-to-service - 24 hours at 77°F (25°C) for hydrocarbon immersion service Outstanding durability in severe chemical, abrasive & temperature service
Uses	<ul style="list-style-type: none"> Internal lining for tanks, vessels, piping and process equipment handling abrasive slurries, aggressive chemicals and hot fluids Coating for primary and secondary containment structures including trenches and sumps in aggressive environments Heat exchangers and tube sheets Clarifiers, thickeners, flotation cells for minerals processing Separators and deaerators
Color	Light gray, dark gray
Finish	Gloss
Dry Film Thickness (DFT)	2 - 3 coats at 10 - 12 mils each 3 - 4 coats at 10 - 12 mils each for high temperature or severe chemical service
Solids Content	99 - 100% by volume

SUBSTRATES & SURFACE PREPARATION

All	Substrate must be clean, dry and free of contaminants.
Steel	<p>Immersion: SSPC-SP5/NACE 1 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-SP 2 Hand Tool or SSPC-SP 3 Power Tool Cleaning are suitable for mild environments.</p> <p>Self-priming on steel.</p>
Concrete or Concrete Masonry Units (CMU)	Concrete must be cured 28 days at 75°F (24°C) and 50% relative humidity or equivalent. Prepare surfaces in accordance with SSPC-SP 13/NACE 6. Required surface profile is CSP 3-5. Voids in concrete surfaces may require filling. Mortar joints should be cured a minimum of 15 days. Prime with Novocoat SC1100 Primer/Sealer.
Previously Painted Surfaces	Consult with Armor Technical Service.

MIXING & THINNING

Ratio	3.3A:1B by volume, 5A:1B by weight
Mixing	Power mix Part A and Part B separately. For brush, roller or single leg spray application, combine Part A with Part B and power mix.
Thinning	<p>Spray: Up to 6.5 oz/gal (5%) with Novocoat TH1710 Thinner</p> <p>Brush: Up to 12.8 oz/gal (10%) with Novocoat TH1710 Thinner</p> <p>Roller: Up to 12.8 oz/gal (10%) with Novocoat TH1710 Thinner</p>
Pot Life	<p>30 minutes at 75°F (24°C)</p> <p>Pot life is shorter at higher temperatures. A larger volume of mixed material will have a shorter pot life than a smaller volume.</p>
Cleanup	MEK or Acetone

APPLICATION GUIDELINES

Spray Application	The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.
Airless Spray Plural Component	<p>Tip Size: 0.027 to 0.029-inch, reversible type</p> <p>Part A Fluid Line: 1/2-inch ID</p> <p>Part B Fluid Line: 3/8-inch ID</p> <p>Spray Line: 1/2-inch ID x 50 feet maximum</p> <p>Whip: 1/4-inch to 3/8-inch ID</p> <p>Whip Length: 20 feet maximum</p> <p>Output Pressure: 3,300 – 5,600 psi</p> <p>Pump Size: 56:1 or greater</p> <p>Static Mixer: 2 x 1/2-inch ID x 12 inches (24-inch total length) behind mixing valve</p> <p>Part A Temperature: 130°F - 135°F (54°C - 57°C)</p> <p>Part B Temperature: 90°F - 95°F (32°C - 35°C)</p>
Airless Spray Single Leg or Hot Pot	<p>Pump Size: 56:1 (minimum)</p> <p>Output: 5600 - 7000 psi with filter removed</p> <p>Hose: 50 feet x 3/8-inch ID (minimum)</p> <p>Whip: 10 feet maximum x 1/4-inch to 3/8-inch ID</p> <p>Tip Size: 0.027 inch to 0.029 inch</p>

Brush & Roller	Multiple coats may be required to obtain desired appearance, recommended dry film thickness and adequate hiding. Avoid excessive re-brushing or re-rolling. For best results, tie in within 10 minutes at 75°F (24°C).
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Brush	Medium bristle brush
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Roller	Short-nap synthetic roller cover with phenolic core
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CURE SCHEDULE & RECOAT WINDOW

SUBSTRATE TEMPERATURE	MINIMUM RECOAT	MAXIMUM RECOAT	RETURN TO SERVICE (IMMERSION)
50°F (10°C)	8 hours	24 hours	14 days
77°F (25°C)	3 hours	12 hours	7 days
140°F (60°C)	30 minutes	1 hour	4 hours

Return-to-service will vary with chemical exposure. Consult with Armor Technical Service for guidance.

PACKAGING, ESTIMATING & HANDLING

ITEM#	PRODUCT	PACKAGING
M-SC5410-QTCS-01	Novocoat SC5400 Lining, Light Gray Case includes tools Each kit includes: - Part A Resin, Light Gray - Part B Resin - Chip brush and mixing knife	4 x 2.3 lbs (1 kg) Kit 1.9 lbs (0.86 kg) Pail 6.1 oz (173 g) Jar
M-SC5410-1GLKT-01	Novocoat SC5400 Lining, Light Gray - Part A Resin, Light Gray - Part B Hardener	1 gal (3.8 L) 9.5 lbs (4.3 kg) Pail 1.9 lbs (0.86 kg) Pail
M-SC5410-4GLKT-01	Novocoat SC5400 Lining, Light Gray - Part A Resin, Light Gray - Part B Hardener	38 lbs (17 kg) Pail 7.6 lbs (3.4 kg) Pail
M-SC5420-QTCS-01	M-SC5420-QTCS-01 Novocoat SC5400 Lining, Dark Gray Case includes tools Each kit includes: - Part A Resin, Dark Gray - Part B Resin - Chip brush and mixing knife	4 x 2.3 lbs (1 kg) Kit 1.9 lbs (0.86 kg) Pail 6.1 oz (173 g) Jar
M-SC5420-1GLKT-01	Novocoat SC5400 Lining, Dark Gray - Part A Resin, Dark Gray - Part B Hardener	1 gal (3.8 L) 9.5 lbs (4.3 kg) Pail 1.9 lbs (0.86 kg) Pail
M-SC5420-4GLKT-01	Novocoat SC5400 Lining, Dark Gray - Part A Resin, Dark Gray - Part B Hardener	38 lbs (17 kg) Pail 7.6 lbs (3.4 kg) Pail
M-SC5440-1GLKT-01	Novocoat SC5400 Lining, Red - Part A Resin, Red - Part B Hardener	1 gal (3.8 L) 9.5 lbs (4.3 kg) Pail 1.9 lbs (0.86 kg) Pail
M-SC5440-4GLKT-01	Novocoat SC5400 Lining, Red - Part A Resin, Red - Part B Hardener	38 lbs (17 kg) Pail 7.6 lbs (3.4 kg) Pail
M-SC5410-200GLKT-1	Novocoat SC5400 Lining, Light Gray - Part A Resin, Light Gray - Part B Hardener	640 lbs (290 kg) Drum 410 lbs (186 kg) Drum

Theoretical Coverage

160 square feet per gallon at 10 mils DFT
133 square feet per gallon at 12 mils DFT
Allow for loss in mixing and application.

Storage & Shelf Life

Maintain product in original packaging and sealed until ready for use. Estimated shelf life is 12 months when stored in a dry area at 75°F (24°C). Actual shelf life may vary with storage conditions. Do not store below 40°F (4°C) or above 110°F (43°C).

If there is any question with respect to the quality of the components, check reactivity prior to use. Consult Armor Technical Service for assistance.

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.

TYPICAL PHYSICAL PROPERTIES

PROPERTY	SYSTEM	VALUE
Dry adhesion ASTM D4541	Blasted steel 1 coat	>2,500 psi (17 MPa)
Wet adhesion ASTM D4541 5 days 158°F (70°C) water	Blasted steel 1 coat	>2,500 psi (17 MPa)
Abrasion resistance ASTM D4060	Blasted steel 1 coat	17 mg loss per 1000 cycles, CS17 wheel 1000 g load 0.1 mil loss per 1000 cycles
Compressive strength ASTM C109		10,000 - 13,000 psi (69 - 90 MPa)
Hardness ASTM D2240	Blasted steel 1 coat	84 Shore D

SERVICE TEMPERATURE

SERVICE	TEMPERATURE
Dry, continuous	450°F (232°C)
Dry, intermittent	500°F (260°C)

Temperature limitations will vary with chemical exposure. Consult Armor Technical Service for guidance.

Discoloration and loss of gloss occur above 200°F (93°C) but do not affect performance.

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TERMS AND CONDITIONS OF SALE

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