



SPI COATINGS

PROVEN PERFORMANCE • REAL WORLD SOLUTIONS

LINING KOTE NOVOLAC

Epoxy Enamel

**INSULATION
AND
CORROSION
SPECIALISTS**

Application Instructions (2/1/21)

LINING KOTE NOVOLAC is a two-part pigmented epoxy coating, which will produce a hard, tough coating film.

ADVANTAGES: 1) Outstanding resistance to solvents, acids, and alcohols, 2) Rapid property development at ambient & low temperatures, 3) Good working life, with cure-speed balance, and 4) NOVOLAC offers abrasion and high-chemical resistance.

GUIDELINES REGARDING pH SCALE

Use LINING KOTE NOVOLAC when facing pH values from 1-14.

SURFACE PREPARATION

Surface must be clean from oil, tar, rust, grease, salts, and films.

- 1) Use general degreaser if needed.
- 2) Clean surface using TSP (tri-sodium-phosphate) or a citrus cleaner to release dirt and degreaser residue.
- 3) Pressure-wash, if possible, @ 3500 psi.
- 4) Salt contamination on a surface can develop as a result of salt water, fertilizers, and car exhaust. Use Chlor*Rid or equivalent to decontaminate surface if salts are present. Acceptable levels: Nitrates: 5-10 mcg/cm², Sulfates: 5-10 mcg/cm², Chlorides: 3-5 mcg/cm²

Surface must be completely dry before applying.

- 1) LINING KOTE NOVOLAC must be applied during proper temperatures (below) and the prescribed overcoat window of the coating over which it will be applied.
- 2) If applied over an existing coating having a glossed or shiny finish, it must be sanded and roughed to remove gloss before application, to improve the profile.
- 3) Additional coats of LINING KOTE NOVOLAC can only be applied when the 1st coat becomes tacky to the touch and has little to no transfer of coating. After this stage, the surface must be lightly sanded to improve the profile.

MIXING

- 1) Open pail, mix base with curing agent (3 parts base: 1 part curing agent) (ratio by volume, not by weight)
- 2) Mix by hand for two minutes or using drill and mixing blade for a minimum of 30 seconds with NO vortex.

POT LIFE

30-45 minutes at 70°F (21°C) - 30 minutes or less at 90°F (32°C)

APPLICATION

LINING KOTE NOVOLAC can be applied by brush, roller, or spray; however, the preferred method is by air or airless sprayer.

- 1) If application is by brush, use a soft bristle brush.
- 2) If application is by roller, use a 1/4-1/2-inch nap roller, depending upon surface.
- 3) If application is by spray, use a standard airless sprayer (1½ gallons/minute at 3,300 psi or less) and .017-.027 tip.
- 4) Overcoat window is from tack free to 48 hours @ 70°F.

- **NOTE:** The number of applications and the thickness of each should be in accordance with the job specifications.

- **NOTE:** Temperatures must always be a minimum of 5 degrees above the dew point during application.

MINIMUM SPREAD RATES (mil thickness)

Porous Surfaces – Apply 2-3 applications of LINING

KOTE NOVOLAC @ 200 sqft/gallon; (18 sqmtr/gallon); 8 mils wet, 6.4 mils dry (200 microns wet, 160 microns dry) each coat. This will leave a total thickness of 12.8 dry mils (2 coats) or 19.2 (3 coats).

Metal Surfaces – Apply Moist Metal Grip as a primer and apply 2-3 applications of LINING KOTE NOVOLAC as directed above. **Important:** When applying LINING KOTE NOVOLAC over Moist Metal Grip, if relative humidity (RH) is <60% (and/or low temperature is below 70°F), Moist Metal Grip must be given extended time to cure (6-36 hours) due to low RH and low temp.

Note: Surface and ambient temperatures will determine cure time. Introduction of heat beneath or over surface will enhance cure time.

CURE TIME

Note: Surface and ambient temperatures will determine cure time. Introduction of heat over surface will enhance the cure time. Average time at 70°F is 7 days.

Induction Period: None is required at 70°F or above.

TEMPERATURE

- 1) Apply between 40°F. and 120°F.
- 2) Store between 40°F. and 100°F. according to hazmat standards indicated on MSDS.

CLEAN-UP EQUIPMENT

- 1) After completion, spray systems should be flushed and cleaned with MEK or other comparable solvents.
- 2) After completion, brushes can be cleaned with MEK or comparable solvents, store and reused.