

**DESCRIPTION**

- a high solids polyamine adduct-cured chemical resistant epoxy tank lining
- conforms to AS/NZS 3750.14
- approved to AS/NZS 4020:2005

PRINCIPAL CHARACTERISTICS

- suitable for the protection of steel structures and tanks in aggressive chemical environments when applied over suitably prepared substrates
- excellent resistance to a wide range of chemicals (refer to *I-19 Watty Tank Lining Resistance Guide* for a full list of suitable cargoes)
- resistant to aliphatic and aromatic petroleum products
- resistant to fresh and salt water
- good low temperature cure down to +5°C
- approved for use as a lining in potable water tanks with volumes of 180 litres or greater

COLOURS AND GLOSS

- white, gloss

BASIC DATA AT 25°C

- solids content approx. 77% by volume
- mix ratio 3A:1B by volume
- typical film thickness (per coat) 150-250 microns(dry), 195-325 microns(wet)
- theoretical spreading rate 5.1 m²/l for 150 microns(dry)
- touch dry after 3 hours
- overcoating interval..... refer to overcoating table for details
- full cure after refer to curing table for details
- shelf life (cool and dry place) at least 12 months

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURE

- all surfaces to be coated must be clean, dry and free from chalking and contamination
- oil and grease should be removed from all surfaces in accordance with AS 1627.1 solvent cleaning
- mild steel; blast clean in accordance with AS 1627.4 to Sa 2½ minimum (AS 1627.9), surface profile 40-70 microns
- if oxidation occurs between blasting and application, the surface should be reblasted to the specified visual standard
- surface defects revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner
- concrete should be blast cleaned to remove all laitance; moisture content should be maximum 4%
- previous suitable coat; dry and free from any contamination and sufficiently roughened if necessary
- substrate temperature must be at least 5°C during surface preparation, application and curing and at least 3°C above dew point
- relative humidity should not exceed 85%
- for potable water tanks, the substrate temperature must be at least 10°C during application and curing



INSTRUCTIONS FOR USE

- mix ratio 3A:1B by volume
- mix with EpinameL TL710 Part B only
- induction time - 15 mins at 15°C, 5 mins at 25°C
- stir thoroughly after the induction time before using
- pot life at 25°C 1 hour. Do not use after this time even if the mix is still liquid
- stir the components and mixed product well using a mechanical mixer
- the temperature of the mixed product must be above 15°C, otherwise extra thinner may be required to obtain application viscosity
- too much thinner will result in lower sag resistance and slower cure
- thinner should only be added after mixing the components
- additional stripe coat to be brush applied to edges, holes, corners and welds before application of the next full coat
- for full cure and chemical resistance, thinning rates and film thicknesses must be strictly controlled
- freshly catalysed material should not be added to product that has been mixed for some time
- for recommendations outside those contained in this data sheet, refer to WattyL

APPLICATION

- **AIRLESS SPRAY**
 - thinner L760
 - thinner addition..... up to 10%
 - nozzle orifice..... approx. 0.53 mm (= 0.021 inch)
 - nozzle pressure 15 MPa (2100 psi)
- **AIR SPRAY**
 - recommended thinner L760
 - volume of thinner up to 15%
 - nozzle orifice..... 1.8 - 2.0 mm
 - nozzle pressure 0.3 - 0.4 MPa (50 - 60 psi)
- **BRUSH/ROLLER**

For spot repair and stripe coating only

 - thinner L760
 - volume of thinner up to 5%

The maximum dry film thickness that can be achieved when brushing/rolling is 100 microns
Multiple coats may be required to achieve the recommended dry film thickness
- **CLEANING SOLVENT** L760

SAFETY PRECAUTIONS

- flammable. Avoid contact with heat and naked flame
- avoid contact with skin and eyes
- use gloves, mask and goggles during application
- provide adequate ventilation when using in confined spaces
- this product is intended for use in industrial situations by professional applicators in accordance with the advice given on this sheet. All work involving the use and application of this product should be carried out in compliance with all relevant Health, Safety & Environmental standards and regulations and must not be used without reference to the Material Safety Data Sheet (MSDS)

**ADDITIONAL DATA****Overcoating table with Epinamel TL710**

Substrate temperature	5°C	15°C	25°C	35°C
Minimum interval	32 hours	16 hours	8 hours	4 hours
Maximum interval when NOT exposed to direct sunlight	6 days	5 days	5 days	3 days
Maximum interval when exposed to direct sunlight	3 days	2 days	2 days	1 day

- surface must be dry and free from chalking and contamination
- coating may darken on exposure to direct sunlight

Curing table

Minimum curing time of Epinamel TL710 coating system before exposure to:

Substrate temperature	Potable water	Other recommended products *
5°C	not recommended	18 days
15°C	15 days	10 days
25°C	9 days	7 days
35°C	6 days	5 days

- adequate ventilation must be continuously maintained during application and curing

* refer to *I-19 Wattyl Tank Lining Resistance Guide* for further information

Tank Cleaning Procedure (for holding potable water)

- Fully cured coating shall be cleaned before putting into service.
- Tank cleaning procedure shall be performed in accordance with local council or water authority procedures. If no such procedures exist, the following procedure should be used.
- Clean tank by high pressure water washing with potable water. Then fill tank with potable water, allow to stand for 24 hours, drain, then perform a final high pressure water wash with potable water. Maximum water temperature for washing shall be 40°C.

Pot life (at application viscosity)

Paint temperature	Potlife
15°C	2 hours
25°C	1 hour
35°C	30 mins

For the most up to date information contact Wattyl Customer Service Hotline or visit the Wattyl Website.

	Australia	New Zealand
CUSTOMER SERVICE HOTLINE	132 101	0800 735 551
WEBSITE	http://www.wattyl.com.au	http://www.wattyl.co.nz

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