DUREBILD® TLE

High Build Two Pack Epoxy **PC 221**

FEATURES

- SELF PRIMING
- EXCELLENT CHEMICAL RESISTANCE
- EXCELLENT WATER TANK LINING
- SUITABLE FOR HOT WATER IMMERSION
- SUITABLE FOR CONTACT WITH FOODSTUFFS

USES

DUREBILD®TLE is recommended for the protection of steel structures in harsh chemical atmospheres and in aggressive on and off shore environments. It is suitable for immersion in fresh, salt and hot (up to 100°C) water.

SPECIFICATIONS

The use of film forming components of DUREBILD® TLE when applied as directed is authorised by Section 175.300 of the U.S. Code of Federal Regulation (Food & Drugs) as the food contact surface of articles intended for use in producing, manufacturing, packing, processing, preparing, treating, packaging, transporting or holding food, subject to the limitation and conditions of use prescribed in that Section.
AS4020 for use with potable water.

RESISTANCE GUIDE

HEAT RESISTANCE	Up to 130°C dry heat. 100°C Wet
WEATHERABILITY	Epoxy coatings may yellow with time. On exterior exposure some chalking may also occur. This will not detract from the protective properties of the coating. Use a weatherable topcoat if required for appearance.
SOLVENTS	Excellent lining for aliphatic and aromatic hydrocarbons and refined petroleum products. Resists splash and spillage of most solvents.
ACIDS	Good resistance to most acids.
ALKALIS	Excellent resistance to most common alkalis.
SALTS	Excellent resistance to splash and spillage of most salt solutions.
WATER	Recommended as a lining for fresh, salt and de-ionised water. Suitable for hot water to 100°C.
ABRASION	Good when fully cured.

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Amine adduct cured epoxy	
FINISH	Low Sheen	
COLOUR	White	
COMPONENTS	Two	
SOLIDS BY VOLUME	52% (White)	
VOC LEVEL	<410 g/L (White)	
FLASH POINT	4°C	
POT LIFE	8 Hours (4L, 25°C)	
MIXING RATIO (V/V)	Part A : 4	Part B : 1
THINNER	920-08925	Dulux® Epoxy Thinner
PRODUCT CODE	781-84396	White
	976-84397	Hardener

APPLICATION CONDITIONS	Min	Max
Air Temperature	5°C	45°C
Substrate Surface Temperature	5°C	45°C
Relative Humidity		85%

	Min	Max	Recom.
Wet film per coat (microns)	195	385	240
Dry film per coat (microns)	100	200	125

SUITABLE SUBSTRATES Abrasive blast cleaned steel.

APPLICATION METHODS Conventional, airless spray or air assisted spray.

Drying characteristics at 125 microns dry film thickness

Temperature	Humidity	Touch	Handle	Full Cure	Overcoat Min	Overcoat Max*
5° C	50%	8 Hours	24 Hours	7 Days	24 Hours	2 Weeks
10° C	50%	7 Hours	16 Hours	7 Days	16 Hours	2 Weeks
15° C	50%	6 Hours	13 Hours	7 Days	13 Hours	2 Weeks
25° C	50%	5 Hours	10 Hours	7 Days	10 Hours	2 Weeks

These figures are given as a guide only, as ventilation, film thickness, humidity, thinning and other factors will influence the rate of drying.

If the maximum overcoat interval is exceeded then the surface MUST be abraded to ensure maximum intercoat adhesion.

- When used for non-immersion conditions. Refer to PRECAUTIONS section for overcoating intervals and requirements fro immersion service.

TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD

A spreading rate of 4.2 sq. metres per litre corresponds to 125 microns dry film thickness assuming no losses.
Practical spreading rates will vary depending on such factors as method and conditions of application and surface roughness.

DUREBILD® TLE

TYPICAL SYSTEMS

(The typical systems are offered as a guide only and are not to be used as a specification. It is recommended that the specific needs of a project be discussed with a Dulux Protective Coatings Consultant.)

SURFACE	PREPARATION GUIDE	SYSTEM		DRY FILM THICKNESS
STEEL	Abrasive blast AS1627.4 Class 2.5	1st Coat	DUREPON® P14	75 Microns
		2nd Coat	DUREBILD® TLE	125 Microns
		3rd Coat	DUREBILD® TLE	125 Microns
STEEL Hot Water Immersion	Abrasive blast to AS1627.4 Class 3.0	1st Coat	DUREBILD® TLE	125 Microns
		2nd Coat	DUREBILD® TLE	125 Microns

SURFACE PREPARATION

Round off all rough welds, sharp edges and remove weld spatter. Remove grease, oil and other contaminants in accordance with AS1627.1. Rust millscale, oxide deposits and old paint films on metal surfaces must be removed by abrasive blast cleaning to a minimum AS1627.4 Class 2.5 with a blast profile of 40-70 microns. Immersed steel must be prepared to AS1627.4 Class 3. Remove all dust by brushing or vacuum cleaning.

APPLICATION

Stir each can thoroughly until the contents are uniform. Use of a power mixer is recommended. Mix the contents of both packs together thoroughly using a power mixer and allow to stand for 10 minutes. Remix thoroughly before using.

BRUSH/ROLLER

Recommended only for spot patching on rivets, seams etc. When brushing and rolling additional coats may be required to attain the specified thickness.

CONVENTIONAL SPRAY

Thin up to 100ml/litre with Dulux® Epoxy Thinner (920-08925) to aid atomisation.

Typical Set-up

Graco Delta Gun:	1.8mm (239543)
Pressure at Pot:	65-100 kPa (10-15 p.s.i.)
Pressure at Gun:	385-420 kPa (55-60 p.s.i.)

AIRLESS SPRAY

Standard airless spray equipment such as a Graco 45:1 or 56:1 Xtreme with a fluid tip of 19–21 thou (0.48-0.53mm) and an air supply capable of delivering 550-690 kPa (80-100 p.s.i.) at the pump. Thinning is not normally required but up to 50 ml/litre of Dulux® Epoxy Thinner (920-08925) may be added to ease application.

PRECAUTIONS

This is an industrial product designed for use by experienced Protective Coating applicators. Where conditions may require variation from the recommendations on this Product Data Sheet contact your nearest Dulux® representative for advice prior to painting. Do not apply in conditions outside the parameters stated in this document without the express written consent of Dulux® Australia. Freshly mixed material must not be added to material that has been mixed for some time. The rate of cure is dependent upon temperatures below 5°C. Do not apply at relative humidity above 85% or when the surface is less than 3°C above the dewpoint. When used for immersion conditions the maximum overcoat interval is 3 days at 25°C. The coating MUST be fully cured and solvent free prior to being placed under immersion conditions. For best results in water immersion conditions replace Dulux® Epoxy Thinner (920-08925) with Dulux® CR Reducer (965-63020).

CLEAN UP

Clean all equipment with Dulux® Epoxy Thinner (920-08925) immediately after use.

OVERCOATING

Aged coating should be tested for lifting by a method appropriate to the coating thickness, for example 'X' cut or cross-hatch methods. If it lifts, remove it. The surface must be free of oil, grease and other contaminants. High-pressure water wash at 8.3 to 10.3 MPa (1,200 - 1,500 p.s.i.) to remove loosely adhering chalk and dust. Abrasion may be required depending on surface. If the maximum overcoat interval is exceeded then the surface MUST be abraded to ensure maximum intercoat adhesion.

SAFETY PRECAUTIONS **Read Data Sheet, Material Safety Data Sheet and any precautionary labels on containers.**

STORAGE

Store as required for a flammable liquid Class 3 in a bunded area under cover. Store in well-ventilated area away from sources of heat or ignition. Keep containers closed at all times.

HANDLING

As with any chemical, ingestion, inhalation and prolonged or repeated skin contact should be avoided by good occupational work practice. Eye protection approved to AS1337 should be worn where there is a risk of splashes entering the eyes. Always wash hands before smoking, eating, drinking or using the toilet.

USING

Use with good ventilation and avoid inhalation of spray mists and fumes. If risk of inhalation of spray mists exists, wear combined organic vapour/particulate respirator. When spray painting, users should comply with the provisions of the respective State Spray Painting Regulations.

FLAMMABILITY

This product is flammable. All sources of ignition must be eliminated in, or near the working area. DO NOT SMOKE. Fight fire with foam, CO_2 or dry chemical powder. On burning will emit toxic fumes.

WELDING

Avoid inhalation of fumes if welding surfaces coated with this paint. Grind off coating before welding.

MATERIAL SAFETY DATA SHEET is available from Customer Service (132377) or www.duluxprotectivecoatings.com.au

Dulux Protective Coatings a division of DuluxGroup (Australia) Pty Ltd
1956 Dandenong Road, Clayton 3168
A.B.N. 67 000 049 427

PACKAGING	Available in 4 and 20 litre packs
TRANSPORTATION WEIGHT	1.49 kg/litre (Average of components)
DANGEROUS GOODS	Part A: Class 3 UN 1263
	Part B: Class 3 UN 1866