DUREBILD® TLE

High Build Two Pack Tank Lining Epoxy — PC 221

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

USES

DUREBILD® TLE is a general purpose tank lining epoxy. It is recommended for the protection of steel structures in harsh chemical atmospheres and in aggressive on and off shore environments.

DUREBILD® TLE is suitable for immersion in fresh, salt and hot water (up to 100°C).

For information on suitability for use as a food contact surface, refer to your Dulux® Protective Coatings Representative.

SPECIFICATIONS AS/NZ 4020:2005 for use with potable water (White only)

RESISTANCE GUIDE

WEATHERABILITY	Will yellow with time and chalk on exterior exposure. Neither yellowing nor chalking detracts 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.
HEAT RESISTANCE	Up to 130°C dry heat. Up to 100°C wet	**WATER**	Excellent lining for fresh, salt and de-ionised water. Suitable for hot water immersion to 100°C.
SALTS	Excellent resistance to splash and spillage of most salt solutions	**ALKALIS**	Excellent resistance to most common alkalis
ACIDS	Good resistance to most acids	**ABRASION**	Good when fully cured

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Amine adduct cured epoxy
FINISH	Low Sheen
COLOUR	White
COMPONENTS	Two
VOLUME SOLIDS	52%
VOC LEVEL	<410 g/L
FLASH POINT	4°C
POT LIFE	8 hours (4 litre kit, 25°C)
MIXING RATIO V/V	Part A : 4 Part B : 1
THINNER	920-08925 Dulux® Epoxy Thinner
THINNER (IMMERSION)	965-63020 Dulux® CR Reducer
PRODUCT CODE	781-84396 White 976-84397 Hardener

APPLICATION CONDITIONS

	Min	Max
Air Temp.	10°C	45°C
Substrate Temp.	10°C	45°C
Relative Humidity		85%

COATING THICKNESS (MICRONS)

	Min	Max	Recommended
Wet film per coat (µm)	195	385	240
Dry film per coat (µm)	100	200	125

SUITABLE SUBSTRATES	Abrasive blast cleaned steel
PRIMERS	Durepon P14
APPLICATION METHODS	Conventional, airless spray or air assisted spray

DRYING CHARACTERISTICS AT 125 µm DRY FILM THICKNESS*

					OVERCOAT	
Temperature	**Humidity**	**Touch**	**Handle**	**Full Cure**	**Min**	**Max[1, 2]**
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 Hour	10 Hours	7 Days	10 Hours	2 Weeks

***** These figures are a guide only, as ventilation, film thickness, humidity, thinning and other factors will influence the rate of drying.
[1] If the maximum overcoat interval is exceeded then the surface MUST be abraded to ensure maximum intercoat adhesion
[2] NOTE: Figures shown above are for non-immersion conditions. 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. Refer to PRECAUTIONS section.

SPREADING RATE ASSUMING NO LOSSES

4.2 square metres per litre equals 125 µm dry film thickness
NOTE: Practical spreading rates will vary depending on such factors as application method, ambient conditions, surface porosity and roughness.

DUREBILD® TLE

TYPICAL SYSTEMS

This is a guide only and not to be used as a specification. Your specific project needs must be discussed with a Dulux Protective Coatings Consultant.

SURFACE	ENVIRONMENT	PREPARATION GUIDE	SYSTEM		DFT (µm)
STEEL – NEW	Very high corrosivity (AS2312.1 Cat C5) System EHB3	Abrasive blast clean AS1627.4 Class 2.5	1st Coat 2nd Coat 3rd Coat	Durepon® P14 Durebild® TLE Durebild® TLE	75 µm 125 µm 125 µm
STEEL – NEW	Immersion – hot or potable water	Abrasive blast clean AS1627.4 Class 3	1st Coat 2nd Coat	Durebild® TLE Durebild® TLE	125 µm 125 µm
CONCRETE	Exterior/Interior	Remove release agents and other surface contaminants	1st Coat 2nd Coat	Durebild® TLE Durebild® TLE	125 µm 125 µm

NOTE: If application is by brush or roller, additional coats will be necessary to achieve the minimum DFT

SURFACE PREPARATION

Steel: Round off all rough welds, sharp edges and remove weld spatter. Remove grease, oil and other contaminants in accordance with AS1627.1. Degrease with Gamlen CA 1 (a free-rinsing, alkaline detergent) according to the manufacturer's written instructions and all safety warnings. Abrasive blast clean to a minimum of AS1627.4 Class 2.5. **Immersed steel**: Abrasive blast cleaned to AS1627.4 Class 3. Remove all dust by brushing or vacuum cleaning. **Concrete**: Concrete must be at least 28 days old before coating. Remove all laitance, form release, curing compounds, oil, grease and other surface contaminants. **Horizontal concrete**: Diamond grind to provide a profile. Remove all dust by vacuum cleaning. Fill any large cracks or voids using Luxepoxy® Filler.

APPLICATION

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

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 atomization.

Typical Set-up	Graco AirPro:	1.8mm (239543)
	Pressure at Triton 308:	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 Xtreme 45:1 or 56:1 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 aid 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® Consultant for advice prior to painting. Do not apply in conditions outside the parameters stated in this document without the 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 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. When used for water immersion conditions, replace Dulux® Epoxy Thinner with Dulux® CR Reducer (965-63020).

CLEAN UP

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

OVERCOATING

Degrease with Gamlen CA 1 according to the data sheet. Test adhesion of existing coating by standard cross hatch adhesion test. If the coating fails, remove it. High-pressure water wash at 8.3 to 10.3 MPa (1,200-1,500 p.s.i.) to remove chalk and dust. Abrade surface to provide a good key for the new coating. Epoxies must be abraded if recoated outside the recoat window.

SAFETY PRECAUTIONS

Read Data Sheet, SAFETY DATA SHEET and any precautions on container labels. SAFETY DATA SHEET is available from Customer Service (13 23 77) or www.duluxprotectivecoatings.com.au

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 spraying, users must comply with their 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, CO2 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.

COMPANY INFORMATION

Dulux Protective Coatings a division of

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PACKAGING, TRANSPORT AND STORAGE

PACKAGING	Available in 20 litre packs
TRANSPORTATION WEIGHT	1.49 kg/litre (Average of components)
DANGEROUS GOODS	Part A: Class 3 UN 1263 Part B: Class 3, 8 UN 2945