Dulux
PROTECTIVE COATINGS

Ultra High Build Epoxy

Dulux® Dureline™ SE 10

Protection you can count on.

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1.0 Introduction

Dulux® Dureline™ SE 10 is a spray-applied, 100% solids, two-component, 2:1 epoxy system. It provides a seamless lining/coating through single-leg airless and plural component equipment (preferred). This product is suitable for application to steel or concrete in water and open top wastewater treatment, secondary containment, sheet pilings, pipelines, and tank linings.

Read this guide carefully before starting work. It provides essential information for applying Dureline™ SE 10. The respective Technical Data Sheet (TDS) and project specification need to be reviewed in conjunction with this guide. Resolve any inconsistencies before starting work. For more information, Contact Dulux® Protective Coatings for more information.

1.1 What is Dulux® Dureline™ SE 10

Dureline™ SE 10 is a 100% two-component solvent free Bis-A type epoxy.

- Part A: 2 parts by volume
- Part B: 1 part by volume

The recommended method for applying this product is through plural component equipment as outlined within this guide. Alternatively, a single-leg airless application option is also available.

The guide is intended to offer important information to applicators of Dulux® Dureline™ SE 10 to ensure the final project meets its intended purpose.

Applicators must follow these guidelines unless they have written approval from Dulux® Protective Coatings Technical Service.

1.2 Product Quality Assurance

All raw materials are subjected to ISO 9001:2015 registered quality testing systems before being released for manufacture.

1.3 Technical Support

An experienced technical service team works with sales to support our customers in the field.

Please Note: Dulux® Dureline™ SE 10 is a specialised product, and application training of the product is exclusively provided by Dulux® Protective Coatings Technical Services.

2.0 Surface Preparation and Priming

2.1 Steel Surface Preparation

All steel surfaces to be protected by Dulux® Dureline™ SE 10 must be correctly prepared. Surface preparation and painting should be carried out in line with best industry practices as indicated in many publications by organisations such as NACE, SSPC, AMPP, ISO, ASTM, AS, and NZS etc. The Dulux® Protective Coatings surface preparation specification for the project is to be considered the minimum requirements. If a client or project specifications require a higher level of surface preparation and/or cleaning, then the higher level should be adopted. All steel surfaces must be clean, dry, and free from all surface contamination, refer to AS 1627.1 (similar to SSPC - SP1), before abrasive blast cleaning according to AS 1627.4 using pictorial guide ISO 8501-1:2007 (similar to SSPC-VIS 1).

After abrasive blasting has been completed, all dust and debris resulting from the surface preparation process must be removed from the cleaned surface using a vacuum cleaner, dry, oil-free compressed air and/or brush. Dulux® Dureline™ SE 10 can be applied directly to blast-cleaned steel (where appropriate) with a uniform angular anchor surface profile of 75 to 100 µm.

2.2 Concrete Surface Preparation

Concrete must be at least 28 days old before coating. Remove all laitance, form release agents, curing compounds, oils, greases, and other surface contaminants. Use diamond grinding, track blasting, light shot-blasting, or other mechanical methods as recommended within ICRI Guideline No. 310.2R to achieve an appropriate profile for the intended surface i.e. ICRI CSP 4-5 for primary containment concrete tanks. For other concrete structures, contact your local Dulux® Protective Coatings Consultant for concrete surface profile levels.

Fill any bugholes, cracks or voids opened up during surface preparation process using an appropriate Dulux® Protective Coatings or Fosroc Filler/Resurfacer to create a monolithic surface to coat over. The specific filler(s) will be determined according to the Dulux® Protective Coatings' specification.

To minimise the risk of moisture interference, Dulux® Protective Coatings advises conducting the following qualitative test before applying the coating:

- ASTM D 4263 "Standard Test Method for Indicating Moisture in Concrete by the Plastic Sheet Method" (no visible moisture present).

If there are any concerns regarding moisture issues with the concrete slab, or for projects exceeding 500m2, at least one of the following more precise quantitative test methods should be used. Before coating, the moisture content must meet the stated requirements:

- ASTM F 1869 “Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete Subfloor Using Anhydrous Calcium Chloride” (moisture vapour transmission should not exceed 1.4 kilograms (3 pounds) per 93 square metres (1,000 square feet) in 24 hours).
- ASTM F 2170 “Standard Test Method for Determining Relative Humidity in Concrete using in situ Probes” (as referred to in AS 1884-2012, relative humidity should be less than 75%) Note: The testing listed above cannot guarantee avoidance of future moisture related problems particularly with existing concrete slabs. This is especially true if the use of an under-slab moisture vapour barrier cannot be confirmed or concrete contamination from oils, chemical spills, unreacted silicates, chlorides or Alkali-Silica Reaction (ASR) is suspected.

2.3 Primer

Consult your local Dulux® Protective Coatings Consultant and/or project specification to determine if a primer is required.

2.4 Coating Over Approved Primers and/or Properly Prepared Surfaces

Before applying Dulux® Dureline™ SE 10, ensure the primed surfaces are dry, and free from all traces of surface contaminants, such as grease and soluble salts. Follow the overcoating time and temperature guidelines stated on the specific primer’s technical data sheet.

3.0 Product Storage

Store the product in a ventilated, covered area. Keep containers closed.

4.0 Application

Two application methods are provided in the guide. Plural component is preferred for the best finish. Single-leg airless application is possible but has a limited pot life and may result in a coarser finish when compared to plural component application.

NOTE: Brush and roll application should only be used for small areas of touch up or as part of a wet-on-wet stripe coat application.

4.1 Plural Component: Required Equipment

The proportioning pump shall be capable of delivering 7,000 PSI (483 BAR) static material pressure, 6,000 PSI (414 BAR) dynamic pressure. The preferred equipment starting base is a Graco® XP-70hf plural component pump. Consult Dulux® Protective Coatings Technical Service for advice on alternative equipment or configurations to apply this material.

Modify the Graco® XP plural component unit as follows:

- TANKS: (2) 95 Liter double wall heated tanks with temperature gauges, (2) 5:1 feed pumps with regulators and pressure gauges, (2) agitators, (2) 30 mesh low-pressure WYE filters between tanks and pump lowers, (2) 3/4 inch (18 MM) ID fluid lines from the feed pumps to the pump lowers and (4) ½ inch (13MM) ID air lines for the feed pumps and agitators.
- Pump Ratio: This product is a 2:1 ratio product. 290CC lower for Part A /145CC lower for Part B are recommended with the XP hf air XL 10,000 motor.
- Primary Heaters: Two 5,400-watt fluid heaters with temperature gauges.
- Solvent Flush Pump: A 30:1 or larger solvent pump with the fluid line to the mix manifold.
- Heated Hose Bundle (Remote Mix Manifold Option): 45 meter maximum length – with (1) ½ inch (13MM) ID paint line for the Part B side, (1) 3/8 inch (10MM) ID paint line for the Part A side, (2) 3/8 inch (10MM) recirculation lines that go back to the feed tanks/drums, (1) 1/4 inch (6MM) solvent flush line, and (1) hose heat controller unit with heat trace line and temperature sensor. All is wrapped in insulation and covered with an abrasion-resistant plastic jacket.
- Mix Manifold: Should include valving for material flow, recirculation lines, and solvent flush. Remove any restrictors or filters that may come with the mix manifold. Also, remove any filters that may be present on the high-pressure side of the pump.
- Forward of the Mix Manifold: Forward of the mix manifold the static mixers and paint line should be configured in the following order:

(2) 3/8 inch (10MM) x 12 fold SS static mixers	**(1) 15 meter x 3/8 inch (10MM) ID paint line**	**(1) ¼ inch (6MM) ID x 12 fold SS static mixer**	**(1) 2 meter x ¼ inch (6MM) ID whip line**	**Graco XHF, or similar spray gun w/ XHD RAC & tips**

- Material should be preconditioned to 20˚C – 30˚C 24 to 48 hours prior to use.
- Both sides should be heated to 35˚C – 40˚C inside the heated tanks. This is accomplished through a combination recirculating the material through the primary heaters back into the tank, constant slow agitation of the product on both sides, and the heated tanks maintaining the material temperature. Take care to not overheat product.
- Material temperature exiting the spray tip should range between 30˚C to 35˚C.
- Optional heated hose bundle heat should be set at 60˚C – 70˚C.
- Dynamic pressure range (the pressure while spraying) should range between 3,500 (241 BAR) to 4,000 (276 BAR) PSI.
- Spray tips – Graco HD RAC spray tips at a range of 0.021 – 0.025 without diffuser bar. The ideal orifice size typically is 0.023.
- Static mixers, whip lines, spray gun and spray tip should be flushed with Dulux® Epoxy Thinner (920-08925) or Dulux® CR Reducer (965-63020) as needed. Replace or disassemble and clean static mixers as needed. A second set of static mixers, whip line, and gun is recommended to decrease down time on projects.
- Material must be flushed out with Dulux® Epoxy Thinner (920-08925) or Dulux® CR Reducer (965-63020) within 1 minute of releasing the trigger on the spray gun. Failure to flush within the set time will result in material setting up in the static mixers, paint line, spray gun, and spray tip.

4.2 Plural Component: Application Information

Setting Up to Spray: Plural Component

- For new equipment, individual components should be connected as recommended by the equipment manufacturer and Dulux® Protective Coatings Technical Services. Lubricate all pumps and follow all the equipment manufacturer's instructions for the assembly of equipment.
- Provided used equipment meets Dulux® Protective Coatings' equipment recommendations, and is in good working order, there should not be a concern about using that equipment. NOTE: Do not use equipment where there is a potential of cross contamination between other technologies (such as polyurethane) and epoxy coatings.
- Check and clean all fluid filters, air traps and filters. Ensure filters are installed on the low-pressure side only, and are removed from the high-pressure side.
- Have a qualified electrician check the electrical system to ensure proper power requirements are satisfied and there is complete continuity in all circuits.
- Identify and mark which side will contain the epoxy side, and which side will contain the polyamine hardener.
    - o Mark all epoxy side pumps, inlets, outlets, heaters, hose fittings, and gun inlets "A-Side".
    - o Mark all Amine hardener side pumps, inlets, outlets, hose fittings, and gun inlets "B side". Retain this identification and use only as indicated to avoid cross contamination.
- Perform an initial flush of the system with Dulux® Epoxy Thinner (920-08925) or Dulux® CR Reducer (965-63020) , followed by a final purge with Dulux® Protective Coatings CR Reducer Thinner. Ensure that all moisture, equipment oils, etc. is removed from filters, hoses, etc.
- Perform a pressure check of the system to ensure there are no loose or leaking connection points. Repair any issues found through the test.

Spraying Material: Plural Component

- Once the equipment system is clean and leak free, push all solvents out of the heated tanks and recirculation system out to waste. Ensure all solvent is removed out of the heated tanks before putting material into them.
- Individually premix both sides with dedicated double helical mixing blades, heavy duty power mixers. Use long bladed stainless-steel spatulas to scrape the product off the internal can walls into the main body of the material while being power mixed.
    - o Once premixing is complete, pour material into the appropriate heated tanks using the dedicated stainless-steel spatulas to get all the material out of the cans into the tanks.
    - o Once the heated tanks have been filled with material, turn the agitators on a low speed to keep the material temperature and product blend uniform.
    - o As material is applied and product is depleted inside the heated tanks, repeat this process every 20 litres used to keep the product uniformly heated and blended throughout the application process.
    - o No thinner is to be added to either side.

- Push material through each recirculation line until a solid flow of Part A and Part B individually comes out of each recirculation line into individual waste buckets (not inside the equipment tanks). Once this step is complete, reinstall recirculation lines back into their individual heated tanks. Recirculate both sides of the material through the primary inline heaters until the correct material temperatures have been reached on each side before beginning the application.

- Once the correct material temperature has been achieved, switch from recirculation mode to spray mode and push out all residual solvent out forward of the mix manifold - through the integration line, static mixers, and spray gun to a grounded waste container until solid, mixed material is flowing out the spray gun. Once this step has been achieved, install the needed spray tip and increase spray pressure until a proper spray pattern is achieved.
- Start all spraying off target, moving over the target to avoid spot build-up of material on the edges of the spray pattern. Use a 50% overlap with the spray orientation perpendicular to the target being sprayed to ensure an evenly coated surface. Spray continuously as much as possible and minimise triggering the gun.
- Wherever there is even a small change in pressure, spray pattern, colour or consistency of the material, the applicator should stop coating activity and solvent flush everything forward of the mix manifold, then evaluate for the source of the problem and the issue resolved before moving forward with the coating application. All off-ratio material should be remediated before continuing the application.
- Static mixers should be checked periodically for any build-up of material. If build-up is found, clean and/or replace to ensure the project is not slowed down.
- If the integration line and whip hose is unheated, the material inside will cool down during periods when not spraying and therefore will be below the temperature required to yield a satisfactory spray pattern. Spray into a waste bucket until a satisfactory spray pattern is re-established before spraying on target. The temperature of the material at the gun can be checked using an IR gun pointed at the stream of the material.
- At a minimum, fully flush static mixers, whip lines, spray gun and spray tip every four hours and when completed for the day. Replace and/or disassemble and clean all static mixers as part of the shutdown process for each day. Ideally, this is accomplished twice a day if a full day of application occurs.

Purge Time: Product forward of the mix manifold

- Fully flush and clean everything forward of the mix manifold with Dulux® Protective Coatings CR Reducer if more than 5 minutes at an ambient temperature of 25˚C elapse after releasing the spray gun trigger. Failure to flush/purge within the set time may result in material setting up in the static mixers, paint line, spray gun, and spray tip.
- Warmer ambient air and material temperatures will decrease the purge time, cooler material may slightly increase the purge time. It is a good practice to always purge all material forward of the mix manifold if there is any chance of a delay in spraying the product.

Overnight Shutdown Procedures/Changeout of Lines Forward of Mix Manifold

- Reduce material pressure and close the main air valve to the system.
- Close the material dual shutoff handle.
- Engage the spray gun trigger lock, remove the spray tip and clean/soak in solvent.
- Open the solvent flush pump valve and air valve. Slowly turn the solvent pump air regulator clockwise to increase air pressure.
- Disengage the trigger lock and trigger spray gun into a grounded pail. It is ideal to use a pail with a pail lid with a hole in the lid to reduce the possibility of solvent “blowing back” onto the person doing the work.
- Flush out everything forward of the mix manifold through to the spray gun until all material is removed and the clean solvent is observed coming out of the spray gun.
- Decrease the pressure on the solvent flush pump air regulator until depressurised and then shut off the fluid valve.
- Break down the static mixers, spray gun, and spray tip/spray guard. Clean all items until fully clean of product. Replace static mixers where needed.
- Reassemble all parts back together then flush solvent through all elements forward of the mix manifold to the spray gun until clean solvent is observed. Pressure check the system forward of the mix manifold for leaks and repair as required.
- Depressurise the system for the evening.
- Ensure the equipment is sealed and the material is free of moisture.
- If needed, precondition material for use on the following day.

Clean up of Equipment for Long Term Storage

Contact Dulux® Protective Coatings Technical Services for detailed recommendations.

4.3 Single-Leg Airless: Required Equipment:

The single-leg airless pump shall be capable of delivering 6,000 PSI (414 BAR) dynamic pressure. The preferred single-leg airless equipment starting base is a Graco® King XL60-220 (60-1 airless single-leg pump with 220cc lower) airless pump. Consult Dulux® Protective Coatings Technical Service for advice on alternative equipment or configurations.

Modify the Graco® King XL60-220 airless pump unit as follows:

- Add stainless steel hopper and camlock connection assembly to gravity feed the pump lower.
- While not always required (material temperature dependant), it is highly recommended to install a 5,400-watt fluid inline heater with temperature gauge, mounting/hose/fitting kit. In cooler weather conditions this will be needed, in warmer conditions it will not be needed.

NOTE: When heating material via single-leg airless application, there is an increased potential for the coating to solidify in the line and spray gun. The applicator must be aware of this and keep the product constantly moving through the spray gun. Any breaks in spraying will require immediate flushing of the equipment to prevent the product from setting up and solidifying.

- From the pump add up to 15 meters of 3/8" (10mm) material hose, followed by up to 2 meters of ¼" whip line and then a Graco XTR 7 spray gun.
- Depending upon the head pressure involved, the use of up to 15m ½" (12.7mm) material line with a 2m of 3/8" (10mm) whip line may be required.
- Use Graco XHD RAC switch tip and guard or equivalent. Spray tip size range is 0.023 to 0.027. The ideal spray tip typically is 0.025.

4.4 Single-Leg Airless: Application Information:

Setting Up to Spray: Single Leg Airless

- For new equipment, individual components should be connected as recommended by the equipment manufacturer and Dulux® Protective Coatings Technical Services. Be sure to lubricate all pumps and follow all the equipment manufacturer's instructions for assembly of equipment.
- Provided used equipment meets Dulux® Protective Coatings' equipment recommendations, and is in good working order, there should not be a concern about using that equipment. NOTE: Do not use equipment where there is a potential of cross contamination between other technologies and epoxy coatings.
- Ensure filters are removed from the pump manifold and spray gun.
- Have a qualified electrician check the electrical system to ensure proper power requirements are satisfied and there is complete continuity in all circuits when using an inline fluid heater.
- Perform an initial flush of the system with Dulux® Epoxy Thinner (920-08925) or Dulux® CR Reducer (965-63020) , followed by a final purge with Dulux® Protective Coatings CR Reducer Thinner. Ensure that all moisture, equipment oils, etc. is removed from filters, hoses, etc.
- Perform a pressure check of the system to ensure there are no loose or leaking connection points. Repair any issues found through the test.
- Ensure all equipment is clean. During flushing with solvent prior to painting, ensure there are no leaks.
- A stainless-steel hopper must be fitted to the pump lower to gravity feed material to the pump lower.
- Once the equipment is clean and leak free, push all solvents out of the equipment to waste. Ensure all solvent is removed out of the SS hopper and foot valve before putting material into the SS hopper.
- Pre-condition the material to between 20˚C to 30˚C prior to using material. This may involve cooling the material in the summer and warming in the cooler times of the year.
- In times of extreme weather conditions, both hot and cold, it may be necessary to precondition the surface temperature of the application equipment as the material will quickly assume the temperature of the metal parts of the pump it encounters and affect items such as viscosity, application, and pot life/spray life
- Individually premix both sides with dedicated double helical mixing blades, heavy duty power mixers.
    - o Power mix the Part A and Part B together in the Part A pail for a minimum of 2 minutes until the material is a homogenous blend. Use long bladed stainless-steel spatula to scrape the product off the internal can walls into the main body of the material while being power mixed. Ensure all material is thoroughly mixed together before pouring into the SS hopper.
    - o No thinner is to be added to this material.
- Once mixed product is poured into the SS hopper, push all residual waste in the system to a grounded waste bucket until a solid stream of Dureline™ SE 10 material is exiting the spray gun.

- Bring up the pressure up to a dynamic pressure range (the pressure while spraying) range between 5,000 (344 BAR) to 6,000 (414 BAR) PSI. Ideally, the material temperature exiting the spray gun will range between 30˚C to 35˚C. Adjust the inline heater as needed if being used during the application.
- Start all spraying off target, moving over the target to avoid spot build-up of material on the edges of the spray pattern. Use a 50% overlap with the spray orientation perpendicular to the target being sprayed to ensure an evenly coated surface. Spray continuously as much as possible and minimise triggering the gun.
- Wherever there is even a small change in pressure, spray pattern, colour or consistency of the material, the applicator should stop coating activity and solvent flush everything forward of the mix manifold then evaluate for the source of the problem and resolve before moving forward. All off-ratio material should be remediated before continuing the application.
- The material inside the line may cool down during periods when not spraying and therefore will be below the temperature required to yield a satisfactory spray pattern. Spray into a waste bucket until a satisfactory spray pattern is re-established before spraying on target. The temperature of the material at the gun can be checked using an IR gun pointed at the stream of the material.
- After every 4-6 kits the equipment should be flushed with solvent. First, Dulux® CR Reducer (965-63020), either new or filtered, is run through the pump pushing out residual material out to waste. If there is concern of residual material build up being present in the bottom of the SS hopper, fittings and associated piping going to the foot valve or the foot valve, take the time to clean out the residual material to avoid bigger issues later. Perform a second flush for five minutes or until solvent is clear using fresh Dulux® CR Reducer (965-63020). Dulux® CR Reducer (965-63020) can be used for the first flush cycle of the next flush cycle). Once flush is complete, reload pump with more mixed product and begin spraying product again.
- After the end of a work shift, the pump needs to be flushed as stated above. This time after the second flush, the foot valve connected to the pump lower, hopper and hopper assembly kit needs to be disassembled and thoroughly cleaned to remove all traces of coating material. This includes all spray tips and RACs. It should be noted the amount of flushing needed is dependent on temperatures, material build-up, and extended spray times. Complete cleaning is required at the end of every shift/day.

5.0 Spot Repair, Removal & Reinstall. Including the Process of Recoating Over Itself Past the Maximum Recoat Window

5.1 Spot Repair Including Film Defects

When removing film defects, cut back to a sound underlying coating or substrate. A sound coating is one that cannot be removed with a dull putty knife.

For Steel: If the steel substrate is exposed, the surface should be prepared to the original specification, or in the absence of a specification, to AS627.4 to ISO 8501-1 appearance Class Sa 2 ½, "Near White Metal" minimum blast cleanliness. Then prime as per the specification. The primer must be applied and cured as per the specific Dulux® Protective Coatings' latest technical data sheet.

For Concrete: If the concrete substrate is exposed, the surface should be prepared to the original specification, or in the absence of a specification, to SSPC SP13/NACE 6 "Severe Service" and a concrete surface profile of ICRI CSP 5. Fill voids in the concrete with an appropriate Fosroc® filler and/or resurfacer. Then prime with an appropriately specified primer. The primer must be applied and cured as per the specific Dulux® Protective Coatings' latest technical data sheet.

- If a prime coat is exposed, but determined to be intact and allowed to remain, it will need to be thoroughly and uniformly scarified to receive the subsequent coat of Dureline™ SE 10.
- Thoroughly and uniformly scarify and feather the edges of the existing, and sound Dureline™ SE 10 coating approximately 100-125mm or 4-6 inches out and around the area to be repaired.
    - o If amine blush or bloom is detected on the applied Dureline™ SE 10 coating surface, fully remove the blush or bloom using clean rags and a cleaning solution mix of 70% isopropyl alcohol and 30% deionized water. Changing out dirty rags to clean rags to ensure the blush or bloom is removed and not spread around the surface.
    - o After abrasion is complete, wipe the prepared area to be coated with MEK to remove debris and contaminants and allow the surface to dry.
- To the properly prepared, clean, dry, and contaminant-free surface apply Dureline™ SE 10 at the specified thickness, ensuring the application remains confined to the area(s) that have been sacrificed and prepared.

5.3 Process of Recoating over Dureline™ SE 10 "Drops" Past its Maximum Recoat Window

If the maximum recoat window has been exceeded, follow the process outlined below:

- Thoroughly and uniformly scarify and feather the edges of the existing, and sound Dureline™ SE 10 coating approximately 100-125mm or 4-6 inches out and around the area to be repaired.
    - o If amine blush or bloom is detected on the applied Dureline™ SE 10 coating surface, fully remove the blush or bloom using clean rags and a cleaning solution mix of 70% isopropyl alcohol and 30% deionized water. Changing out dirty rags to clean rags to ensure the blush or bloom is removed and not spread around the surface.

- After abrasion is complete, wipe the prepared area to be coated with MEK to remove debris and contaminants and allow the surface to dry.

- To the properly prepared, clean, dry, and contaminant-free surface, apply Dureline™ SE 10 at a minimum DFT of 300µms over the previously coated area, ensuring the application remains confined to the area(s) that have been scarified and prepared. Flowing out from the “drop” connection point, continue to apply Dureline™ SE 10 to the remaining surfaces as specified. Ensure all areas meet the specified minimum requirements.

- Fresh coating shall be feathered in at least 10cm, ensuring the application remains confined to the area(s) that have been scarified and prepared. Avoid application to glossy surfaces. Coating applied to improperly prepared surfaces shall be removed immediately.

6.0 Safety

All necessary measures should be adopted under the requirements of all Health & Safety Acts or other nationally recognised legislation. In particular, lighting, grounding, ventilation, and protective clothing shall be adequate for the safe and proper execution of the work.

Before work commences, refer to the product specific Technical Data Sheet (TDS) and Safety Data Sheet (SDS).

7.0 Product Packaging

Kit Size	Part A	Part B
18L Mixed	1 × 12L in a 20L Pail	1 × 6L in a 10L Pail

8.2 Product Performance Properties

Refer to Technical Data Sheet for product performance and properties

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Dulux® PROTECTIVE COATINGS

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