EPINAMEL® TL770SF

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Description

- A solvent-free, two-pack, amine cured epoxy coating.
- Conforms to AS/NZS 3750.14.
- Approved to AS/NZS 4020:2018.
- Approved to APAS 2974, 2974F, 2974P.

Product Characteristics

- Epoxy coatings are suitable with well-designed cathodic protection system
- Suitable for immersion in fresh and salt water
- Approved for use as a lining in potable water tanks with volumes of 300 litres or greater
- Suitable for the protection of steel structures and storage tanks against corrosion
- Can be applied by single feed 60:1 airless spray equipment
- Solvent free, eliminates risk of explosion or fire
- No thinning required.
- Light colour provides good visibility in tank interiors
- Single coat systems available.
- Suitable for pit filling and use with fibre glass reinforcing.

Colours and Gloss

- Off white, gloss.

Recommended Film Thickness (Per Coat)

	Minimum	Maximum	Typical
Dry film thickness (µm)	150	500	150
Wet film thickness (µm)	150	500	150
Theoretical spreading rate (m^2/l)	6.7	2.0	6.7

Basic Data at 25°C

Solids content approx.	100% by volume
Mix ratio	4A:1B by volume
Touch dry after	6 hours
Full cure	Refer to curing table
Temperature resistance	100°C (dry), 35°C (wet)

Surface Preparation

- 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 50-100 microns
- if oxidation occurs between blasting and application, the surface should be re-blasted to the specified visual standard.
- Epinamel PR250 may be applied at 75 microns dft as a holding primer before oxidation occurs.
- Alternatively, the blast can be maintained using dehumidification in tanks.
- surface defects revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner.

CONCRETE

- Must be free from bond breakers, curing agents or any other contaminants that may interfere with adhesion.
- Should be blast cleaned to remove all laitance; moisture content should be maximum 4%.
- Ensure all new concrete is fully cured prior to coating. Typically this may take a minimum of 4-6 weeks.

PREVIOUS SUITABLE COAT

- Dry and free from any contamination and sufficiently roughened if necessary.
- Substrate temperature must be at least 10°C during application and curing and at least 3°C above dew point.
- For optimal installation conditions, relative humidity levels should be maintained between 40-60%, although some lining applications may be carried out between 25-85% relative humidity.
- The relative humidity should be controlled using dehumidification equipment. Where such equipment is not available, a system using a single coat of Epinamel TL770SF shall be used.
- Exposure to unacceptably low temperatures and/or high humidity during, or immediately after, application may result in incomplete cure and surface contamination that could adversely affect subsequent intercoat adhesion.

Application Instructions

- Mix ratio by volume: 4A:1B.
- Mix Epinamel TL770SF Part A with Epinamel TL770SF Part B only.
- Induction time – none.
- Pot life at 25°C 40 minutes. 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 at least 20°C.
- Mixed product with a temperature below 20°C will be too high in viscosity to spray.
- Product must not be thinned.
- Additional stripe coat to be brush applied to edges, holes, corners and welds before application of the next full coat.
- Freshly catalysed material should not be added to product that has been mixed for some time.
- Wattyl recommends the use of coating inspection reports in compliance with AS/NZS 3894.10,11,12 refer to Information Sheet I-20 for more information.
- For recommendations outside those contained in this data sheet, refer to Wattyl.

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Application Methods

AIRLESS SPRAY

- Use single feed airless spray unit with pump ratio 60:1.
- Use minimum 10 mm (3/8") diameter high pressure fluid hose, max length 15 m.
- Inline heating or insulated hoses may be necessary to avoid cooling down at low temperatures.
- Application with 45:1 pump ratio is possible provided in-line heated high pressure fluid hoses are used and the mixed paint is heated to 30°C to reduce viscosity.

Recommended thinner	Do not thin
Filter	60 mesh
Tip	0.53-0.66mm (0.021-0.026 inch)
Fluid pressure	Min 28 MPa (4000 psi) at paint temperature of 20°C min 22 MPa (3200 psi) at paint temperature of 30°C

AIR SPRAY – Not recommended

BRUSH / ROLLER

For spot repair and stripe coating only.

- Recommended thinner - do not thin
- 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.
- Nylon/polyester or natural bristle brushes recommended.
- Recommended roller cover should be 5-10mm woven with a solvent resistant core.

CLEANING SOLVENT – Thinner L760

- All paint must be removed from the spray equipment immediately after use. Clean thoroughly with the recommended solvent before the pot life expires

Safety Precautions

- 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 safety data sheet (SDS).

Additional Data

Wet/dry film thickness

- Product thixotropy and surface tension will retard the release of entrapped air after application and may result in a deviation between the wet film thickness (wft) measured immediately after application and the dry film thickness (dft) of the cured coating.
- To ensure that the correct specified dft is achieved it is recommended that applied wft is equal to the specified dft plus 60 microns.
- When measuring the dft in the early stages of cure it is recommended that a calibration shim of a known thickness be placed between the film thickness gauge and the surface of the coating to avoid penetration into the soft coating.

OVERCOATING TABLE

Overcoating interval for Epinamel TL770SF when top coating with itself.

Interval	10°C	15°C	25°C	35°C
Min (**not** exposed to sunlight)	4 days	3 days	24 hrs	16 hrs
Max (exposed to sunlight)	20 days	20 days	10 days	5 days

- Coating may darken on exposure to direct sunlight.
- Surface must be dry and free from chalking and contamination prior to overcoating. If overcoating interval is exceeded, the surface must be dry and free from chalking and contamination and sufficiently roughened.

CURING AND POTLIFE TABLE

Minimum curing time of Epinamel TL770SF coating system before exposure to:

Paint temperature	10°C	15°C	25°C	35°C
Potable Water	20 days	16 days	10 days	6 days
Other recommended products	10 days	8 days	5 days	3 days

*adequate ventilation must be continuously maintained during application and curing.

POTLIFE TABLE

Paint temperature	20°C	25°C	30°C
Potlife – at application viscosity	50 mins	40 mins	30 mins

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, by filling tank with potable water, allow

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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.

Precautions

- For recommendations outside those contained in this data sheet, refer to Wattyl.
- Epoxy coatings characteristically chalk or discolour on exterior exposure - this does not detract from their protective performance.

Product Compatibility

PRIMERS

- Epinamel PR250

TOPCOATS

- Epinamel TL770SF

Storage and Packaging

- Shelf life at least 24 months.
- All components shall be stored in a dry internal environment at between 5°C and 35°C.
- Packaging: 20 litre kit (16 litre Part A, 4 litre Part B)
- Product line: 2028.

For the most up to date information, please visit our website at www.wattylpc.com.au, or contact us at Australia 132 101 (Australia) 0800 825 7727 (New Zealand).