

DESCRIPTION

- a high solids polyamine adduct-cured chemical resistant epoxy tank lining
- conforms to AS/NZS 3750.14
- approved to AS/NZS 4020:2005
- approved to APAS- 2973, 2973F, 2973P

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 Wattyl 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

RECOMMENDED FILM THICKNESS

	Minimum	Maximum	Typical
Dry film thickness microns	150	250	150
Wet film thickness microns	195	325	195
Theoretical spreading rate m ² /l	5.1	3.1	5.1

BASIC DATA AT 25 °C

- solids content approx.....77% by volume
- mix ratio3A:1B by volume
- touch dry after3 hours
- full curerefer to curing table for details
- abrasion resistance.....81mg
(AS1580.403.2-2006, CS17 wheel, 1000g, 1000 cycles)
- temperature resistance95 °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 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

APPLICATION INSTRUCTIONS

- mix ratio by volume: 3A:1B
- mix Epinamel TL710 Part A 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
- Valspar 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 Valspar

APPLICATION METHODS

- **AIRLESS SPRAY**
 - recommended thinner Thinner L760
 - volume of thinner 0-10%
 - nozzle orifice approx. 0.53 mm
(0.021 inch)
 - nozzle pressure 15 MPa (2100 psi)

- **AIR SPRAY**
 - recommended thinner Thinner L760
 - volume of thinner 0-15%
 - nozzle orifice 1.8-2.0mm
 - nozzle pressure 0.3-0.4 MPa (50-60 psi)

- **BRUSH/ROLLER**
For spot repair and stripe coating only
 - recommended thinner Thinner L760
 - volume of thinner 0-5%
 - 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**..... Thinner L760

- If spraying for extended periods or if stopping work it is recommended to intermittently flush out spray lines.

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

Overcoating interval for EpinameL TL710 when top coating with itself

Interval	5 °C	15 °C	25 °C	35 °C
Min	32 hrs	16 hrs	8 hrs	4 hrs
Max*	3 days	2 days	2 days	1 day

- *Maximum overcoating interval is double the time stated above for coatings not exposed to direct sunlight
- 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 Table

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

Paint temperature	5 °C	15 °C	25 °C	35 °C
Potable Water	N/R	15 days	9 days	6 days
Other recommended products *	18 days	10 days	7 days	5 days

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

- adequate ventilation must be continuously maintained during application and curing

Potlife Table

Paint temperature	5 °C	15 °C	25 °C	35 °C
Potlife (at application viscosity)	N/R	2 hrs	1 hr	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. 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.

PRECAUTIONS

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

PRODUCT COMPATIBILITY

Primers

- Epinamel CP502
- Epinamel PR250

Topcoats

- Epinamel TL710

STORAGE AND PACKAGING

- shelf life at least 12 months
- all components shall be stored in a dry internal environment at between 5 °C and 35 °C
- packaging 20 Litre kit (15 Litre Part A, 5 Litre Part B)
- product line: 2028



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ISO 9001

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CUSTOMER SERVICE HOTLINE
WEBSITE

Australia
132 101
www.wattylpc.com

New Zealand
0800 735 551
www.wattylpc.com

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