

DESCRIPTION

- a solvent free two pack amine cured novolac phenolic epoxy coating
- conforms to AS/NZS 3750.14

PRINCIPAL CHARACTERISTICS

- suitable for the protection of steel structures and storage tanks against corrosion
- excellent resistance to a wide range of chemicals (refer to I-19 Wattyl Tank Lining Resistance Guide for a full list of suitable cargoes)
- suitable as a tank lining for cargoes including crude oil, leaded and unleaded petrol and diesel
- suitable for immersion in fresh and salt water
- 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 use under insulation up to 150 °C
- suitable for pit filling and use with fibre glass reinforcing

COLOURS AND GLOSS

- off white, gloss

RECOMMENDED FILM THICKNESS

	Minimum	Maximum	Typical
Dry film thickness microns	300	600	400
Wet film thickness microns	300	600	400
Theoretical spreading rate m ² /l	3.3	1.7	2.5

BASIC DATA AT 25 °C

- solids content approx.....100% by volume
- mix ratio4A:1B by volume
- touch dry after6 hours
- full curerefer to curing table for details
- temperature resistance150 °C (dry), 60 °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 reblasted to the specified visual standard
- alternatively, the blast can be maintained using dehumidification in tanks
- for selected cargoes, EpinameL PR250 may be applied at 75 microns dft as a holding primer before oxidation occurs - refer to Valspar for more details

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
- relative humidity should not exceed 85%
- conditions within the confines of the application environment e.g. tank etc, must be controlled to maintain a maximum relative humidity of 50% at temperatures between 10 - 15 °C, and a relative humidity of maximum 60% at temperatures above 15 °C during application and the first two days of cure
- the relative humidity should be controlled using dehumidification equipment. Where such equipment is not available, a system using a single coat of EpinameL TL725SF 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 TL725SF Part A with EpinameL TL725SF Part B only
- induction time – none
- pot life at 25 °C 50 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
- 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**

- use single feed airless spray unit with pump ratio 60:1 or 68:1
- 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**
- nozzle orifice approx. 0.53-0.66mm (0.021-0.026 inch)
- nozzle 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

• **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 Material Safety Data Sheet (MSDS)

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 TL725SF when top coating with itself

Interval	10 °C	15 °C	25 °C	35 °C
Min	36 hrs	30 hrs	20 hrs	16 hrs
Max- NOT exposed to direct sunlight	3 mths	2 mths	1 month	1 month
Max- exposed to direct sunlight	7 days	7 days	2 days	1 day

- 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 TL725SF coating system before exposure to:

Substrate temperature	10 °C	15 °C	25 °C	35 °C
Recommended products	7 days	6 days	5 days	3 days
Potlife (at application viscosity)			50 mins	40 mins

- adequate ventilation must be continuously maintained during application and curing

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 PR250 (selected systems only)

Topcoats

- Epinamel TL725SF

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 20litre kit (16 litre Part A, 4 litre Part B)
- product line:



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ISO 9001

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For the most up to date information contact Valspar Customer Service Hotline or visit the Wattyl Website.

**CUSTOMER SERVICE HOTLINE
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