

DUREBILD[®] TLE

High Build Two Pack Epoxy

PC 221

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

USES DUREBILD[®]TLE is recommended for the protection of steel structures in harsh chemical atmospheres and in aggressive on and off shore environments. It is suitable for immersion in fresh, salt and hot (up to 100°C) water.

SPECIFICATIONS Approved to APAS 2972F.
The use of film forming components of DUREBILD[®] TLE when applied as directed is authorised by Section 175.300 of the U.S. Code of Federal Regulation (Food & Drugs) as the food contact surface of articles intended for use in producing, manufacturing, packing, processing, preparing, treating, packaging, transporting or holding food, subject to the limitation and conditions of use prescribed in that Section.

RESISTANCE GUIDE

HEAT RESISTANCE	Up to 130°C dry heat. 100°C Wet	ALKALIS	Excellent resistance to most common alkalis.
WEATHERABILITY	Some chalking and yellowing will occur with exterior exposure if not topcoated. This will not detract from the resistance properties of the coating.	SALTS	Excellent resistance to splash and spillage of most salt solutions.
SOLVENTS	Excellent lining for aliphatic and aromatic hydrocarbons and refined petroleum products. Resists splash and spillage of most solvents.	WATER	Recommended as a lining for fresh, salt and deionised water. Suitable for hot water to 100°C.
ACIDS	Good resistance to most acids.	ABRASION	Good when fully cured.

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Amine adduct cured epoxy	APPLICATION CONDITIONS	Min	Max	
FINISH	Low Sheen	Air Temperature	5°C	45°C	
COLOUR	White and WT Grey (approximate match to AS2700 N33 Lightbox Grey)	Substrate Surface Temperature	5°C	45°C	
COMPONENTS	Two	Relative Humidity		85%	
SOLIDS BY VOLUME	52% (White)		Min	Max	Recom.
FLASH POINT	4°C	Wet film per coat (microns)	195	385	240
POT LIFE	8 Hours (4L, 25°C)	Dry film per coat (microns)	100	200	125
MIXING RATIO (V/V)	Part A : 4 Part B : 1	SUITABLE SUBSTRATES	Abrasive blast cleaned steel.		
THINNER	920-08925 Dulux [®] Epoxy Thinner	APPLICATION METHODS	Conventional, airless spray or air assisted spray.		
PRODUCT CODE	781-84396 White 781-84536 WT Grey 976-84397 Hardener				

Drying characteristics at 125 microns dry film thickness

Temperature	Humidity	Touch	Handle	Full Cure	Overcoat	
					Min	Max*
5° C	50%	8 Hours	24 Hours	7 Days	24 Hours	2 Weeks
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 Hours	10 Hours	7 Days	10 Hours	2 Weeks

These figures are given as a guide only, as ventilation, film thickness, humidity, thinning and other factors will influence the rate of drying.

If the maximum overcoat interval is exceeded then the surface MUST be abraded to ensure maximum intercoat adhesion.

* When used for non-immersion conditions. Refer to PRECAUTIONS section for overcoating intervals and requirements fro immersion service.

TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD

A spreading rate of 4.2 sq. metres per litre corresponds to 125 microns dry film thickness assuming no losses. Practical spreading rates will vary depending on such factors as method and conditions of application and surface roughness.

DUREBILD® TLE

TYPICAL SYSTEMS (For specific requirements contact a Dulux® Protective Coatings Consultant)

SURFACE	PREPARATION GUIDE	SYSTEM		DRY FILM THICKNESS
STEEL	Abrasive blast AS1627.4 Class 2.5	1st Coat	DUREPON® P14	75 Microns
		2nd Coat	DUREBILD® TLE	125 Microns
		3rd Coat	DUREBILD® TLE	125 Microns
STEEL Hot Water Immersion	Abrasive blast to AS1627.4 Class 3.0	1st Coat	DUREBILD® TLE	125 Microns
		2nd Coat	DUREBILD® TLE	125 Microns

SURFACE PREPARATION Round off all rough welds, sharp edges and remove weld spatter. Remove grease, oil and other contaminants in accordance with AS1627.1. Rust millscale, oxide deposits and old paint films on metal surfaces must be removed by abrasive blast cleaning to a minimum AS1627.4 Class 2.5 with a blast profile of 40-70 microns. Immersed steel must be prepared to AS1627.4 Class 3. Remove all dust by brushing or vacuum cleaning.

APPLICATION Stir contents of each can thoroughly with a broad flat stirrer using a stirring, lifting action or use a power mixer. Mix the contents of both packs together thoroughly using a power mixer and allow to stand for 10 minutes. Remix thoroughly before using.

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 atomisation.
Typical Set-up
 Graco Delta Gun: 1.8mm (239543)
 Pressure at Pot: 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 45:1 or 56:1 Xtreme with a fluid tip of 19–21 thou (0.48-0.53mm) and a tip pressure of 13.8-20.6 MPa (2,000-3,000 psi). Thinning is not normally required but up to 50 ml/litre of Dulux® Epoxy Thinner (920-08925) may be added to ease 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® representative for advice prior to painting. Do not apply in conditions outside the parameters stated in this document without the express 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 the 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. For best results in water immersion conditions replace Dulux® Epoxy Thinner (920-08925) with Dulux® CR Reducer (965-63020).

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

OVERCOATING Aged coating should be tested for lifting by a method appropriate to the coating thickness, for example 'X' cut or cross-hatch methods. If it lifts, remove it. The surface must be free of oil, grease and other contaminants. High-pressure water wash at 8.3 to 10.3 MPa (1,200 - 1,500 p.s.i.) to remove loosely adhering chalk and dust. Abrasion may be required depending on surface. If the maximum overcoat interval is exceeded then the surface MUST be abraded to ensure maximum intercoat adhesion.

SAFETY PRECAUTIONS Read Data Sheet, Material Safety Data Sheet and any precautionary labels on containers.

STORAGE Store as required for a flammable liquid Class 3 in a banded 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 spray painting, users should comply with the provisions of the 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.

A MATERIAL SAFETY DATA SHEET IS AVAILABLE FROM CUSTOMER SERVICE PH. 13 2377

Dulux Australia Pty Ltd
 McNaughton Road, Clayton 3168
 A.B.N. 99 004 117 828

The word Orica, the ring device, the Orica mark, Dulux, DUREBILD and DUREPON are registered trademarks of Orica Group Companies.

PACKAGING	Available in 4 and 20 litre packs
TRANSPORTATION WEIGHT	1.49 kg/litre (Average of components)
DANGEROUS GOODS	Part A: Class 3 UN 1263 Part B: Class 3 UN 1866

Any advice, recommendation, information, assistance or service provided by ORICA Australia (Orica) in relation to goods manufactured by it or their use and application is given in good faith and is believed by Orica to be appropriate and reliable. However, any advice, recommendation, information, assistance or service provided by Orica is provided without liability or responsibility PROVIDED THAT the foregoing shall not exclude, limit, restrict or modify the right entitlements and remedies conferred upon any person or the liabilities imposed upon Orica by any condition or warranty implied by Commonwealth, State or Territory Act or ordinance void or prohibiting such exclusion limitation or modification. Products can be expected to perform as indicated in this sheet so long as applications and application procedures are as recommended.