

## DULUX

### HI BUILD EPOXY TANK COATING

#### A580-LINE (HIGH PERFORMANCE-SOLVENTBORNE)

#### PRODUCT INFORMATION

PRODUCT NAME	<b>Dulux</b> Hi Build Epoxy Tank Coating.
PRODUCT CODE	Base: A580-Line. Activator : A275-81
DESCRIPTION	<b>Dulux</b> Hi Build Epoxy Tank Coating is a two pack high build epoxy gloss finish.
USAGE	Formulated for Airless Spray application to interior blast cleaned steel tank.
BENEFITS	Excellent resistance to chemicals, solvent, and water. Exceptional build and sag resistance.
PACK SIZE	5 litres units comprising Base: 4.6 litres and Activator: 0.4litre.
COLOUR RANGE	Refer to HPC Colour Card.

#### PERFORMANCE GUIDE





FILM PROPERTIES	
Chemical Resistance	Resistance against splashes and spillage of common acids, alkalis, solvents, and salt solutions.
Heat Resistance	Can be used on heated surfaces up to 110°C.
Water Resistance	Excellent.
THEORETICAL COVERAGE	A guide to the theoretical coverage which can be achieved under normal conditions is 3.6-7.2m <sup>2</sup> /L.

#### PRODUCT DATA




COMPOSITION (nominal)	Pigment : Zinc Phosphate, Non-Lead Pigments and Inert Mineral Extenders. Blinder : Amine Adduct Cured Epoxy. Solvent : Ketone, Toluene and Alcohol.
VOLUME SOLIDS	54% (nominal).
FLASH POINT	Base and Activator - 22°C.
POT LIFE	Up to 6 hours at 30°C.

#### APPLICATION

MIXING RATIO	11.5 parts Base to 1 part Activator by volume.
THINNING	Add up to 1 part of <b>Dulux</b> Thinner 850-761 or 850-11 to 20 parts of paint (5%)
SPRAY RECOMMENDATIONS Airless Spray	A typical set up for airless spray application is a minimum working pressure on paint of 140kg/cm <sup>2</sup> (2000 lb/sq in) with a spray tip size 0.38-0.53mm (15-21 thou) and a spray tip angle of 20°-45°.
SPRAY NOTES	It is important that the Base and the Activator are at the minimum temperature of 15°C when mixed for satisfactory spray application.
CURING TIMES Recoat At 30°C Full Cure	Single coat at standard thickness: 6 hours minimum. 7 days. Please note that the reaction of epoxies commences immediately after the two components are mixed. This reaction is temperature related and so the curing time will be approximately halved by a 10°C increase in temperature and doubled by a 10°C decrease in temperature.
CLEANING UP	Clean all equipment with <b>Dulux</b> Thinner 850-761 or 850-11 immediately after use.
FILM THICKNESS	Wet: 140-280 micro-metres






















	Dry: 75-150 micro-metres.
	   
	<p>Application method      20°- 45° spraying tip      6 hours recoat time      Practise proper cleaning</p>

### PRE - APPLICATION

SURFACE PREPARATION	For optimum performance, blast clean to BS 7079 Part A1: 1989 Sa 2.5 to give an appropriate surface profile.
SYSTEM INFORMATION Metal	<p><b>PRIMER (1 COAT)</b> <b>Dulux</b> Epoxy Zinc Phosphate Primer (A580-16252)</p> <p><b>FINISH (2 COATS)</b> <b>Dulux</b> Hi Build Epoxy Tank Coating (A580)</p>
	<p>It is important to ensure that the substrate temperature is at least 3°C above dew point. The minimum temperature for application is 10°C. Relative humidity should not exceed 85%.</p> <p><b>Note:</b> Where primer has been left exposed over a period of time, it will be necessary to thoroughly prepare the surface by removing all dirt, grease, oil, wax, rust, salts etc before the overpainting. Where rusting of peaks has occurred on blast cleaned steel, flash blasting or thorough manual preparation followed by spot priming with an appropriate primer will be required.</p>
	  
	<p>Blast cleaning      Ensure good surface profile      Seal a coat with primer</p>

### PRECAUTION

SAFETY, HEALTHY AND ENVIRONMENTAL INFORMATION	<p><b>HIGHLY FLAMMABLE</b> Harmful by inhalation and in contact with skin. In case of contact with eyes, rinse immediately with plenty of water and seek medical advice. If swallowed seek medical advice immediately and show this container or label. Keep away from food, drinks, animal feed and out of the reach of children. Keep away from combustible material. Container must be stored in a cool and shaded place. It must be tightly closed in a secure, upright position. Take precautionary measures against static discharges. Do not breathe dust. Work in a well-ventilated area and do not breathe in vapour or spray. When applying paint, wear suitable protective clothing, gloves and eye/ face protection.</p>
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	<p>In case of fire use foam, dry powder, AFFF, CO2 – Never use water.          In case of a spillage, contain and collect spillage using sand or earth and do not empty into watercourses, drains or the environment.          Dispose of any paint waste in accordance with the appropriate Environmental Quality Regulations.          Refer to <b>Dulux</b> Product Safety Data Sheet for further details.          In case of emergency, refer to Emergency Incident Response Hotline 1800 80 6187.</p>							
	<table border="0"> <tr> <td data-bbox="619 562 730 712">             FLAMMABLE         </td> <td data-bbox="802 562 914 712">             Keep seal tight         </td> <td data-bbox="978 562 1090 712">             Store in cool place         </td> </tr> <tr> <td data-bbox="619 757 730 907">             Secure upright         </td> <td data-bbox="802 757 914 907">             Wear proper protection         </td> <td data-bbox="978 757 1090 907">             Ensure good ventilation         </td> <td data-bbox="1153 757 1265 929">             Practise proper disposal         </td> </tr> </table>	 FLAMMABLE	 Keep seal tight	 Store in cool place	 Secure upright	 Wear proper protection	 Ensure good ventilation	 Practise proper disposal
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