

TL-45-S High-Build Novolac Epoxy Coating and Lining System

DESCRIPTIONS AND USES

Blome International's Novolac Epoxy tank lining systems are formulated to offer superior resistance to some of the most aggressive chemicals found in the process industries. Blome TL-45-S exhibits excellent resistance to a broad range of harsh chemicals, including high concentrations of sulfuric acid, hydrochloric acid, phosphoric acid, strong caustic solutions, as well as many organic chemicals and solvents.

TL-45-S is a high performance Novolac epoxy tank lining/coating system for immersion service. Typically spray applied, its high build properties allow thicknesses of up to 80 mils to be achieved on vertical surfaces.

TL-45-S is a two component product with a 4:1 volumetric mix ratio. TL-45-S possesses the following properties:

- Excellent chemical resistance;
- Thermal shock, impact and wear resistance;
- 100% solids;
- Long Pot Life for airless spray application;
- Excellent bond strength;
- Resistance to chipping and cracking due to torsional twisting;
- Superior edge coat properties;
- High cohesive strength;
- Low permeability;
- Low odor

Typical uses include:

- Tank Linings, External Tank Coatings, Coating
- Structural Steel in harsh chemical vapor environments.

PACKAGING/COVERAGE

TL-45-S is available in 1-gallon, 5-gallon, and 25-gallon units. Each unit consists of premeasured Part A and Part B components.

Application thickness will vary depending on expected service conditions. Consult Blome International's Tank Lining Systems Guide or contact our technical service group for specific lining recommendations.

Coverage rates will be affected by the condition of surface being coated (degraded vs. smooth, steel vs. concrete, etc.). To calculate theoretical coverage per gallon, divide desired mil thickness into 1,604. (For example, theoretical coverage for a 30 mil thickness is: 1,604 divided by 30 = 53.46 square feet per gallon.) For practical coverage, make necessary allowances for condition of the substrate, temperatures, jobsite conditions, waste, overspray, etc.

TYPICAL PROPERTIES -WET

Solids by Volume:	100%
Weight per Mixed Gallon:	10 lbs
Pot Life @ 75°F:	40 to 45 min*
Cure Times @ 75°F:	Dry to Touch: 16 hrs
Firm:	24 hrs
Chemical Service:	72 hrs
Primer:	Not required on properly prepared steel
Flammability:	Nonflammable

*Significantly less at elevated temperatures

TYPICAL PROPERTIES -CURED

Color:	Medium Grey or Red
Hardness- ASTM D-2240 Shore D:	74
Compressive Strength -ASTM C-579:	15,000 psi
Tensile Strength -ASTM D-638:	7,900 psi
Flexural Strength -ASTM D-790:	13,500 psi
Flexural Modulus of Elasticity -ASTM D-790:	7.7 psi x 10 ⁵
Bond Strength -ASTM D-4541:	Concrete:concrete failure Steel: 1 ,500 psi
Water Vapor Transmission -ASTM E-96:	0.0120 grain per hr ft ²
Permeability:	0.0036 perm. - in.

STORAGE AND SHELF LIFE

Keep TL-45-S components tightly sealed in their original containers until ready for use. Store at 50°F to 75°F out of direct sunlight.

APPLICATION GUIDELINES

For applications on vertical surfaces, use TL-45-S within four months of its date of manufacture. Otherwise, Blome TL-45-S has a shelf life of one year, when properly stored.

TEMPERATURE CONSIDERATIONS

The temperature of the surface to be coated, and the ambient air temperature should be at least 55°F while applying TL-45-S and while it cures. If you attempt to apply TL-45-S in cooler temperatures, tarp and heat the area to be coated to maintain the minimum 55°F conditions.

Stop application if the temperature falls within 5°F of the dew point.

Outgassing bubbles may appear in TL-45-S if it is applied over concrete, particularly in direct sunlight, or when air and substrate temperatures are rising. This is due to the expansion of air and/or moisture trapped in the concrete. It is especially true of air entrained concrete. For best results, shade the work area and apply TL-45-S when the temperature of the concrete substrate is falling. A surface thermometer must be used to frequently monitor substrate temperature.

Twenty-four hours before application, all materials (components A and B) should be stored at a 75°F to 85°F, to facilitate handling and spraying.

**SURFACE PREPARATION
-GENERAL**

Surfaces must be dry and free of dust, dirt, grease, oil, chemicals and contaminants immediately prior to applying each coat of either primer or TL-45-S.

**SURFACE PREPARATION
OF STEEL**

1. Abrasive blast steel surfaces to white metal finish with a 2 to 3 mil anchor profile. (Ref. SSPC-SP-5)
2. All welds should be continuous and should be ground to remove all sharp edges, laps, under cuts and other surface irregularities. Relatively smooth, ripple finished welds are acceptable. Stripecoat all welds just prior to applying coating.
3. Steel in Non -Immersion Service
Abrasive blast steel surfaces to a near white metal finish with 1 to 2 mil anchor profile. (Ref. SSPC-SP-10)

MASKING

Mask surfaces that are not to be coated. TL-45-S is difficult to remove, once cured.

PRIMING

Steel -priming not required.

**APPLICATION
EQUIPMENT**

TL-45-S may be applied using a spray rig, brush or notched trowel. Use Graco 45:1 King airless spray rig or Graco Hydro-Cat fixed at a 4:1 volumetric ratio.

CARE OF SPRAY RIG HOSES

Take care to prevent the mixed material from setting up in your hoses. For best results, keep hoses as short as possible, purge hoses immediately if work is interrupted. Keep hoses out of direct sunlight and insulated or away from hot surfaces.

MIXING AND APPLICATION

TL-45-S may be thinned for certain applications. Use up to 5% by weight of MEK. Refer to specifications for your project, or consult Blome International for alternate thinner recommendations. The mix ratio of Part A to Part B is 4:1 A to B by volume.

1. The components must be individually mixed immediately prior to use:
Part A: Blend Part A component to a uniform consistency in its individual container, using a Jiffy type mixer.
Part B: Blend Part B component to a uniform consistency in its individual container.
2. If you are using plural component equipment, skip this step. Otherwise:
Pour the entire contents of Part B into the container holding Part A and mix thoroughly for two minutes using a Jiffy type mixer. The temperature of the mixed material should be 75°F to 85°F for hot potting. The pot life of the mixture will be approximately 40 to 45 minutes at 75°F; significantly less time at elevated temperatures. The longer the material is in the bucket after mixing, the shorter its pot life will be. Therefore, use immediately once mixed.
3. Material should be applied in even coats.
If spraying, use multidirectional passes to ensure positive coverage and proper film build

TL-45-S Page 3 of 4

4. Horizontal Surfaces

The entire thickness may be applied to horizontals in a single coat.

5. Vertical Surfaces
Minimum of 15 mils up to 80 mils may be applied to vertical surfaces.
6. Spark Testing Steel
Spark testing is recommended for coated steel in immersion service.
Test at 100 volts per mil.
7. Prepare surfaces for inter-coat adhesion as follows:
 - a. Allow TL-45-S to cure until firm before applying subsequent coats.
 - b. After the surface cures firm to the touch, but less than 24 hours, it must be washed with soap and water, rinsed and dried before re-coating.
 - c. Surfaces cured beyond 24 hours must be washed with soap and water, rinsed, dried and lightly sanded or abrasive blasted.
8. If work is interrupted, or at the end of the day, terminate the coating in a straight line.
9. As it cures, TL-45-S will sometimes develop a thin, oily film on its surface. This film may be easily removed by washing with soap and water.

CLEANUP

Before material gels, tools and equipment should be cleaned using hot, soapy water. After TL-45-S begins to cure, thinners will be required. Chlorinated solvents may be used if flammable solvents are prohibited.

SAFETY PRECAUTIONS FOR INDUSTRIAL USE ONLY

Avoid contact with skin and eyes; do not ingest material or inhale vapors. When working with TL-45-S, always wear chemical goggles, appropriate rubber gloves, and other appropriate safety clothing. When spraying in confined areas, wear a fresh air hood and make provisions for forced air ventilation. When spraying in open areas, a NIOSH approved respirator suitable for organic vapors can replace fresh air hood. Prolonged or repeated exposure to the Part A and Part B components of TL-45-S may cause skin irritation and/or allergic reactions. Refer to Blome Material Safety Data Sheets for individual components.

WARRANTY

We warrant that our goods will conform to the description contained in the order and that we have good title to all goods sold. Our material data sheets and other literature are to be considered accurate and reliable, but are used as guides only. WE GIVE NO WARRANTY OR GUARANTEE, WHETHER OF MERCHANT ABILITY OR FITNESS OF PURPOSE OR OTHERWISE, AND WE ASSUME NO LIABILITY IN CONNECTION THEREWITH. We are happy to give suggestions for applications; however, the user assumes all risks and liabilities in connection there with regardless of any suggestion, we may give. We assume no liability for consequential or incidental damages. Our liability, in law and equity, shall be expressly limited to the replacement of non-conforming goods at our factory, or at our sole option, to repayment of the purchase price of the non-conforming goods.

Printed: July 15, 2012
Supersedes all previous literature