



POTA-POX® PLUS SERIES L140

PRODUCT PROFILE

GENERIC DESCRIPTION	Polyamidoamine Epoxy
COMMON USAGE	Versatile epoxy coating for protection and finishing of steel. It has excellent resistance to abrasion and is suitable for immersion service. This product can be used for lining storage tanks that contain demineralized, deionized or distilled water.
COLORS	1211 Red, 1255 Beige, 00WH Tnemec White, 15BL Tank White. Note: Epoxies chalk with extended exposure to sunlight. Lack of ventilation, incomplete mixing, miscatalyzation or the use of heaters that emit carbon dioxide and carbon monoxide during application and initial stages of curing may cause yellowing to occur.
SPECIAL QUALIFICATIONS	Certified by NSF International in accordance with NSF/ANSI Std. 61 . Series L140 (with or without 44-700 Epoxy Accelerator) is qualified for use on tanks of 50,000 gallons (189,270.6L) capacity or greater and fittings one (1) inch (2.5 cm) in diameter or greater. Reference Tnemec's certified product listing at www.nsf.org for details on maximum allowable DFT.

COATING SYSTEM

SURFACER/FILLER/PATCHER	Series 215, 217, 218
PRIMERS	Self-priming or Series 1, 91-H ₂ O, 94-H ₂ O, N140, N140F, L140F, V140, V140F, 141
TOPCOATS	Interior: Series 22, FC22, L140, L140F, N140, N140F, V140, V140F, 141 Exterior: Series 27, 27WB, 30, 66, L69, L69F, N69, N69F, V69, V69F, 72, 73, 118, L140, L140F, N140, N140F, V140, V140F, 156, 157, 161, 180, 181, 446, 700, V700, 701, V701, 740, 750, 1026, 1028, 1029, 1074, 1074U, 1075, 1075U, 1078, 1078V, 1080, 1081, 1094, 1095, 1096, 1224. Note: When topcoating with Series 700, V700, 701 or V701, an intermediate coat of Series 73, 1075, 1075U, 1095 or 1096 is required. Note: The following recoat times apply for Series L140: Immersion Service—Surface must be scarified after 60 days. Atmospheric Service—After 60 days, scarification or an epoxy tie-coat is required. When topcoating with Series 740 or 750, recoat time for L140 is 21 days. Contact your Tnemec representative for specific recommendations.

SURFACE PREPARATION

STEEL	Immersion Service: SSPC-SP10/NACE 2 Near-White Blast Cleaning or ISO Sa 2 1/2 Very Thorough Blast Cleaning with a minimum angular anchor profile of 1.5 mils. Non-Immersion Service: SSPC-SP6/NACE 3 Commercial Blast Cleaning or ISO Sa 2 Thorough Blast Cleaning with a minimum angular anchor profile of 1.5 mils. Note: Commercial Blast Cleaning generally produces the best coating performance for this exposure. If conditions will not permit this, in moderate exposures Series L140 may be applied to SSPC-SP2 or SP3 Hand or Power Tool Cleaned surfaces (SSPC Rust Grade Condition C).
CAST/DUCTILE IRON	All external surfaces of ductile iron pipe and fittings shall be delivered to the application facility without asphalt or any other protective lining on the exterior surface. All oils, small deposits of asphalt paint, grease, and soluble deposits should be removed and uniformly abrasive blasted using angular abrasive in accordance with NAPF 500-03-04: External Pipe Surface condition. When viewed without magnification, the exterior surfaces shall be free of all visible dirt, dust, loose annealing oxide, rust, mold coating and other foreign matter. Any area where rust reappears before application shall be reblasted. The surface shall contain a minimum angular anchor profile of 1.5 mils (38.1 microns) (Reference NACE RP0287 or ASTM D 4417, Method C).
CONCRETE	Allow new cast-in-place concrete to cure a minimum of 28 days at 75°F (24°C). Verify concrete dryness in accordance with ASTM F 1869 "Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete Subfloor Using Anhydrous Calcium Chloride" (moisture vapor transmission should not exceed three pounds per 1,000 square feet in a 24 hour period), F 2170 "Standard Test Method for Determining Relative Humidity in Concrete using in situ Probes" (relative humidity should not exceed 80%), or D 4263 "Standard Test Method for Indicating Moisture in Concrete by the Plastic Sheet Method" (no moisture present). Prepare concrete surfaces in accordance with NACE No. 6/SSPC-SP13 Joint Surface Preparation Standards and ICRI Technical Guidelines. Abrasive blast, shot-blast, water jet or mechanically abrade concrete surfaces to remove laitance, curing compounds, hardeners, sealers and other contaminants and to provide an ICRI-CSP 2-3 surface profile. Large cracks, voids and other surface imperfections should be filled with a recommended filler or surfacer.
PAINTED SURFACES	Non-Immersion Service: Ask your Tnemec representative for specific recommendations.
PRIMED SURFACES	Immersion Service: Scarify the Series L140 prime coat surface by abrasive-blasting with a fine abrasive before topcoating if the Series L140 prime coat has been in exterior exposure for 60 days or longer and Series 66, L69, L69F, N69, N69F, V69, V69F, L140, L140F, N140, N140F, V140, V140F or 161 is the specified topcoat.
ALL SURFACES	Must be clean, dry and free of oil, grease and other contaminants.

TECHNICAL DATA

VOLUME SOLIDS	65.0 ± 2.0% (mixed) †
RECOMMENDED DFT	2.0 to 10.0 mils (50 to 255 microns) per coat. Note: Dry film thickness that exceeds published recommendations but is in compliance with SSPC PA-2 and ANSI/NSF Std. 61 certifications, is acceptable. Note: Number of coats and thickness requirements will vary with substrate, application method and exposure. Contact your Tnemec representative.

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CURING TIME AT 5 MILS DFT

Without 44-700 Accelerator:

Temperature	To Handle	To Recoat	Immersion
90°F (32°C)	5 hours	7 hours	7 days
80°F (27°C)	7 hours	9 hours	7 days
70°F (21°C)	9 hours	12 hours	7 days
60°F (16°C)	16 hours	22 hours	9 to 12 days
50°F (10°C)	24 hours	32 hours	12 to 14 days

Curing time varies with surface temperature, air movement, humidity and film thickness. **Ventilation:** When used in enclosed areas, provide adequate ventilation during application and cure. **Note:** Refer to product listing on www.nsf.org for specific potable water return to service information. **Note:** For faster curing and low temperature applications, add No. 44-700 Epoxy Accelerator, see separate product data sheet for cure information.

VOLATILE ORGANIC COMPOUNDS

Unthinned: 0.81 lbs/gallon (97 grams/litre)
Thinned 5% (No. 49 Thinner): 0.81 lbs/gallon (97 grams/litre) †

HAPS

Unthinned: 0 lbs/gal solids
Thinned 5% (No. 49 Thinner): 0 lbs/gal solids

THEORETICAL COVERAGE

1,043 mil sq ft/gal (25.6 m²/L at 25 microns). See APPLICATION for coverage rates. †

NUMBER OF COMPONENTS

Two: Part A (amine) and Part B (epoxy) — One (Part A) to one (Part B) by volume.

PACKAGING

	Part A	Part B	Yield (mixed)
Large Kit	5 gallon pail	5 gallon pail	10 gallons (37.9 L)
Small Kit	1 gallon can	1 gallon can	2 gallons (7.6 L)

Reference 44-700 Epoxy Accelerator product data sheet for its packaging information.

NET WEIGHT PER GALLON

13.50 ± 0.25 lbs (6.12 ± .11 kg) (mixed) †

STORAGE TEMPERATURE

Minimum 20°F (-7°C) Maximum 110°F (43°C)
 For optimum application properties, material temperature should be above 60°F (16°C) prior to application.

TEMPERATURE RESISTANCE

(Dry) Continuous 250°F (121°C) Intermittent 275°F (135°C)

SHelf LIFE

Part A: 24 months; Part B: 12 months at recommended storage temperature.

FLASH POINT - SETA

Part A: 98°F (37°C) Part B: 95°F (35°C)

HEALTH & SAFETY

Paint products contain chemical ingredients which are considered hazardous. Read container label warning and Material Safety Data Sheet for important health and safety information prior to the use of this product.
Keep out of the reach of children.

APPLICATION

COVERAGE RATES

	Dry MILS (Microns)	Wet MILS (Microns)	Sq Ft/Gal (m ² /Gal)
Suggested	6.0 (150)	9.0 (230)	174 (16.1)
Minimum	2.0 (50)	3.0 (75)	521 (48.4)
Maximum	10.0 (255)	15.0 (375)	104 (9.6)

Note: Roller or brush application requires two or more coats to obtain recommended film thickness. Allow for overspray and surface irregularities. Wet film thickness is rounded to the nearest 0.5 mil or 5 microns. Application of coating below minimum or above maximum recommended dry film thicknesses may adversely affect coating performance. Reference the NSF website at www.nsf.org for details on the maximum allowable DFT. †

MIXING

Start with equal amounts of Series L140 Parts A and B. Power mix contents of each container separately, making sure no pigment remains on the bottom. Pour a measured amount of Part B into a clean container large enough to hold both components. If Series 44-700 is not being used, proceed with mixing and add an equal volume of Part A to Part B while under agitation. Continue agitation until the two components are thoroughly mixed. **Note:** Both components must be above 50°F (10°C) prior to mixing. For optimum mixing and application properties, the material should be above 60°F (16°C).

If using Series 44-700 accelerator, slowly add four (4) fluid ounces of 44-700 per gallon to Series L140 Part A material while under agitation and proceed with adding Part B. **Note:** The use of more than the recommended amount of 44-700 will adversely affect performance.

Thin by volume and thoroughly mix. Failure to thoroughly mix the Part A and Part B components prior to thinning can affect product's gloss and performance. Do not use mixed material beyond pot life limits. **Note:** For application of the unaccelerated version to surfaces between 50°F to 60°F (10°C to 16°C) or the accelerated version to surfaces between 35°F to 50°F (2°C to 10°C), allow mixed material to stand 30 minutes and restir before using.

THINNING

Use No. 49 Thinner. For air spray, thin up to 5% or 1/4 pint (190 mL) per gallon. No thinning necessary for airless spray. For roller or brush application, thin up to 5% or 1/4 pint (190 mL) per gallon. **Caution: Series L140 NSF certification is based on thinning with No. 49 Thinner only. Use of any other thinner voids ANSI/NSF Std 61 certification.** Use of any other thinner voids ANSI/NSF Std. 61 certification.

POT LIFE

Without 44-700: 6 hours at 50°F (10°C) 4 hours at 75°F (24°C) 1 hour at 100°F (38°C)
 With 44-700: 2 hours at 50°F (10°C) 1 hour at 75°F (24°C) 30 minutes at 100°F (38°C)

SPRAY LIFE

Without 44-700: 1 hour at 75°F (24°C)
 With 44-700: 30 minutes at 75°F (24°C)
Note: Spray application after listed times will adversely affect ability to achieve recommended dry film thickness.

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APPLICATION EQUIPMENT

Air Spray

Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomizing Pressure	Pot Pressure
DeVilbiss JGA	E	704	5/16" or 3/8" (7.9 or 9.5 mm)	3/8" or 1/2" (9.5 or 12.7 mm)	50-80 psi (3.4-5.5 bar)	10-20 psi (0.7-1.4 bar)

Low temperatures or longer hoses require higher pot pressure.

Airless Spray

Tip Orifice	Atomizing Pressure	Mat'l Hose ID	Manifold Filter
0.015"-0.019" (380-485 microns)	3500-5100 psi (241-351 bar)	1/4" or 3/8" (6.4 or 9.5 mm)	60 mesh (250 microns)

Use appropriate tip/atomizing pressure for equipment, applicator technique and weather conditions.

Roller: Use a 3/8" or 1/2" (9.5 mm or 12.7 mm) synthetic woven nap roller cover. Use longer nap to obtain penetration on rough or porous surfaces.

Brush: Recommended for small areas only. Use high quality natural or synthetic bristle brushes.

SURFACE TEMPERATURE

Without 44-700: Minimum 50°F (10°C) Maximum 135°F (57°C)

With 44-700: Minimum 35°F (2°C) Maximum 135°F (57°C)

The surface should be dry and at least 5°F (3°C) above the dew point. Coating will not cure below minimum surface temperature.

CLEANUP

Flush and clean all equipment immediately after use with the recommended thinner or MEK.

† Values may vary with color.

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