



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 1255 Beige, 1211 Red, 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 the "Search Listings" section of the NSF website at www.nsf.org for details on the maximum allowable DFT.

PERFORMANCE CRITERIA Extensive test data available. Contact your Tnemec representative for specific test results.

COATING SYSTEM

PRIMERS Self-priming, 1, 91-H₂O, 94-H₂O, N140, N140F, L140F, V140, V140F, 141

TOPCOATS **Interior:** Series 22, FC22, L140, L140F, N140, N140F, V140, V140F, 141
Exterior: Series 27, 66, L69, L69F, N69, N69F, V69, V69F, 72, 73, L140, L140F, N140, N140F, V140, V140F, 156, 157, 161, 175, 180, 181, 446, 740, 750, 1028, 1029, 1074, 1074U, 1075, 1075U, 1080, 1081. Refer to COLORS on applicable topcoat data sheets for additional information. **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

PRIMED STEEL **Immersion Service:** Scarify the Series L140 prime coat surface by abrasive-blasting with fine abrasive before topcoating if it has been exterior exposed for 60 days or longer and L140 is the specified topcoat.

STEEL **Immersion Service:** SSPC-SP10/NACE 2 Near-White Blast Cleaning with a minimum angular anchor profile of 1.5 mils.
Non-Immersion Service: SSPC-SP6/NACE 3 Commercial Blast Cleaning with a minimum angular anchor profile of 1.5 mils.

CAST/DUCTILE IRON Contact Tnemec Technical Services.

CONCRETE Allow new concrete to cure 28 days. For optimum results and/or immersion service, abrasive blast referencing SSPC-SP13/NACE 6, ICRI-CSP 2-4 Surface Preparation of Concrete and Tnemec's Surface Preparation and Application Guide. Fill all holes, pits, voids and cracks with 215 or 218.

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:** Number of coats and thickness requirements will vary with substrate, application method and exposure. Contact your Tnemec representative.

CURING TIME AT 5 MILS DFT Without 44-700 Accelerator:

Temperature	To Handle	To Recoat	Immersion
75°F (24°C)	6 hours	9 hours	7 days

With 44-700 Accelerator:

Temperature	To Handle	To Recoat	Immersion
75°F (24°C)	4 hours	5 hours	7 days
65°F (18°C)	7-8 hours	9-11 hours	8 days
55°F (13°C)	12-14 hours	16-20 hours	9-10 days
45°F (7°C)	18-22 hours	28-32 hours	12-13 days
35°F (2°C)	28-32 hours	46-50 hours	16-18 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.

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

5 gallon (18.9L) pails and 1 gallon (3.79L) cans — Order in multiples of 2.

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)

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HEALTH & SAFETY
FLASH POINT - SETA Part A: 98°F (37°C) Part B: 95°F (35°C)
SHelf LIFE 12 months at recommended storage temperature.
 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 (m²/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 "Search Listings" section of the NSF website at www.nsf.org for details on the maximum allowable DFT. †

MIXING

1. Start with equal amounts of both Parts A & B.
2. Using a power mixer, separately stir Parts A & B.
3. (For accelerated version. If not using 44-700, skip to No. 4.) Add four (4) fluid ounces of 44-700 per gallon of Part A while Part A is under agitation.
4. Add Part A to Part B under agitation, stir until thoroughly mixed.
5. Both components should be above 50°F (10°C) prior to mixing. 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.

Note: The use of more than the recommended amount of 44-700 will adversely affect performance.

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.

POT LIFE

Without 44-700: 4 hours at 75°F (24°C)
 With 44-700: 2 hours at 75°F (24°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.

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)	70-90 psi (4.8-6.2 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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