



WALL-TECH W.B.

Two Component Water-Based Epoxy Finish



Thortex Wall-Tech W.B. is a high performance water-based epoxy coating designed for use on internal wall surfaces including tunnels and is ideal for applications in food and beverage processing establishments where low odor and hygiene conditions are important.

Thortex Wall-Tech W.B. consists of a unique blend of water dispersible epoxy resins combined with hydrophilic amine adducts which have been specifically formulated to offer a tough durable coating with excellent application properties and provide the optimum level of adhesion, abrasion, impact and chemical resistance, together with excellent bacteriological and graffiti resistance.

Before proceeding, please read the following information carefully to ensure that the correct application procedure is fully understood.

SURFACE PREPARATION

Existing Coatings: Provided the coatings are firmly adherent to the substrate, then light abrasion of the surface will be sufficient. Where the coating has only loose adhesion, then these areas should be chipped clean and all prepared surfaces should be primed with **Thortex Uni-Tech G.P. Primer**.

Steel Surfaces: Surfaces should be abrasive blasted then treated with either **Thortex Corro-Tech M.C. Primer**, **Thortex Corro-Tech W.B.** or **Thortex Corro-Tech G.P. Primer**. Steel surfaces which cannot be abrasive blasted should be manually abraded then primed with **Thortex Corro-Tech G.P. Primer**.

Other metal surfaces should be primed with **Thortex Corro-Tech W.B.** in accordance with the product tech sheet.

Other Substrates: These should first be primed with **Thortex Uni-Tech G.P. Primer**.

All surfaces should be dry and free from contamination.

MIXING

Thortex Wall-Tech W.B. is a two component material which must be mixed together prior to use.

The base component should be thoroughly stirred to incorporate any slight separation, while continuing stirring the contents of the activator container should be added. Continue stirring until a homogeneous mix is obtained.

The mixed material must be used within 2 hours of mixing at 68°F.

APPLICATION

Application should not be carried out at temperatures below 40°F nor when relative humidity exceeds 85% or when the surface to be coated is less than 5°F above the dew point.

Thortex Wall-Tech W.B. can be applied by brush, roller or airless spray.

Brush: Brush application should be carried out using even brush strokes. **Thortex Wall-Tech W.B.** should not be over brushed which may lead to lower than specified coating thickness.

Roller: **Thortex Wall-Tech W.B.** should be spread evenly over the surface to give a film thickness of 4 mils wet. Periodic thickness checks should be made to ensure the correct uniform thickness is achieved.

Airless Spray: Typical spray settings are as follows:-

Tip Size	0-011 - 0.015"
Tip Pressure	1750 - 2500 psi
Product Temperature	68 - 77°F

Excessively high tip spraying pressures should be avoided. The minimum pressure at the pump conducive to good atomization should be used.

Thinning: Thortex Wall-Tech W.B. does not normally require any thinning for spray application. Where thinning is necessary then upto 5% by volume of clean water may be added.

NOTE: When spraying **Thortex Wall-Tech W.B.** equipment should be first flushed out with a water miscible solvent followed by clean water (this is important where solvent based products have previously been sprayed through the equipment).

All equipment must be cleaned **IMMEDIATELY** after use with water stubborn deposits may be removed by the use of **Thortex Universal Cleaner**.

Theoretical Coverage Rate per Coat

108 ft²/liter at 2 mils dft per coat

Recommended Film Thickness

Wet 4 mils

Dry 2 mils

Note: Normally applied as a two coat system to achieve a total dry film thickness of 4 mils.

Detailed working recommendations are available from the Technical Center on request.

PHYSICAL CONSTANTS

Mixing Ratio 4 parts base to 1 part activator by volume.

Appearance Base Colored Liquid
Activator Clear Liquid

Drying & Cure

times at 68°F	Usable Life	2 Hours
	Touch Dry	4 Hours
	Hard Dry	16 Hours
	Minimum Overcoating	6 Hours
	Maximum Overcoating	5 Days
	Full Cure	10 Days

Volume Solids 50%

V.O.C. Nil

Shelf Life Use within 2 years of purchase. Store in original sealed containers at temperatures between 40°F and 86°F. **PROTECT FROM FROST.**

Food Contact Meets U.S.D.A. requirements for incidental food contact.
Meets FDA CFR 21.175.300 requirements for food contact.

Fire Performance (Applied at recommended dft)

BS 476 Part 7 Class 1 surface spread of flame
BS 476 Part 6 Class 0 in accordance with UK Building Regulations 1991 Approvals
Document B2/3/4 Appendix A.

PHYSICAL PROPERTIES

Abrasion Resistance 70 mg loss per 1000 cycles
ASTMD4060

Bacteria Resistance Excellent

Dry Heat Resistance 275°F
ASTMD248

Humidity Resistance Unaffected 5,000 hours exposure
BS 3900 Part F2

Scratch Resistance No failure at 5.5 lbs load
BS 3900 Part E2

Water Vapor Permeability 5.62 x 10⁻⁶ perm.cm
ASTMD1653

HEALTH AND SAFETY

As long as normal good practice is observed **Thortex Wall-Tech W.B.** can be safely used.

Vapor masks should be worn for spraying **Thortex Wall-Tech W.B.**

A fully detailed **Material Safety Data Sheet** is either included with the material or is available on request.

PACKAGING

Supplied in 5 and 20 liter packs.

The information provided in this Product Data Sheet is intended as a general guide only and should not be used for specification purposes. The information is given in good faith but we assume no responsibility for the use made of the product or this information because this is outside the control of the company. Users should determine the suitability of the product for their own particular purposes by their own tests.



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FOR FURTHER INFORMATION PLEASE CONTACT