

# LUXAFLOOR<sup>®</sup> RollCoat

(Replaces LUXAFLOOR<sup>®</sup> HS)

High Build High Solids Epoxy Floor Coating

PC 227

- FEATURES**
- EXTREMELY TOUGH, DAMAGE RESISTANT FILM
  - GENERAL EPOXY FLOOR COATING
  - EXCELLENT ADHESION TO CONCRETE
  - GOOD CHEMICAL RESISTANCE
  - LOW VOC
  - EASY TO CLEAN
  - AVAILABLE IN A SELECTED RANGE OF FACTORY MADE AND TINTED COLOURS

**USES** LUXAFLOOR<sup>®</sup> RollCoat is a high build, high solids, two pack epoxy floor coating that provides a hardwearing surface. It is ideal for use in areas subject to foot and rubber-tired vehicle traffic. Can be applied as a slip resistant finish to provide maximum safety by using a suitable aggregate. Refer Product Data Sheet PC940 LUXAFLOOR<sup>®</sup> Aggregate.  
LUXAFLOOR<sup>®</sup> RollCoat is ideal for use in internal floor areas of factories, warehouses etc. It provides an attractive appearance that is easily cleaned.

**SPECIFICATIONS** AS/NZS 4586 (with the addition of a suitable LUXAFLOOR<sup>®</sup> Aggregate)

## RESISTANCE GUIDE

<b>HEAT RESISTANCE</b>	Up to 120°C dry heat.	<b>ALKALIS</b>	Excellent resistance to splash and spillage of most alkalis.
<b>WEATHERABILITY</b>	Epoxy coatings may yellow with time. On exterior exposure some chalking may also occur. This will not detract from the protective properties of the coating. Use a weatherable topcoat if required for appearance.	<b>SALTS</b>	Unaffected by splash and spillage of neutral and alkaline salt solutions.
<b>SOLVENTS</b>	Resists splash and spillage of aromatic and aliphatic hydrocarbon solvents and alcohols.	<b>WATER</b>	Excellent resistance to fresh and salt water.
<b>ACIDS</b>	Suitable for splash and spillage exposure to dilute acids.	<b>ABRASION</b>	Excellent when fully cured. 133 mg per 1000 cycles (CS-17, 1000 gm load/wheel)
		<b>ADHESION</b>	10 MPa (1458 p.s.i.) (Adhesion Pull-off Test, AS1580.408.5)

## TYPICAL PROPERTIES AND APPLICATION DATA

<b>CLASSIFICATION</b>	High build high solids epoxy coating	
<b>FINISH</b>	Gloss	
<b>COLOUR</b>	Selected range of factory made and tinted colours. MTO factory made colours.	
<b>COMPONENTS</b>	Two	
<b>SOLIDS BY VOLUME</b>	Refer to Page 2	
<b>VOC LEVEL</b>	Refer to Page 2	
<b>FLASH POINT</b>	24°C	
<b>POT LIFE (4L, 25°C)</b>	Refer to Page 2	
<b>MIXING RATIO (V/V)</b>	Part A : 3	Part B : 1
<b>THINNER</b>	920-08925	Epoxy Thinner*
<b>PRODUCT CODE</b>	707-89815	Mid Base
	707-38678	Light Grey
	707-38661	Pewter
	707-38716	Blue Grey
	976-H0000	Standard Hardener
	976-H0001	Cold Weather Hardener
	976-H0002	Hot Weather Hardener

## APPLICATION CONDITIONS

	Refer to Page 2		
	Min	Max	Recom.
Wet film per coat (microns)			
Dry film per coat (microns)			Refer to Page 2

**SUITABLE SUBSTRATES** Suitably prepared concrete.

**APPLICATION METHODS** Brush, Roller, Conventional and Airless spray.

\*THINNER SHOULD ONLY BE USED IF REQUIRED – Refer to your DULUX<sup>®</sup> Protective Coatings Consultant

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Standard Hardener						
<b>COATING THICKNESS</b>				<b>APPLICATION CONDITIONS</b>		
	Min	Max	Recom.		Min	Max
Wet film per coat (microns)	115	230	145	Air Temperature	15°C	35°C
Dry film per coat (microns)	100	200	125	Substrate Surface Temperature	15°C	35°C
				Relative Humidity		85%
				Concrete Moisture Content		<10%
<b>SOLIDS BY VOLUME</b>	88 % (Mid Base)			<b>POT LIFE</b>	60 Minutes (4L, 25°C)	
<b>VOC LEVEL</b>	140 g/L (Mid Base, untinted)					
<b>Drying characteristics at 125 microns dry film thickness</b>						
<b>Temperature</b>	<b>Humidity</b>	<b>Touch</b>	<b>Light Traffic</b>	<b>Full Cure</b>	<b>Overcoat Min</b>	<b>Max</b>
15° C	50%	4 Hours	20 Hours	7 Days	10 Hours	30 Hours
25° C	50%	2 Hours	16 Hours	7 Days	6 Hours	18 Hours
<b>TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD</b>				A spreading rate of 7.0 sq. metres per litre corresponds to 125 microns dry film thickness assuming no losses. Practical spreading rates will vary depending on such factors as method and conditions of application and surface roughness.		

Cold Weather Hardener						
<b>COATING THICKNESS</b>				<b>APPLICATION CONDITIONS</b>		
	Min	Max	Recom.		Min	Max
Wet film per coat (microns)	115	230	145	Air Temperature	10°C	25°C
Dry film per coat (microns)	100	200	125	Substrate Surface Temperature	10°C	25°C
				Relative Humidity		85%
				Concrete Moisture Content		<10%
<b>SOLIDS BY VOLUME</b>	88 % (Mid Base)			<b>POT LIFE</b>	45 Minutes (4L, 25°C)	
<b>VOC LEVEL</b>	140 g/L (Mid Base, untinted)					
<b>Drying characteristics at 125 microns dry film thickness</b>						
<b>Temperature</b>	<b>Humidity</b>	<b>Touch</b>	<b>Light Traffic</b>	<b>Full Cure</b>	<b>Overcoat Min</b>	<b>Max</b>
10° C	50%	4 Hours	22 Hours	7 Days	12 Hours	36 Hours
15° C	50%	3 Hours	18 Hours	7 Days	10 Hours	30 Hours
25° C	50%	1½ Hours	14 Hours	7 Days	6 Hours	18 Hours
<b>TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD</b>				A spreading rate of 7.0 sq. metres per litre corresponds to 125 microns dry film thickness assuming no losses. Practical spreading rates will vary depending on such factors as method and conditions of application and surface roughness.		

Hot Weather Hardener						
<b>COATING THICKNESS</b>				<b>APPLICATION CONDITIONS</b>		
	Min	Max	Recom.		Min	Max
Wet film per coat (microns)	115	230	145	Air Temperature	20°C	45°C
Dry film per coat (microns)	100	200	125	Substrate Surface Temperature	20°C	45°C
				Relative Humidity		85%
				Concrete Moisture Content		<10%
<b>SOLIDS BY VOLUME</b>	88 % (Mid Base)			<b>POT LIFE</b>	90 Minutes (4L, 25°C)	
<b>VOC LEVEL</b>	140 g/L (Mid Base, untinted)					
<b>Drying characteristics at 125 microns dry film thickness</b>						
<b>Temperature</b>	<b>Humidity</b>	<b>Touch</b>	<b>Light Traffic</b>	<b>Full Cure</b>	<b>Overcoat Min</b>	<b>Max</b>
25° C	50%	2½ Hours	18 Hours	7 Days	8 Hours	20 Hours
<b>TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD</b>				A spreading rate of 7.0 sq. metres per litre corresponds to 125 microns dry film thickness assuming no losses. Practical spreading rates will vary depending on such factors as method and conditions of application and surface roughness.		

These figures are given as a guide only, as ventilation, film thickness, humidity, thinning and other factors will influence the rate of drying.

If the maximum overcoat interval is exceeded then the surface MUST be abraded to ensure maximum intercoat adhesion.

Use of fast or low temperature hardeners may result in increased yellowing and a reduction of gloss level.

\* When used for non-immersion conditions. Refer to PRECAUTIONS section for overcoating intervals and requirements for immersion service.

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## TYPICAL SYSTEMS

(The typical systems are offered as a guide only and are not to be used as a specification. It is recommended that the specific needs of a project be discussed with a Dulux Protective Coatings Consultant.)

SURFACE	PREPARATION GUIDE	SYSTEM		DRY FILM THICKNESS
CONCRETE	Clean surface to remove contaminants. Diamond grind, track or light-shot blast. Remove dust.	1st Coat	LUXAFLOOR® RollCoat™	125 Microns
		2nd Coat	LUXAFLOOR® RollCoat™	125 Microns
		1st Coat	DUREBILD® STE	125 Microns
		2nd Coat	LUXAFLOOR® RollCoat™	125 Microns
For a slip resistant finish refer to Product Data Sheet PC940 LUXAFLOOR® Aggregate.				

### SURFACE PREPARATION

#### Concrete:

Remove all laitance, form release, curing compounds, oil, grease and other surface contaminants. Diamond grind, track or light shot-blast to provide suitable profile. Remove all dust by vacuum cleaning. Fill any large voids exposed using Luxepoxy Filler. Cement based substrates should be at least 21 days old before coating.

### APPLICATION

Stir each can thoroughly until the contents are uniform. Use of a power mixer is recommended. Ensure bases have been tinted to the correct colour before use – DULUX ASSUMES NO RESPONSIBILITY FOR THE APPLICATION OF AN INCORRECT COLOUR. Mix the contents of both packs together thoroughly using a power mixer and allow to stand for 3 minutes. Box all containers before use to ensure colour consistency. Remix thoroughly before using.

### BRUSH/ROLLER

Roller application suitable for use on concrete floors by applying even coats of mixed material to the prepared surface. Thin up to 5% to assist application. It is recommended that typical "X" and "Y" roller patterns be used, working in small areas of up to 10m<sup>2</sup> at a time, keeping a wet-edge moving forward. When brushing and rolling additional coats may be required to attain the specified thickness.

### PRECAUTIONS

This is an industrial product designed for use by experienced Protective Coating applicators. Where conditions may require variation from the recommendations on this Product Data Sheet contact your nearest Dulux® representative for advice prior to painting. Do not apply in conditions outside the parameters stated in this document without the express written consent of Dulux® Australia. Freshly mixed material must not be added to material that has been mixed for some time. The rate of cure is dependent upon temperature. Do not apply at temperatures below 10°C, or where the surface temperature is below 10°C. Do not apply at relative humidity above 85% or when the surface is less than 3°C above the dewpoint. To minimise colour variation ensure all product is mixed and thinned as directed, box containers before use, do not mix hardener types on one job. To minimise variations in appearance topcoat must be applied in one session using a uniform/consistent application technique.

### CLEAN UP

Clean all equipment with Dulux® Epoxy Thinner (920-08925) immediately after use.

### OVERCOATING

Aged coating should be tested for lifting by a method appropriate for the coating thickness, for example 'X' cut or cross-hatch methods. If it lifts, remove it. The surface must be free of oil, grease and other contaminants. High-pressure water wash at 8.3 to 10.3 MPa (1,200 - 1,500 p.s.i.) to remove loosely adhering chalk and dust. Abrasion may be required depending on surface condition. If the maximum overcoat interval is exceeded then the surface MUST be abraded to ensure maximum intercoat adhesion.

### SAFETY PRECAUTIONS

**Read Data Sheet, Material Safety Data Sheet and any precautionary labels on containers.**

#### STORAGE

Store as required for a flammable liquid Class 3 in a bunded area under cover. Store in well-ventilated area away from sources of heat or ignition. Keep containers closed at all times.

#### HANDLING

As with any chemical, ingestion, inhalation and prolonged or repeated skin contact should be avoided by good occupational work practice. Eye protection approved to AS1337 should be worn where there is a risk of splashes entering the eyes. Always wash hands before smoking, eating, drinking or using the toilet.

#### USING

Use with good ventilation and avoid inhalation of spray mists and fumes. If risk of inhalation of spray mists exists, wear combined organic vapour/particulate respirator. When spray painting, users should comply with the provisions of the respective State Spray Painting Regulations. This product contains silica. Dry sanding should therefore be avoided and if it cannot wear appropriate respiratory protection.

#### FLAMMABILITY

This product is flammable. All sources of ignition must be eliminated in, or near the working area. DO NOT SMOKE. Fight fire with foam, CO<sub>2</sub> or dry chemical powder. On burning will emit toxic fumes.

#### WELDING

Avoid inhalation of fumes if welding surfaces coated with this paint. Grind off coating before welding.

**MATERIAL SAFETY DATA SHEET is available from Customer Service (132377) or [www.duluxprotectivecoatings.com.au](http://www.duluxprotectivecoatings.com.au)**

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PACKAGING	Available in 10 litre packs
TRANSPORTATION WEIGHT	1.36 kg/litre (Average of components)
DANGEROUS GOODS	Part A: Class 3 UN 1263 Part B: Class 3 UN 1760

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