

LUXATHANE[®] R

Recoatable Gloss Polyurethane Finish

PC 402

- FEATURES**
- VERY GOOD WEATHERING AND CHEMICAL RESISTANCE
 - VERY GOOD ABRASION RESISTANCE AND TOUGHNESS
 - EASY TO APPLY AND MAINTAIN/TINTABLE
 - TINTABLE – AVAILABLE IN OVER 5,000 COLOURS

USES LUXATHANE[®] R is a full gloss, two-component acrylic polyurethane that is recoatable with minimum surface preparation. It is designed for general use in atmospheric chemical and marine service where gloss and colour retention, hardness and abrasion resistance, and wide-ranging chemical resistance are required. It may be used in new construction and maintenance services over properly primed steel, galvanised steel, concrete or hardwood timber.

LUXATHANE[®] R may be applied directly over all Dulux[®] Epoxy Primers and universal primers or over recommended high-build epoxy intermediate coats. It may be effectively used over aged tightly adhering epoxy and other coatings subject to necessary solvent resistance tests and appropriate surface preparation.

SPECIFICATIONS

RESISTANCE GUIDE

WEATHERABILITY	Very good gloss and colour retention on exterior exposure	SOLVENTS	Unaffected by splash and spillage of common alcohols, aliphatic and aromatic hydrocarbons, esters and ketones
HEAT RESISTANCE	Up to 120°C dry heat	WATER	Excellent resistance to fresh and salt water but not suitable for immersion
SALTS	Excellent resistance to most salt solutions	ALKALIS	Good resistance to splash and spillage of most common alkalis
ACIDS	Suitable for splash and spillage of mild acids	ABRASION	Very good when fully cured

TYPICAL PROPERTIES AND APPLICATION DATA (STANDARD HARDENER)

CLASSIFICATION	Two Component Catalysed Acrylic	APPLICATION CONDITIONS			
FINISH	High Gloss		Min	Max	
COLOUR	White, LF Golden Yellow, Black and a full range of tinted colours and MTO factory made colours.	Air Temp.	5°C	45°C	
		Substrate Temp.	5°C	45°C	
		Relative Humidity		85%	
COMPONENTS	Two	COATING THICKNESS (MICRONS)			
VOLUME SOLIDS	46% White, 42% - 45% Colours		Min	Max	Recommended
VOC LEVEL	<490 g/L (White, untinted)	Wet film per coat (µm)	95	130	110
FLASH POINT	16°C	Dry film per coat (µm)	45	60	50
POT LIFE	4 – 6 hours (4 litre kit, 25°C)	SUITABLE SUBSTRATES	Suitably primed steel, aluminium, zinc coated steel, concrete, fibreglass and MDF		
MIXING RATIO V/V	Part A : 4 Part B : 1	PRIMERS	Most Dulux [®] two pack and single pack primers		
THINNER – BRUSH	965-42166 Duthin [®] 040	TOPCOATS	Not applicable		
THINNER – SPRAY	965-63023 Dulux [®] Urethane Thinner	APPLICATION METHODS	Conventional, HVLP, airless spray or air assisted spray		
PRODUCT CODE	737-63313 White 737-39141 LF Golden Yellow 737-00070 Black 737-63001 Light Base 737-63002 Deep Base 737-63003 Clear Base 976-63091 Standard Hardener 976-88960 Cold Cure Hardener				

DRYING CHARACTERISTICS AT 50 µm DRY FILM THICKNESS* (STANDARD HARDENER)

Temperature	Humidity	Touch	Handle	Full Cure	OVERCOAT	
					Min	Max
10° C	50%	90 Minutes	24 Hours	7 Days	24 Hours	Indefinite
15° C	50%	60 Minutes	12 Hours	7 Days	12 Hours	Indefinite
25° C	50%	30 Minutes	9 Hours	7 Days	9 Hours	Indefinite

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

SPREADING RATE 9.2 m²/L (white) 8.4-9.0 m²/L (colours) equals 50 µm dry film thickness with Standard Hardener assuming no losses
NOTE: Practical spreading rates will vary depending on such factors as application method, ambient conditions, surface porosity and roughness.

LUXATHANE® R

COLD CURE HARDENER

COATING THICKNESS (MICRONS)

	Min	Max	Recommended
Wet film per coat (µm)	95	130	110
Dry film per coat (µm)	45	60	50

APPLICATION CONDITIONS

	Min	Max
Air Temperature	5°C	45°C
Substrate Surface Temperature	5°C	45°C
Relative Humidity		85%

SOLIDS BY VOLUME	46% White, 42% - 45% Colours
VOC LEVEL	<490 g/L (White)
POT LIFE	90 Minutes (4 litre kit, 25°C)

DRYING CHARACTERISTICS AT 50 µm DRY FILM THICKNESS* (COLD CURE HARDENER)

Temperature	Humidity	Touch	Handle	Full Cure	OVERCOAT	
					Min	Max
10° C	50%	75 Minutes	14 Hours	7 Days	14 Hours	Indefinite
15° C	50%	50 Minutes	7 Hours	7 Days	7 Hours	Indefinite
25° C	50%	25 Minutes	5 Hours	7 Days	5 Hours	Indefinite

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

SPREADING RATE 9.2 m²/L (white) 8.4-9.0 m²/L (colours) equals 50 µm dry film thickness with Cold Cure Hardener assuming no losses
 NOTE: Practical spreading rates will vary depending on such factors as application method, ambient conditions, surface porosity and roughness.

TYPICAL SYSTEMS

This is a guide only and not to be used as a specification. Your specific project needs must be discussed with a Dulux Protective Coatings Consultant.

SURFACE	ENVIRONMENT	PREPARATION GUIDE	SYSTEM	DFT (µm)
STEEL	Coastal (AS2312.1 Cat C5)	Abrasive blast AS1627.4 Class 2.5	1 st Coat Zincanode® 402	75 µm
			2 nd Coat Ferreko® No. 3	125 µm
			3 rd Coat Luxathane® R	50 µm
STEEL	Mild - Moderate (AS2312.1 Cat C2-3)	Abrasive blast AS1627.4 Class 2.5	1 st Coat Durepon® P14	75 µm
			2 nd Coat Luxathane® R	50 µm
			3 rd Coat Luxathane® R	50 µm
CONCRETE	Exterior/Interior	Remove release agents and other surface contaminants	1 st Coat Durebild® STE	125 µm
			2 nd Coat Luxathane® R	50 µm
			3 rd Coat Luxathane® R	50 µm
HARDWOOD & MDF	Interior	Sand and dust down before and after first coat	1 st Coat Luxepoxy® 4 White Primer	50 µm
			2 nd Coat Luxathane® R	50 µm
			3 rd Coat Luxathane® R	50 µm
ALUMINIUM	Exterior/Interior	Clean, degrease and abrade surface	1 st Coat Luxepoxy® 4 White Primer	50 µm
			2 nd Coat Luxathane® R	50 µm
			3 rd Coat Luxathane® R	50 µm

NOTE: If application is by brush or roller, additional coats will be necessary to achieve the minimum DFT and full opacity

LUXATHANE[®] R

SURFACE PREPARATION	<p>Specifiers should follow the surface preparation guidelines from the data sheet for the primer selected. The surface must be free from grease, oil, dirt, rust and other contaminants. Dulux[®] recommends that surfaces be degreased with Gamlen CA No. 1 (a free-rinsing, alkaline detergent) according to the manufacturer's written instructions and all safety warnings.</p> <p>Steel: Round off all rough welds, sharp edges and remove weld spatter. Remove grease, oil and other contaminants in accordance with AS1627.1. Abrasive blast clean to a minimum of AS1627.4 Class 2.5.</p> <p>Concrete: Concrete must be at least 28 days old before coating. Remove all laitance, curing compounds, oil, grease and other surface contaminants. Fill any large cracks or voids using Luxepoxy[®] Filler.</p> <p>Non-ferrous substrates: Remove grease, oil and other contaminants in accordance with AS1627.1. Whip blast to provide a key. Alternatively, degrease and abrade the surface with a non-metallic abrasive pad, such as Scotch-Brite[®] scourer wetted with Gamlen CA No. 1 (a free-rinsing, alkaline detergent) and water. Rinse thoroughly with fresh water.</p> <p>MDF and hardwood: Sand thoroughly and remove all dust. Resand surface after primer has cured to remove any raised fibres.</p>												
APPLICATION	Mix each can thoroughly using a power mixer until the contents are uniform. Ensure bases have been tinted to the correct colour before use. DULUX [®] ASSUMES NO RESPONSIBILITY FOR THE APPLICATION OF INCORRECT COLOUR. Mix the contents of both packs together thoroughly with a power mixer and let stand for 10 minutes. Box all containers before use to ensure colour consistency. Remix thoroughly before application.												
BRUSH/ROLLER	Suitable for small areas only. Where larger areas are involved, application is improved by the addition of up to 100 ml/litre with DUTHIN [®] 040 (965-42166). When brushing and rolling additional coats may be required to attain the specified thickness.												
CONVENTIONAL SPRAY	Thin up to 150ml/litre with Dulux [®] Urethane Thinner (965-63023) to aid atomisation. Apply in multiple wet coats overlapping each pass 50%.												
	<table border="0"> <tr> <td>Typical Set-up</td> <td>Graco Delta Gun</td> <td>1.4mm (239542)</td> </tr> <tr> <td></td> <td>Pressure at Pot:</td> <td>70-100 kPa (10-15 p.s.i.)</td> </tr> <tr> <td></td> <td>Pressure at Gun:</td> <td>380-410 kPa (55-60 p.s.i.)</td> </tr> <tr> <td></td> <td>HVLP</td> <td>1.4 Fluid Tip Set</td> </tr> </table>	Typical Set-up	Graco Delta Gun	1.4mm (239542)		Pressure at Pot:	70-100 kPa (10-15 p.s.i.)		Pressure at Gun:	380-410 kPa (55-60 p.s.i.)		HVLP	1.4 Fluid Tip Set
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	HVLP	1.4 Fluid Tip Set											
AIRLESS SPRAY	Standard airless spray equipment such as a Graco 30:1 President with a fluid tip of 15 thou (0.38mm) and an air supply capable of delivering 550-690 kPa (80-100 p.s.i.) at the pump. Thinning is not normally required but up to 100 ml/litre of Dulux [®] Urethane Thinner (965-63023) may be added to aid application.												
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 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 5°C. Do not apply at relative humidity above 85% or when the surface is less than 3°C above the dewpoint. Ensure that you read and understand the safety precautions on the Material Safety Data Sheets for the two components before using. The recommended thinner MUST be used as some solvents react with the isocyanate hardener seriously degrading the life of the coating. Under no circumstances should water or non-recommended thinner be allowed to contaminate the product. In hot weather use Duthin [®] 040 (965-42166) for improved flow and to reduce dry spray.												
CLEAN UP	Clean all equipment with Dulux [®] Urethane Thinner (965-63023) immediately after use.												
OVERCOATING	Remove oil, grease, dirt and other surface contaminants. Test adhesion of existing coating by standard cross hatch adhesion test. If the coating fails, remove it. High-pressure water wash at 8.3 to 10.3 MPa (1,200-1,500p.s.i.) to remove chalk and dust. Abrade to remove gloss and provide a key for the new coating. Epoxies must be abraded if recoated outside the recoat window.												
SAFETY PRECAUTIONS	Read Data Sheet, SAFETY DATA SHEET and any precautions on container labels. SAFETY DATA SHEET is available from Customer Service (132377) or www.duluxprotectivecoatings.com.au												
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 spraying, users must comply with their respective State Spray Painting Regulations.												
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 ₂ 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.												

COMPANY INFORMATION		PACKAGING, TRANSPORT AND STORAGE	
Dulux Protective Coatings a division of		PACKAGING	Available in 4 litre and 20 litre packs
DuluxGroup (Australia) Pty Ltd 1956 Dandenong Road, Clayton 3168 A.B.N. 67 000 049 427	DuluxGroup (New Zealand) Pty Ltd 150 Hutt Park Road, Lower Hutt, NZ A.B.N. 55 133 404 118	TRANSPORTATION WEIGHT	1.28 kg/litre (Average of components)
		DANGEROUS GOODS	Part A: Class 3 UN 1263 Part B: Class 3 UN 1263

Dulux, Duthin, Durebild, Durepon, Luxepoxy, Luxathane and Zincode are registered trade marks of DuluxGroup (Australia) Pty Ltd.

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