

LUXATHANE[®] R

Recoatable Gloss Polyurethane Finish

PC 402

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

USES LUXATHANE[®] R is a full gloss, two-component acrylic polyurethane that displays the advantage of being 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 AS/NZS 3750.6

RESISTANCE GUIDE

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

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION FINISH	Acrylic polyurethane coating High Gloss		APPLICATION CONDITIONS	REFER TO PAGE 2		
COLOUR	White, LF Golden Yellow, Black, a full range of tinted colours and MTO factory made colours.					
COMPONENTS	Two			Min	Max	Recom.
SOLIDS BY VOLUME	REFER TO PAGE 2		Wet film per coat (microns)	REFER TO PAGE 2		
VOC LEVEL	REFER TO PAGE 2		Dry film per coat (microns)	REFER TO PAGE 2		
FLASH POINT	16°C		SUITABLE SUBSTRATES	Suitably primed steel, aluminium, zinc coated steel, concrete, fibreglass or MDF.		
POT LIFE	REFER TO PAGE 2		TOPCOATS	Epoxy primers, etch primers and universal metal primers.		
MIXING RATIO (V/V)	Part A : 4	Part B : 1	APPLICATION METHODS	Conventional, HVLP, airless spray or air assisted spray.		
THINNER	Brush	965-42166				
	Spray	965-63023				
				DUTHIN [®] 040 Dulux [®] Urethane Thinner		
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 Weather Hardener				

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Standard Hardener						
COATING THICKNESS @ 46% Volume Solids				APPLICATION CONDITIONS		
	Min	Max	Recom.		Min	Max
Wet film per coat (microns)	95	130	110	Air Temperature	5°C	45°C
Dry film per coat (microns)	45	60	50	Substrate Surface Temperature	5°C	45°C
				Relative Humidity		85%
SOLIDS BY VOLUME	46% White, 42% - 45% Colours			POT LIFE	4 - 6 Hours (4L, 25°C)	
VOC LEVEL	<490 g/L (White)					
Drying characteristics at 50 microns dry film thickness						
Temperature	Humidity	Touch	Handle	Full Cure	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
TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD				A spreading rate of 9.2 sq. metres per litre for White and 8.4-9.0 sq. metres per litre for colours corresponds to 50 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						
COATING THICKNESS @ 46% Volume Solids				APPLICATION CONDITIONS		
	Min	Max	Recom.		Min	Max
Wet film per coat (microns)	95	130	110	Air Temperature	5°C	45°C
Dry film per coat (microns)	45	60	50	Substrate Surface Temperature	5°C	45°C
				Relative Humidity		85%
SOLIDS BY VOLUME	46% White, 42% - 45% Colours			POT LIFE	90 Minutes (4L, 25°C)	
VOC LEVEL	<490 g/L (White)					
Drying characteristics at 50 microns dry film thickness						
Temperature	Humidity	Touch	Handle	Full Cure	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
TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD				A spreading rate of 9.2 sq. metres per litre for White and 8.4-9.0 sq. metres per litre for colours corresponds to 50 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.

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
STEEL	Abrasive blast AS1627.4 Class 2.5	1st Coat	ZINCANODE® 402	75 Microns
		2nd Coat	FERREKO® No 3	125 Microns
		3rd Coat	LUXATHANE® R	50 Microns
		1st Coat	DUREPON® P14	75 Microns
		2nd Coat	LUXATHANE® R	50 Microns
		3rd Coat	LUXATHANE® R	50 Microns
CONCRETE	Clean surface to remove contaminants. Diamond grind, track or light-shot blast. Remove dust.	1st Coat	LUXEPOXY® 4 White Primer	50 Microns
		2nd Coat	LUXATHANE® R	50 Microns
		3rd Coat	LUXATHANE® R (Thin prime coat 10-15%)	50 Microns
HARDWOOD & MDF	Sand and dust down before and after first coat.	1st Coat	LUXEPOXY® 4 White Primer	50 Microns
		2nd Coat	LUXATHANE® R	50 Microns
		3rd Coat	LUXATHANE® R	50 Microns
ALUMINIUM	Clean, degrease and abrade surface	1st Coat	LUXEPOXY® 4 White Primer	50 Microns
		2nd Coat	LUXATHANE® R	50 Microns
		3rd Coat	LUXATHANE® R	50 Microns

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SURFACE PREPARATION	It is recommended that specifiers follow the guidelines for surface preparation from the data sheet for the primer selected. The primer surface must be free from grease, oil, dirt and other loosely adhering materials.
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 10 minutes. Box all containers before use to ensure colour consistency. Remix thoroughly before using.
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%. <u>Typical Set-up</u> 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
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 ease 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 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 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	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.
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. Gas is evolved when isocyanate in the hardener reacts with water. If a closed container shows signs of internal pressure, cover it completely with a cloth and remove the lid slowly to prevent splashing or violent expulsion of the lid.
USING	Use with good ventilation and avoid inhalation of spray mists and fumes. If risk of inhalation of spray mists exists, wear a positive-pressure, air-supplied respirator. When spray painting, users should comply with the provisions of the 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.

MATERIAL SAFETY DATA SHEET is available from Customer Service (132377) or www.duluxprotectivecoatings.com.au

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PACKAGING	Available in 4 litre and 20 litre packs
TRANSPORTATION WEIGHT	1.28 kg/litre (Average of components)
DANGEROUS GOODS	Part A: Class 3 UN 1263 Part B: Class 3 UN 1263

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