

EPIGLOSS[®] 4 Finish

(Replaces LUXEPOXY[®] 4 Finish)

Two Pack Epoxy Gloss Finish

PC 223

- FEATURES**
- APPROVED TO APAS 0330/1
 - GLOSS FINISH FOR SEVERE CHEMICAL AND MARINE EXPOSURES
 - TOUGH, ABRASION RESISTANT FINISH
 - SUITABLE FOR CONTACT WITH FOODSTUFFS

USES EPIGLOSS[®] 4 Finish provides a high gloss, easily maintained surface in areas of high abuse and under aggressive chemical exposure. It is recommended for the protection of plant in most chemical, industrial and petrochemical environments including alumina refineries, paper mills, oil refineries, food and beverage plants, abattoirs and canneries. EPIGLOSS[®] 4 Finish is also a versatile maintenance coating for machinery, process equipment, many flooring surfaces, canteens and amenity blocks and laboratories. It is also used in a system as a tank lining for storage of petroleum products including aviation turbine fuel, aviation gasoline fuel and hydrocarbon solvents.

SPECIFICATIONS The use of the film forming components of EPIGLOSS[®] 4 Finish when applied as directed is authorised by Section 175.300 of the U.S. Code of Federal Regulation (Food & Drugs) as the food contact surface of articles intended for use in producing, manufacturing, packing, processing, preparing, treating, packaging, transporting or holding food, subject to the limitation and conditions of use prescribed in that Section.
AS/NZS 3750.10

RESISTANCE GUIDE

| | | | |
|------------------------|--|-----------------|--|
| HEAT RESISTANCE | Up to 120°C dry heat. Slight discolouration may occur. | ALKALIS | Excellent resistance to splash and spillage of most common alkalis. |
| WEATHERABILITY | 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. | SALTS | Unaffected by splash and spillage of neutral and alkaline salt solutions. |
| SOLVENTS | Resists splash and spillage of most hydrocarbon solvents, refined petroleum products and most common alcohols. | WATER | Excellent resistance to fresh and salt water (not recommended for immersion conditions). |
| ACIDS | Suitable for splash and spillage exposure to weak solutions of inorganic acids. | ABRASION | Excellent when fully cured. |

TYPICAL PROPERTIES AND APPLICATION DATA

| | | | | | |
|---------------------------|---|-------------------------------|---|------|--------|
| CLASSIFICATION | Two pack epoxy gloss finish | APPLICATION CONDITIONS | Min | Max | |
| FINISH | High Gloss | Air Temperature | 10°C | 45°C | |
| COLOUR | White and MTO factory made colours. | Substrate Surface Temperature | 10°C | 45°C | |
| | | Relative Humidity | | 85% | |
| COMPONENTS | Two | | Min | Max | Recom. |
| SOLIDS BY VOLUME | 50% (White) | Wet film per coat (microns) | 80 | 150 | 100 |
| VOC LEVEL | <440 g/L (White) | Dry film per coat (microns) | 40 | 75 | 50 |
| FLASH POINT | 14°C | | | | |
| POT LIFE | 8 Hours (4L, 25°C) | | | | |
| MIXING RATIO (V/V) | Part A : 2 Part B : 1 | SUITABLE SUBSTRATES | Suitably primed steel, aluminium, zinc coated steel, concrete, fibreglass or MDF. | | |
| THINNER | 920-08925 Dulux [®] Epoxy Thinner | PRIMERS | Most two pack primers. | | |
| PRODUCT CODE | 732-89893 White 976-89894 Hardener | APPLICATION METHODS | Brush, roller, conventional, airless spray, air assisted spray or HVLP. | | |

Drying characteristics at 50 microns dry film thickness

| Temperature | Humidity | Touch | Handle | Full Cure | Overcoat | |
|-------------|----------|---------|----------|-----------|----------|--------|
| | | | | | Min | Max |
| 10° C | 50% | 8 Hours | 22 Hours | 7 Days | 22 Hours | 3 Days |
| 15° C | 50% | 5 Hours | 12 Hours | 7 Days | 12 Hours | 2 Days |
| 25° C | 50% | 2 Hours | 7 Hours | 7 Days | 8 Hours | 2 Days |

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. Refer to PRECAUTIONS section for overcoating requirements for immersion service.

TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD

A spreading rate of 10.2 sq. metres per litre 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.

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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 |
|---------------------|--|----------|--------------------------|--------------------|
| STEEL | Abrasive blast AS1627.4 Class 2.5 | 1st Coat | DUREPON® P14 Primer | 75 Microns |
| | | 2nd Coat | EPIGLOSS® 4 Finish | 50 Microns |
| | | 3rd Coat | EPIGLOSS® 4 Finish | 50 Microns |
| | | 1st Coat | ZINCANODE® 402 | 75 Microns |
| | | 2nd Coat | EPIGLOSS® 4 Finish | 50 Microns |
| | | 3rd Coat | EPIGLOSS® 4 Finish | 50 Microns |
| CONCRETE MASONRY | Clean surface to remove contaminants. Diamond grind, track or light-shot blast. Remove dust. | 1st Coat | LUXEPOXY® 4 White Primer | 50 Microns |
| | | 2nd Coat | EPIGLOSS® 4 Finish | 50 Microns |
| | | 3rd Coat | EPIGLOSS® 4 Finish | 50 Microns |
| HARDWOOD & MDF | Sand and dust down before and after first coat. | 1st Coat | LUXEPOXY® 4 White Primer | 50 Microns |
| | | 2nd Coat | EPIGLOSS® 4 Finish | 50 Microns |
| | | 3rd Coat | EPIGLOSS® 4 Finish | 50 Microns |
| ALUMINIUM | Clean, degrease and abrade surface | 1st Coat | LUXEPOXY® 4 White Primer | 50 Microns |
| | | 2nd Coat | EPIGLOSS® 4 Finish | 50 Microns |
| | | 3rd Coat | EPIGLOSS® 4 Finish | 50 Microns |

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 **USE ONLY EPIGLOSS® 4 FINISH HARDENER (976-89894). Check hardener cans before use.**
Stir each can thoroughly until the contents are uniform. Use of a power mixer is recommended. Mix the contents of both packs together thoroughly using a power mixer and allow to stand for 10 minutes. Remix thoroughly before using.

BRUSH/ROLLER Apply even coats of the mixed material to the prepared surface. Thin if necessary with up to 50 ml/litre with Dulux® Epoxy Thinner (920-08925) to ease application. Additional coats may be required to attain the specified thickness.

CONVENTIONAL SPRAY Thin up to 100ml/litre with Dulux® Epoxy Thinner (920-08925) to aid atomisation.

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.)

AIRLESS SPRAY Standard airless spray equipment such as a Graco 30:1 President with a fluid tip of 15-17 thou (0.38-0.43mm) 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 50 ml/litre of Dulux® Epoxy Thinner (920-08925) 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 if surface/coating temperature will fall below 10°C during the drying period. Do not apply at relative humidity above 85% or when the surface is less than 3°C above the dewpoint. The coating MUST be fully cured and solvent free prior to being placed under immersion conditions. Due to variations in construction standards, EPIGLOSS® 4 Finish is not recommended for use on swimming pools or water immersion.

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.

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, CO₂ 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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RESISTANCE GUIDE:

The following resistance table represents a guide to the expected performance standards for fully cured EPIGLOSS® 4 Finish when applied to specifications on steel or concrete.

| CHEMICAL | PERMANENT EXPOSURE | INTERMITTENT EXPOSURE | CHEMICAL | PERMANENT EXPOSURE | INTERMITTENT EXPOSURE |
|-------------------------|--------------------|-----------------------|---------------------------|--------------------|-----------------------|
| SOLVENTS | | | ALKALI & SALTS | | |
| Aviation gasoline | E | E | Caustic Soda 5% | E | E |
| Ind. Methylated Spirits | E | E | Caustic Soda 5% Hot | E | E |
| Acetone | F | S | Caustic Soda 40% | E | E |
| Amyl acetate | F | S | Ammonia | P | F |
| Benzene | E | E | Common Salt 5% | E | E |
| Butyl acetate | E | E | Common Salt 5% 100°C | S | E |
| Butyl alcohol | E | E | Sodium carbonate | E | E |
| Cellosolve | F | E | Sodium hypochlorite | S | E |
| Cyclohexanol | F | E | Bleaching liquid | S | E |
| Diacetone alcohol | F | S | | | |
| Dibutyl phthalate | E | E | OILS & FATS | | |
| Ethyl acetate | F | S | Lubricating oil | E | E |
| Ethanol | E | E | Diesel Oil | E | E |
| Ethylene diamine | P | P | Crude oil | E | E |
| Ethylene glycol | E | E | Raw linseed oil | E | E |
| Heptane | E | E | Coconut oil | E | E |
| Methyl ethyl ketone | P | S | Caster oil | E | E |
| Methanol | F | E | Peanut oil | E | E |
| Methylene chloride | P | P | Palm oil | E | E |
| Propane | E | E | Soybean oil | E | E |
| Solvent naphtha | E | E | Fatty acids | P | F |
| Toluene | E | E | | | |
| Trichloroethylene | F | E | DETERGENTS | | |
| White spirit | E | E | Teepol | P | E |
| Xylene | E | E | Detergent Alkylate | E | E |
| Styrene Monomer | E | E | | | |
| Vinyl acetate monomer | P | P | MISCELLANEOUS | | |
| | | | Butadiene | E | E |
| ACIDS | | | Bromine | P | P |
| Nitric acid 5% | E | E | Creosote | P | P |
| Nitric acid 10% | F | S | Cresylic acid | P | P |
| Sulphuric acid 10% | S | S | Formaldehyde 40% | P | F |
| Sulphuric acid 50% | P | S | Glycerine | E | E |
| Hydrochloric acid 20% | S | E | P.V.A. latex | F | E |
| Hydrochloric acid conc. | P | S | Ethylene Diamine | P | F |
| Phosphoric acid 20% | F | E | Diethylene triamine | P | F |
| Acetic acid 20% | S | E | Phenol (liquid) | P | F |
| Acetic acid 50% | S | E | | | |
| Acetic acid glacial | P | P | | | |
| Chromic acid 25% | P | S | | | |
| Citric acid 10% | E | E | | | |
| Formic acid 40% | P | P | | | |
| Lactic acid 10% | P | P | | | |
| Naphthenic acid | E | E | | | |

E = Excellent

S = Satisfactory

F = Fair

P = Poor

Is not recommended for resistance to strong oxidising acids such as Sulphuric, Nitric or Chromic; or to strong concentrations of Acetic or Formic acids.

Where specific recommendations are required for service in immersed conditions full details should be referred to Dulux Australia.

Dulux Protective Coatings a division of DuluxGroup (Australia) Pty Ltd
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Dulux, Epigloss, Luxepoxy, Zincanode and Durepon are registered. DuluxGroup is a trademark.

PACKAGING Available in 6 litre packs
TRANSPORTATION WEIGHT 1.26 kg/litre (Average of components)
DANGEROUS GOODS Part A: Class 3 UN 1263
Part B: Class 3 UN 1263

Any advice, recommendation, information, assistance or service provided by DULUX Australia in relation to goods manufactured by it or their use and application is given in good faith and is believed by Dulux to be appropriate and reliable. However, any advice, recommendation, information, assistance or service provided by Dulux is provided without liability or responsibility PROVIDED THAT the foregoing shall not exclude, limit, restrict or modify the right entitlements and remedies conferred upon any person or the liabilities imposed upon Dulux by any condition or warranty implied by Commonwealth, State or Territory Act or ordinance void or prohibiting such exclusion limitation or modification. Products can be expected to perform as indicated in this sheet so long as applications and application procedures are as recommended. Specific advice should be sought from Dulux for application in coastal areas and for large projects to ensure proper performance.