LUXEPOXY® 66

Two Pack Epoxy Blast Primer **PC 208**

FEATURES

- PREFABRICATION HOLDING PRIMER
- APPROVED TO APAS 014/1
- UP TO 6 MONTHS DURABILITY WITHOUT OVERCOATING
- ACCEPTS NORMAL CUTTING AND WELDING OPERATIONS
- CAN BE OVERCOATED WITH A WIDE RANGE OF SINGLE AND TWO PACK COATINGS

USES

LUXEPOXY® 66 is recommended as a holding primer over freshly abrasive blast cleaned steel, for periods of up to 6 months depending on prevailing conditions.
LUXEPOXY® 66 shows good drying properties at the recommended 25 microns dry film thickness and is compatible with a wide range of finishes including epoxy, chlorinated rubber, acrylic epoxy, polyurethane and conventional alkyds.

SPECIFICATIONS AS/NZS 3750.13 Type 1

RESISTANCE GUIDE

HEAT RESISTANCE	Up to 120°C dry heat.
WEATHERABILITY	Protects steel from corrosion for up to 6 months without topcoats. Epoxies may yellow with time. On exterior exposure some chalking may occur. This will not detract from the protective properties of the coating. Use a weatherable topcoat if required for appearance.
SOLVENTS	Resists splash and spillage of most hydrocarbon solvents, refined petroleum products and most common alcohols.
ACIDS	Suitable for splash and spillage exposure to weak solutions of inorganic acids.
ALKALIS	Excellent resistance to splash and spillage of most common alkalis.
SALTS	Excellent resistance to neutral and alkali salt solutions when suitably topcoated.
WATER	Suitable for immersion in fresh and salt water when suitably topcoated.
ABRASION	Good when fully cured.

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Epoxy Primer	
FINISH	Low Gloss	
COLOUR	Red Oxide	
COMPONENTS	Two	
SOLIDS BY VOLUME	28%	
VOC LEVEL	<640 g/L	
FLASH POINT	4°C	
POT LIFE	8 Hours (20L, 25°C)	
MIXING RATIO (V/V)	Part A : 3	Part B : 1
THINNER	920-08925	Dulux® Epoxy Thinner
PRODUCT CODE	731-63050	Part A
	976-63100	Hardener

APPLICATION CONDITIONS	Min	Max
Air Temperature	10°C	45°C
Substrate Surface Temperature	10°C	45°C
Relative Humidity		85%

	Min	Max	Recom.
Wet film per coat (microns)	70	140	90
Dry film per coat (microns)	20	40	25

SUITABLE SUBSTRATES Abrasive blast cleaned steel.

TOPCOATS Most single and two pack topcoats.

APPLICATION METHODS Conventional, airless spray or air assisted spray.

Drying characteristics at 25 microns dry film thickness

					Overcoat	
Temperature	**Humidity**	**Touch**	**Handle**	**Full Cure**	**Min**	**Max***
25° C	50%	5 Minutes	8 Hours	7 Days	8 Hours	6 months

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.

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

TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD

A spreading rate of 11.6 sq. metres per litre corresponds to 25 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 Class 3 for immersion	1st Coat 2nd Coat	LUXEPOXY® 66 LUXEPOXY® STL	25 Microns 500 Microns
		1st Coat 2nd Coat 3rd Coat	LUXEPOXY® 66 DUREMAX® GPE DUREMAX® GPE	25 Microns 125 Microns 125 Microns

SURFACE PREPARATION

Round off all rough welds, sharp edges and remove weld spatter. Remove grease, oil and other contaminants in accordance with AS1627.1. Rust, millscale, oxide deposits and old paint films on metal surfaces must be removed by abrasive blast cleaning to a minimum of AS1627.4 Class 2.5. Immersed steel must be prepared to AS1627.4 Class 3. Remove all dust by brushing or vacuum cleaning.

APPLICATION

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

Not recommended.

CONVENTIONAL SPRAY

Thinning is not normally required, but up to 100 ml/litre of Dulux® Epoxy Thinner (920-08925) can be added to aid atomisation.

Typical Set-up

Graco Delta Gun:	1.8mm (239543)
Pressure at Pot:	70-100 kPa (10-15 p.s.i.)
Pressure at Gun:	340-410 kPa (50-60 p.s.i.)

AIRLESS SPRAY

Standard airless spray equipment such as a Graco President 28:1 pump ratio with a fluid tip of 15 -19 thou (0.38-0.48mm) 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 at temperatures below 10°C. Do not apply at relative humidity above 85% or when the surface is less than 3°C above the dewpoint. When used for immersion conditions the maximum overcoat interval is 3 days at 25°C. The coating MUST be fully cured and solvent free prior to being placed under immersion conditions.

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.

Spot repair with LUXEPOXY® 66 and apply the selected topcoat.

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, 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 20 litre packs
TRANSPORTATION WEIGHT	1.26 kg/litre (Average of components)
DANGEROUS GOODS	Part A: Class 3 UN 1263
	Part B: Class 3 UN 1866