

LUXEPOXY[®] T

Tintable Two Pack Epoxy Finish

PC 222

- FEATURES**
- GLOSS FINISH FOR MOST CHEMICAL, MINING AND MARINE EXPOSURES
 - HIGH ABRASION RESISTANCE
 - FULLY TINTABLE – AVAILABLE IN OVER 5,000 COLOURS

USES LUXEPOXY[®] T is a versatile coating for machinery, process equipment, flooring surfaces, canteens, amenity blocks and laboratories. It may be specified in most chemical, industrial and petrochemical environments, as well as for the protection of shipping and marine structures.
LUXEPOXY[®] T is fully tintable using the COLORFAST[™] tint system, offering an extensive choice in colour selection.

SPECIFICATIONS AS/NZS 3750.10

RESISTANCE GUIDE

HEAT RESISTANCE	Up to 120°C dry heat. Some colours are subject to change at these temperatures.	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 but not suitable for immersion.
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 tintable epoxy finish	APPLICATION CONDITIONS			Min	Max
FINISH	Gloss	Air Temperature	10°C	45°C		
COLOUR	A full range of tinted colours.	Substrate Surface Temperature	10°C	45°C		
COMPONENTS	Two	Relative Humidity		85%		
SOLIDS BY VOLUME	42-48% (varies with colour)				Min	Max
VOC LEVEL	<470 g/L (Light Base, untinted)	Wet film per coat (microns)	90	135	110	Recom.
FLASH POINT	15°C	Dry film per coat (microns)	40	60	50	
POT LIFE	6 hours (4L, 25°C)	SUITABLE SUBSTRATES	Suitably primed steel, aluminium, zinc coated steel, concrete, fibreglass or MDF.			
MIXING RATIO (V/V)	Part A : 3 Part B : 2	PRIMERS	Most two pack primers.			
THINNER	920-08925 Dulux [®] Epoxy Thinner	APPLICATION METHODS	Brush, roller, conventional, airless spray, air assisted spray and HVLP.			
PRODUCT CODE	732-63001 Light Base 732-63002 Deep Base 732-63003 Clear Base 976-63044 Hardener					

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	4 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.

TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD

A spreading rate of 9.0 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	75 Microns
		2nd Coat	LUXEPOXY® T	50 Microns
		3rd Coat	LUXEPOXY® T	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	LUXEPOXY® T	50 Microns
		3rd Coat	LUXEPOXY® T	50 Microns
HARDWOOD & MDF	Sand and dust down before and after first coat.	1st Coat	LUXEPOXY® 4 White Primer	50 Microns
		2nd Coat	LUXEPOXY® T	50 Microns
		3rd Coat	LUXEPOXY® T	50 Microns
ALUMINIUM	Clean, degrease and abrade surface	1st Coat	LUXEPOXY® 4 White Primer	50 Microns
		2nd Coat	LUXEPOXY® T	50 Microns
		3rd Coat	LUXEPOXY® T	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 LUXEPOXY® T HARDENER (976-63044). Check hardener cans before use.**
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 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. When brushing and rolling 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. Thin 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 sometime. 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.

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 to 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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PACKAGING	Available in 4 litre packs
TRANSPORTATION WEIGHT	1.48 kg/litre (Average of components)
DANGEROUS GOODS	Part A: Class 3 UN 1263
	Part B: Class 3 UN 1263

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