Dulux® PROTECTIVE COATINGS

LUXEPOXY® UHB

Ultra High Build Epoxy — PC 240

FEATURES

- APPLIES TO 3,000 MICRONS IN ONE COAT
- SOLVENT FREE – DOES NOT REQUIRE THINNING
- SUITABLE FOR CONTACT WITH POTABLE WATER AND FOODSTUFFS

USES

LUXEPOXY® UHB is designed for long life protection of steel and concrete in areas subject to aggressive chemical or marine atmospheres. Due to its tough, abrasion resistant features it is recommended as a single coat protection for oil platform conductors, jacket legs and difficult to maintain seabed installations. It can also be applied to damp concrete surfaces.
LUXEPOXY® UHB is ideally suited for the protection of concrete in aggressive chemical environments particularly raw and treated sewerage of an acidic nature.

SPECIFICATIONS

The use of the film forming components of LUXEPOXY® UHB 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.
AS4020 for use with potable water.
AS/NZS 3750.2

RESISTANCE GUIDE

HEAT RESISTANCE	Up to 120°C dry heat.
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.
SOLVENTS	Suitable for immersion in aromatic and aliphatic hydrocarbons and refined petroleum products.
ACIDS	Suitable for splash and spillage exposure to weak solutions of inorganic acids.
ALKALIS	Excellent resistance to splash and spillage of most common alkalis.
OILS & FATS	Excellent resistance to mineral and vegetable oils and fats excepting for prolonged contact with fatty acids.
SALTS	Excellent resistance to neutral and alkali salts.
WATER	Excellent resistance to immersion in fresh and salt water.
ABRASION	Excellent when fully cured.

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Two pack epoxy	
FINISH	Low Sheen	
COLOUR	Grey (approximate match to AS2700 N35) & limited range of MTO factory made colours.	
COMPONENTS	Two	
SOLIDS BY VOLUME	100%	
VOC LEVEL	<10 g/L	
FLASH POINT	Above 65°C	
POT LIFE	20 Min (18L, 25°C)	
MIXING RATIO (V/V)	Part A : 1	Part B : 1
THINNER Spray	Do not Thin	
Clean up	920-08925	Dulux® Epoxy Thinner
PRODUCT CODE	742-50688	Grey
	976-50689	Hardener

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

	Min	Max	Recom.
Wet film per coat (microns)	2,000	5,000	3,000
Dry film per coat (microns)	2,000	5,000	3,000

SUITABLE SUBSTRATES Abrasive blast cleaned steel or prepared concrete.

APPLICATION METHODS Airless spray.

Drying characteristics at 3,000 microns dry film thickness

Temperature	Humidity	Touch	Handle	Full Cure	Overcoat Min	Overcoat Max
10° C	50%	10 Hours	30 Hours	7 Days	30 Hours	48 Hours
15° C	50%	7 Hours	24 Hours	7 Days	24 Hours	36 Hours
25° C	50%	4 Hours	13 Hours	7 Days	13 Hours	24 Hours

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 immersion service requirements.

TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD

A spreading rate of 0.30 sq. metres per litre corresponds to 3,000 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.

LUXEPOXY® UHB

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 3, 75-100 microns profile.	1st Coat	LUXEPOXY® UHB	3,000 Microns
CONCRETE	Clean surface to remove contaminants. Diamond grind, track or light-shot blast. Remove dust.	1st Coat 2nd Coat	LUXEPOXY® UHB LUXEPOXY® UHB	500 Microns 2,000 Microns

SURFACE PREPARATION

Steel: 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 AS1627.4 Class 3 with a suitable blast media to give a blast profile of 75-100 microns. Remove all dust by brushing or vacuum cleaning.

Concrete: Remove all laitance, form release, curing compounds, oil, grease and other surface contaminants. Diamond grind, track or light shot-blast to provide suitable profile. Remove all dust by vacuum cleaning. Fill any large voids exposed using Luxepoxy Filler. Cement based substrates should be at least 21 days old before coating.

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 immediately prior to use. Use without further delay. Ensure the clean-up solvent is available before commencing application.

BRUSH/ROLLER

Suitable for small areas only such as rivets and seams. When brushing and rolling additional coats may be required to attain the specified thickness.

CONVENTIONAL SPRAY

Not recommended.

AIRLESS SPRAY

PLURAL COMPONENT AIRLESS UNITS

Airless spray equipment capable of equal volume metering and heating such as a Graco 45:1 or 56:1 Xtreme Mix with a fluid tip of 31 thou (0.79mm, 3 ¼ Twist Tip) or adjustable tip (Titan) and an air supply capable of delivering 690-830 kPa (100-120 p.s.i.) at the pump and a line size of 12 mm I.D.

PRE-MIX AIRLESS APPLICATION

Standard airless spray equipment such as a Graco 68:1 Xtreme with a fluid tip of 31 thou (79mm) and an air supply capable of delivering 690-830 kPa (100-120 p.s.i.) at the pump and a line size of 12mm I.D.

Add the stirred components together in the supplied 1:1 ratio by volume and mix using a power mixer immediately prior to use. Use without further delay.

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. Concrete tanks will need to be emptied in advance of coating application to allow the moisture content of the concrete to fall below the maximum of 12%. After the coating has cured, check for defects in the coating in accordance with AS 3891.4, and repair. Do not apply over water proofing compounds. The coating MUST be fully cured prior to being placed under immersion conditions. This material MUST NOT be thinned.

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.

REPAIR

Within 24 hours at 25°C: Thoroughly solvent wash with Epoxy Thinner, allow the solvent to flash off and apply LUXEPOXY® UHB to the prepared area, overlapping sound coating by 70-100mm.

After 24 hours at 25°C: Sweep blast or abrade by hand (Grade 150 or coarser) and then solvent wash using Epoxy Thinner for areas of low film build or pin holes. Apply LUXEPOXY® UHB to the prepared area, overlapping sound coating by 70-100mm.

SAFETY PRECAUTIONS **Read Data Sheet, Material Safety Data Sheet and any precautionary labels on containers.**

STORAGE: Store in well-ventilated area under cover. 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 combustible. 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

Dulux Protective Coatings a division of DuluxGroup (Australia) Pty Ltd
1956 Dandenong Road, Clayton 3168
A.B.N. 67 000 049 427

PACKAGING	Available in 18 litre packs
TRANSPORTATION WEIGHT	1.14 kg/litre (Average of components)
DANGEROUS GOODS	Part A: Non Dangerous Goods Part B: Non Dangerous Goods