LUXATHANE® R
Recoatable Gloss Polyurethane Finish

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

USES
LUXATHANE® R is a full gloss, two-component acrylic polyurethane that is 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

WEATHERABILITY
Very good gloss and colour retention on exterior exposure.

SOLVENTS
Excellent resistance to 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.

ALKALIS
Good resistance to splash and spillage of most common alkalis.

ACID FAILURE
- Suitable for splash and spillage of mild acids.
- Not suitable for splash and spillage of strong acids.

ABRASION
Very good when fully cured.

TYPICAL PROPERTIES AND APPLICATION DATA (STANDARD HARDENER)

CLASSIFICATION
Two Component Acrylic Polyurethane

FINISH
High Gloss

COLOUR
White, LF Golden Yellow, Black and a full range of tinted colours and MTO factory made colours.

APPLICATION CONDITIONS

<table>
<thead>
<tr>
<th></th>
<th>Min</th>
<th>Max</th>
</tr>
</thead>
<tbody>
<tr>
<td>Air Temp.</td>
<td>5°C</td>
<td>45°C</td>
</tr>
<tr>
<td>Substrate Temp.</td>
<td>5°C</td>
<td>45°C</td>
</tr>
<tr>
<td>Relative Humidity</td>
<td>85%</td>
<td></td>
</tr>
<tr>
<td>Concrete Moisture</td>
<td>&lt;10%</td>
<td></td>
</tr>
</tbody>
</table>

COATING THICKNESS (MICRONS)

<table>
<thead>
<tr>
<th></th>
<th>Min</th>
<th>Max</th>
<th>Recommended</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wet film per coat (μm)</td>
<td>85</td>
<td>130</td>
<td>110</td>
</tr>
<tr>
<td>Dry film per coat (μm)</td>
<td>40</td>
<td>60</td>
<td>50</td>
</tr>
</tbody>
</table>

SUBSTRATES
Suitably primed steel, aluminium, zinc coated steel, concrete, fibreglass or MDF

THINNER – BRUSH
965-42166 Dulux® Urethane Thinner

THINNER – SPRAY
965-63023 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
976-63001 Standard Hardener
976-88960 Cold Cure Hardener
976-H0229 Part C Accelerator

PRIMERS
Most Dulux® two pack and single pack primers

TOPCOATS
Not applicable

APPLICATION METHODS
Conventional, HVLP, airless spray or air assisted spray

DRYING CHARACTERISTICS AT 50 μm DRY FILM THICKNESS* (STANDARD HARDENER)

<table>
<thead>
<tr>
<th>Temperature</th>
<th>Humidity</th>
<th>Touch</th>
<th>Handle</th>
<th>Full Cure</th>
<th>OVERCOAT*</th>
</tr>
</thead>
<tbody>
<tr>
<td>10°C</td>
<td>50%</td>
<td>90 Minutes</td>
<td>24 Hours</td>
<td>7 Days</td>
<td>24 Hours</td>
</tr>
<tr>
<td>15°C</td>
<td>50%</td>
<td>60 Minutes</td>
<td>12 Hours</td>
<td>7 Days</td>
<td>12 Hours</td>
</tr>
<tr>
<td>25°C</td>
<td>50%</td>
<td>30 Minutes</td>
<td>9 Hours</td>
<td>7 Days</td>
<td>9 Hours</td>
</tr>
</tbody>
</table>

* These figures are a guide only, as ventilation, film thickness, humidity, thinning and other factors will influence the rate of drying.

SPREADING RATE
with Standard Hardener
assuming no losses
9.2 m²/L (white), 8.4-9.0 m²/L (colours) equals 50 μm dry film thickness

NOTE: Practical spreading rates will vary depending on such factors as application method, ambient conditions, surface porosity and roughness.
# Luxathane® R

## Cold Cure Hardener

### Coating Thickness (Microns)

<table>
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### Application Conditions

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<tbody>
<tr>
<td>Air Temperature</td>
<td>5°C</td>
<td>45°C</td>
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<td>Substrate Surface Temperature</td>
<td>5°C</td>
<td>45°C</td>
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<tr>
<td>Relative Humidity</td>
<td></td>
<td>85%</td>
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### Solids by Volume

- 46% White, 42% - 45% Colours
- VOC Level: <490 g/L (White)
- POT Life: 90 Minutes (4 litre kit, 25°C)

## Drying Characteristics at 50 μm Dry Film Thickness* (Cold Cure Hardener)

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<tr>
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<tbody>
<tr>
<td>10°C</td>
<td>50%</td>
<td>75 Minutes</td>
<td>14 Hours</td>
<td>7 Days</td>
<td>14 Hours</td>
<td>Extended</td>
</tr>
<tr>
<td>15°C</td>
<td>50%</td>
<td>50 Minutes</td>
<td>7 Hours</td>
<td>7 Days</td>
<td>7 Hours</td>
<td>Extended</td>
</tr>
<tr>
<td>25°C</td>
<td>50%</td>
<td>25 Minutes</td>
<td>5 Hours</td>
<td>7 Days</td>
<td>5 Hours</td>
<td>Extended</td>
</tr>
</tbody>
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*These figures are a guide only, as ventilation, film thickness, humidity, thinning and other factors will influence the rate of drying.

### Spreading Rate

- 9.2 m²/L (white) 8.4-9.0 m²/L (colours) equals 50 μm dry film thickness

### Standard Hardener with Accelerator (Part C)

#### Coating Thickness (Microns)

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<td>45°C</td>
</tr>
<tr>
<td>Relative Humidity</td>
<td></td>
<td>85%</td>
</tr>
</tbody>
</table>

### Solids by Volume

- 45% White
- VOC Level: <50 g/L (White)
- POT Life: 4 – 6 hours (4 litre kit, 25°C)

## Drying Characteristics at 50 μm Dry Film Thickness* (Accelerator)

<table>
<thead>
<tr>
<th>Temperature</th>
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<th>Handle</th>
<th>Full Cure</th>
<th>Min</th>
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<tbody>
<tr>
<td>15°C</td>
<td>50%</td>
<td>50 Minutes</td>
<td>9 Hours</td>
<td>7 Days</td>
<td>9 Hours</td>
<td>Extended</td>
</tr>
<tr>
<td>25°C</td>
<td>50%</td>
<td>25 Minutes</td>
<td>8 Hours</td>
<td>7 Days</td>
<td>8 Hours</td>
<td>Extended</td>
</tr>
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*These figures are a guide only, as ventilation, film thickness, humidity, thinning and other factors will influence the rate of drying.

### Spreading Rate

- 9.2 m²/L (white) 8.4-9.0 m²/L (colours) equals 50 μm dry film thickness

### Typical Systems

This is a guide only and not to be used as a specification. Your specific project needs must be discussed with a Dulux Protective Coatings Consultant.

#### Surface Environment

- **Steel**
  - Very high corrosivity (AS2312.1 Cat C5)
  - System PUR5
  - Preparation Guide: Abrasive blast AS1627.4 Class 2.5
  - Coatings: Zincanode® 402, Duremax® GPE, Luxathane® R
  - DFT: 75 μm

- **Steel**
  - Low-medium corrosivity (AS2312.1 Cat C2-3)
  - Exceeds System PUR 2
  - Preparation Guide: Abrasive blast AS1627.4 Class 2.5
  - Coatings: Durepon® EZP, Luxathane® R, Luxathane® R
  - DFT: 75 μm

- **Aluminium**
  - Exterior/Interior
  - Preparation Guide: Clean, degrease and abrade surface
  - Coatings: Luxepoxy® 4 White Primer, Luxathane® R
  - DFT: 50 μm

**Note:** If application is by brush or roller, additional coats will be necessary to achieve the minimum DFT and full opacity.

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PC 402  August 2018  Page 2 of 3
LUXATHANE® R

SURFACE PREPARATION
Specifiers should follow the surface preparation guidelines from the data sheet for the primer or first coat selected. The surface must be clean, sound and free from moisture, grease, oil, dirt, rust, loose paint, and other contaminants and abraded to provide a suitable key for the coating system. If application of the second coat has exceeded the recoat window of the first coat (refer to data sheet) then the entire surface MUST be abraded.

APPLICATION
Mix each can thoroughly using a power mixer until the contents are uniform. Ensure bases have been tinted to the correct colour before use. DULUX® ASSUMES NO RESPONSIBILITY FOR THE APPLICATION OF INCORRECT COLOUR. Mix the contents of both packs together thoroughly with a power mixer and let stand for 10 minutes. Box all containers before use to ensure colour consistency. Remo/horously before application.

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
Thinn to 150ml/litre with Dulux® Urethane Thinner (965-63023) to aid atomisation. Apply in multiple wet coats overlapping each pass 50%.

Typical Set-up
- Graco AirPro: 1.4mm (239542)
- Pressure at Triton 308: 70-100 kPa (10-15 p.s.i.)
- Pressure at Gun: 380-410 kPa (55-60 p.s.i.)
- HVLP Fluid Tip Set

AIRLESS SPRAY
Standard airless spray equipment such as a Graco Xtreme 30:1 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 aid 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® Consultant for advice prior to painting. Do not apply in conditions outside the parameters stated in this document without the 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 Safety Data Sheets for the two components before using. The recommended thinner MUST be used as some solvents react with the isocyanate hardener seriously decreasing the life of the coating. Under no circumstances should water or non-degrading solvents be used 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
Degrease with Gamlen CA 1 according to the data sheet. Test adhesion of existing coating by standard cross hatch adhesion test. If the coating fails, remove it. High-pressure water wash at 8.3 to 10.3 MPa (1,200-1,500 p.s.i.) to remove chalk and dust. Abrade surface to provide a good key for the new coating.

SAFETY PRECAUTIONS
Read Data Sheet, SAFETY DATA SHEET and any precautions on container labels. SAFETY DATA SHEET is available from Customer Service (13 23 77) or www.duluxprotectivecoatings.com.au

STORAGE
Store as required for a flammable liquid Class 3 in a bunded area under cover. Store in a dry, 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 must be worn while handling. 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. When spraying, wear a positive air-supplied respirator. Users must always comply with the provisions of the respective State Spray Painting Regulations at all times.

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.

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

DuluxGroup (New Zealand) Pty Ltd
150 Hutt Park Road, Lower Hutt, NZ
A.B.N. 55 133 404 118

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PACKAGING, TRANSPORT AND STORAGE

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PC 402 August 2018 Page 3 of 3