

LUXATHANE® SPX

High Performance Recoatable Satin Polyurethane Finish

PC 404

- FEATURES**
- EXCELLENT UV RESISTANCE AND GLOSS RETENTION
 - VERY GOOD DRYING AND RECOAT PROPERTIES
 - SMOOTH SATIN FINISH
 - LONG TERM RECOATABILITY

USES LUXATHANE® SPX is a high performance satin, two-component acrylic polyurethane that is recoatable with minimum surface preparation. It is designed for use in areas where a high gloss is not required and a satin finish is desired. LUXATHANE® SPX is formulated for use in commercial and industrial environments where extended service periods are required.

The smooth, durable, satin finish is ideal for steelwork and facades of commercial projects, such as retail complexes and high rise offices and apartments. This versatile product is equally suitable for new construction and maintenance over properly primed steel, galvanised steel, aluminium, concrete, hardwood timber and MDF.

LUXATHANE® Accelerator is available for use with standard hardener to promote faster drying.

SPECIFICATIONS AS/NZS 3750.5

RESISTANCE GUIDE

WEATHERABILITY	Excellent gloss and colour retention on exterior exposure	SOLVENTS	Unaffected by splash and spillage of common alcohols, aliphatic and aromatic hydrocarbons, esters and ketones
HEAT RESISTANCE	Up to 120°C dry heat	WATER	Excellent resistance to fresh and salt water but not suitable for immersion
SALTS	Unaffected by splash and spillage of most salt solutions	ALKALIS	Good resistance to splash and spillage of most common alkalis
ACIDS	Suitable for splash and spillage exposure to most acids	ABRASION	Good when fully cured

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Two pack acrylic polyurethane coating		APPLICATION CONDITIONS			
FINISH	Satin, 60° gloss of approximately 20-30 GU			Min	Max	
COLOUR	White, Black, and a full range of tinted colours		Air Temp.	10°C	45°C	
COMPONENTS	Two		Substrate Temp.	10°C	45°C	
VOLUME SOLIDS	52 ± 2% (depending on the colour)		Relative Humidity		85%	
VOC LEVEL	<430 g/L		COATING THICKNESS (MICRONS)			
FLASH POINT	>23°C			Min	Max	Recommended
POT LIFE	5 hours (4 litre kit, 25°C)		Wet film per coat (µm)	95	175	145
MIXING RATIO V/V	Part A : 4	Part B : 1	Dry film per coat (µm)	50	90	75
THINNER –BRUSH	965-63023	DULUX® URETHANE THINNER	SUITABLE SUBSTRATES	Suitably primed steel, aluminium, zinc coated steel, concrete, fibreglass or MDF		
THINNER –SPRAY	965-63023	DULUX® URETHANE THINNER	PRIMERS	Epoxy primers, etch primers and universal metal primers		
PRODUCT CODE	729-63313	White	APPLICATION METHODS	Conventional, HVLP, airless spray or air assisted spray		
	729-63001	Light Base				
	729-63003	Clear Base				
	729-63002	Deep Base				
	729-00070	Black				
	976-H0190	Standard Hardener				
	976-H0229	Part C Accelerator				

DRYING CHARACTERISTICS AT 75 µm DRY FILM THICKNESS*

Temperature	Humidity	Touch	Handle	Full Cure	OVERCOAT*	
					Min	Max
10° C	50%	75 Minutes	13 Hours	7 Days	13 Hours	Extended
15° C	50%	60 minutes	10 Hours	7 Days	10 Hours	Extended
25° C	50%	30 minutes	5 Hours	7 Days	5 Hours	Extended

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

SPREADING RATE 6.9 square metres per litre equals 75 µm dry film thickness

ASSUMING NO LOSSES

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

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STANDARD HARDENER WITH ACCELERATOR (PART C)

MIXING RATIO | Part C: 1 dose per 4 litre mixed kit

COATING THICKNESS (MICRONS)

	Min	Max	Recommended
Wet film per coat (µm)	95	145	95
Dry film per coat (µm)	50	70	50

APPLICATION CONDITIONS

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

SOLIDS BY VOLUME	52% White
VOC LEVEL	<440 g/L (White)
POT LIFE	5 hours (4 litre kit, 25°C)

DRYING CHARACTERISTICS AT 50 µm DRY FILM THICKNESS* (ACCELERATOR)

OVERCOAT*

Temperature	Humidity	Touch	Handle	Full Cure	Min	Max
15° C	50%	50 Minutes	6 Hours	7 Days	6 Hours	Extended
25° C	50%	25 Minutes	4 Hours	7 Days	4 Hours	Extended

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

SPREADING RATE 10.4 square metres per litre equals 50 µm dry film thickness

with Cold Cure Hardener
assuming no losses

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

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	PREPARATION GUIDE	SYSTEM	DFT (µm)
STEEL – NEW	High corrosivity (AS2312.1 Cat C5) System PUR5	Abrasive blast AS1627.4 Class 2.5	1 st Coat Zincanode® 402	75 µm
			2 nd Coat Duremax® GPE	200 µm
			3 rd Coat Luxathane® SPX	50 µm
STEEL – NEW	Medium–high corrosivity (AS2312.1 Cat C4) System PUR4	Abrasive blast AS1627.4 Class 2.5	1 st Coat Zincanode® 402	75 µm
			2 nd Coat Duremax® GPE	125 µm
			3 rd Coat Luxathane® SPX	50 µm
STEEL – NEW	Low-medium corrosivity (AS2312.1 Cat C2-4) Exceeds System PUR 2a	Abrasive blast AS1627.4 Class 2.5	1 st Coat Zincanode® 402	75 µm
			2 nd Coat Luxathane® SPX	50 µm
			3 rd Coat Luxathane® SPX	50 µm
STEEL – NEW	Low corrosivity (AS2312.1 Cat C2) System PUR2	Abrasive blast AS1627.4 Class 2.5	1 st Coat Durepon® EZP	75 µm
			2 nd Coat Luxathane® SPX	50 µm
STEEL – NEW OR MAINTENANCE	Low corrosivity (AS2312.1 Cat C2) System PUR1	Abrasive blast AS1627.4 Class 2 or power tool clean AS1627.2 St 3	1 st Coat Durebild® STE	125 µm
			2 nd Coat Luxathane® SPX	50 µm
CONCRETE	Exterior/Interior	Remove release agents and other surface contaminants	1 st Coat Durebild® STE	125 µm
			2 nd Coat Luxathane® SPX	50 µm
			3 rd Coat Luxathane® SPX	50 µm
HARDWOOD & MDF	Interior	Sand and dust down before and after first coat to remove raised fibres	1 st Coat Luxepoxy® 4 White Primer	50 µm
			2 nd Coat Luxathane® SPX	50 µm
			3 rd Coat Luxathane® SPX	50 µm
ALUMINIUM	Exterior/Interior	Clean, degrease and abrade surface	1 st Coat Luxepoxy® 4 White Primer	50 µm
			2 nd Coat Luxathane® SPX	50 µm
			3 rd Coat Luxathane® SPX	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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SURFACE PREPARATION	Specifiers should follow the surface preparation guidelines from the data sheet for the primer (1 st Coat) selected. The primed surface must be free from grease, oil, dirt, rust and other contaminants. If the primed surface has exceeded its maximum overcoat interval (see the data sheet of the primer) then the surface MUST be abraded to maximize the adhesion of this topcoat.																
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 using a power mixer and let stand for 10 minutes. Box all containers before use to ensure colour consistency. Remix thoroughly before application.																
BRUSH/ROLLER	Suitable for small areas only. Application can be improved by thinning with up to 100 ml/litre with Dulux® URETHANE THINNER (965-63023). Additional coats may be required to attain the specified thickness.																
CONVENTIONAL SPRAY	Thin up to 150 ml/litre with Dulux® URETHANE THINNER (965-63023) to aid atomisation. Apply in multiple wet coats overlapping each pass 50% <table border="0"> <tr> <td>Typical Set-up</td> <td>Graco AirPro:</td> <td>1.4mm (239542)</td> </tr> <tr> <td></td> <td>Pressure at Triton 308:</td> <td>70-100 kPa (10-15 p.s.i.)</td> </tr> <tr> <td></td> <td>Pressure at Gun:</td> <td>380-410 kPa (55-60 p.s.i.)</td> </tr> <tr> <td></td> <td>HVLP</td> <td>1.4 Fluid Tip Set</td> </tr> </table>	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	1.4 Fluid Tip Set				
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AIRLESS SPRAY	Standard airless spray equipment such as a Graco Xtreme 30:1 with a fluid tip of 15 thou (0.38) 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 150 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 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 5°C. Do not apply at relative humidity above 85% or when the surface is less than 3°C above the dewpoint. Ensure you read and understand the safety precautions on the Material Safety Data Sheets for the two components before using. The recommended thinner MUST be used as some solvents react with the isocyanate hardener seriously degrading the life of the coating. Under no circumstances should water or non-recommended thinner be allowed to contaminate the product.																
CLEAN UP	Clean all equipment with Dulux® URETHANE THINNER (965-63023) immediately after use.																
OVERCOATING	Degrease with Gamlen CA No. 1 according to the manufacturer's written instructions and all safety warnings. 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 bonded 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 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-pressure, 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, 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.																
COMPANY INFORMATION																	
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