

LUXEPOXY[®] 4 WHITE PRIMER

Two Pack Epoxy Primer

PC 200

- FEATURES**
- VERSATILE PRIMER SUITABLE FOR OVER GALVANISED STEEL, ALUMINIUM AND CONCRETE
 - EXCELLENT ADHESION TO A WIDE RANGE OF SUBSTRATES
 - EXCELLENT TIE COAT OVER INORGANIC ZINC COATINGS

USES LUXEPOXY[®] 4 White Primer is suitable for a broad range of substrates such as galvanised steel, non-ferrous metals, concrete, hardwood and MDF as the primer for high performance two pack and single pack coatings. It displays a high degree of solvent, chemical and abrasion resistance. LUXEPOXY[®] 4 White Primer is typically used in the chemical and petroleum industry, food and beverage plants, abattoirs, and canneries.

For information on suitability for use as a food contact surface, refer to your Dulux[®] Protective Coatings Consultant.

SPECIFICATIONS

RESISTANCE GUIDE

WEATHERABILITY	Will yellow with time and chalk on exterior exposure. Neither yellowing nor chalking detracts from the protective properties of the coating. Use a weatherable topcoat if required for appearance.	SOLVENTS	Good resistance to splash and spillage of most hydrocarbon solvents, refined petroleum products and most common alcohols
HEAT RESISTANCE	Up to 105°C dry heat	WATER	Excellent resistance to fresh and salt water
SALTS	Excellent resistance to neutral and alkaline salts	ALKALIS	Excellent resistance to splash and spillage of most common alkalis
ACIDS	Good resistance to splash and spillage of weak solutions of inorganic acids	ABRASION	Excellent when fully cured

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Two pack epoxy primer	APPLICATION CONDITIONS			
FINISH	Low Gloss		Min	Max	
COLOUR	White	Air Temp.	10°C	45°C	
		Substrate Temp.	10°C	45°C	
		Relative Humidity		85%	
		Concrete Moisture		<10%	
COMPONENTS	Two	COATING THICKNESS (MICRONS)			
VOLUME SOLIDS	43%		Min	Max	Recommended
VOC LEVEL	<490 g/L	Wet film per coat (µm)	95	140	125
FLASH POINT	15°C	Dry film per coat (µm)	40	60	50
POT LIFE	8 hours (4 Litre kit, 25°C)				
MIXING RATIO V/V	Part A : 4 Part B : 1	SUITABLE SUBSTRATES	Concrete, polyester composite, MDF, aluminium and most non-ferrous metals		
THINNER	920-08925 Dulux [®] Epoxy Thinner	PRIMERS	N/A		
PRODUCT CODE	731-63011 Part A 976-50732 Part B Hardener	TOPCOATS	Single and two pack Dulux [®] topcoats		
		APPLICATION METHODS	Brush, roller, conventional or airless spray		

DRYING CHARACTERISTICS AT 50 µm DRY FILM THICKNESS*

Temperature	Humidity	Touch	Handle	Full Cure	OVERCOAT	
					Min	Max ¹
10° C	50%	2 Hours	15 Hours	7 Days	15 Hours	4 Weeks
15° C	50%	2 Hours	9 Hours	7 Days	9 Hours	4 Weeks
25° C	50%	1.5 Hours	4 Hours	7 Days	8 Hours	4 Weeks

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

¹If the maximum overcoat interval is exceeded then the surface MUST be abraded to ensure maximum intercoat adhesion.

SPREADING RATE ASSUMING NO LOSSES

8.6 square metres per litre 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.

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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)
CONCRETE	Exterior/Interior	Remove release agents and other surface contaminants	1 st Coat Luxepoxy® 4 White Primer 2 nd Coat Weathermax® HBR 3 rd Coat Weathermax® HBR	125 µm 100 µm 100 µm
HARDWOOD & MDF	Interior	Sand and dust down before and after first coat	1 st Coat Luxepoxy® 4 White Primer 2 nd Coat Luxathane® HPX 3 rd Coat Luxathane® HPX	50 µm 50 µm 50 µm
ALUMINIUM	Exterior/Interior	Clean, degrease and abrade surface	1 st Coat Luxepoxy® 4 White Primer 2 nd Coat Luxathane® HPX 3 rd Coat Luxathane® HPX	50 µm 50 µm 50 µm

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

SURFACE PREPARATION	Non-ferrous metals: Round off all sharp edges. Remove grease, oil and other contaminants in accordance with AS1627.1. Whip blast with fine non-metallic media such as plastic, glass or garnet to provide a key. Remove all dust with compressed air. Alternatively, degrease and abrade the surface with a non-metallic abrasive pad wetted with Gamlen CA 1 (a free-rinsing, alkaline detergent) and water. Rinse thoroughly with fresh potable water. Concrete: Concrete must be at least 28 days old before coating. Remove curing compounds, oil, grease and other oily contaminants with Gamlen CA 1 (according to the manufacturer's written instructions and all safety warnings). Remove all laitance and loose material. Fill any large cracks or voids using Luxepoxy® Filler. MDF and hardwood: Sand thoroughly and remove all dust. Resand lightly after priming to remove raised fibres.
APPLICATION	Mix each can thoroughly using a power mixer until the contents are uniform. Mix the contents of both packs together thoroughly with a power mixer and let stand for 10 minutes. Remix thoroughly before application.
BRUSH/ROLLER	Apply even coats of the mixed material to the prepared surface. When brushing and rolling additional coats may be required to attain the specified thickness.
CONVENTIONAL SPRAY	Thin up to 150 ml/litre with Dulux® Epoxy Thinner (920-08925) to aid atomization. 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.)
AIRLESS SPRAY	Standard airless spray equipment such as a Graco Xtreme 30:1 with a fluid tip of 13-15 thou (0.33-0.38mm) 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 50 ml/litre of Dulux® Epoxy Thinner (920-08925) 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 10°C. 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	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. Epoxies must be abraded if recoated outside the recoat window.
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 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 spraying, users must comply with their 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.

COMPANY INFORMATION

Dulux Protective Coatings a division of

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PACKAGING, TRANSPORT AND STORAGE

PACKAGING	Available in 4 litre and 20 litre packs
TRANSPORTATION WEIGHT	1.36 kg/litre (Average of components)
DANGEROUS GOODS	Part A: Class 3 UN 1263
	Part B: Class 3 UN 1263

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