

LUXEPOXY® 66

Two Pack Epoxy Blast Primer

PC 208

- FEATURES**
- PREFABRICATION HOLDING PRIMER
 - UP TO 6 MONTHS DURABILITY WITHOUT OVERCOATING
 - ACCEPTS NORMAL CUTTING AND WELDING OPERATIONS
 - CAN BE OVERCOATED WITH A WIDE RANGE OF SINGLE AND TWO PACK COATINGS

USES LUXEPOXY® 66 is recommended as a holding primer over freshly abrasive blast cleaned steel, for periods of up to 6 months depending on prevailing conditions.

LUXEPOXY® 66 shows good drying properties at the recommended 25 microns dry film thickness and is compatible with a wide range of finishes including epoxy, chlorinated rubber, acrylic epoxy, polyurethane and conventional alkyds.

SPECIFICATIONS AS/NZS 3750.13 Type 1

RESISTANCE GUIDE

WEATHERABILITY	Protects steel from corrosion for up to 6 months without topcoat. 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 120°C dry heat	WATER	Suitable for immersion in fresh and salt water when suitably topcoated
SALTS	Excellent resistance to neutral and alkaline salts when suitably topcoated	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	Good when fully cured

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Two pack epoxy primer	APPLICATION CONDITIONS			
FINISH	Low Gloss		Min	Max	
COLOUR	Red Oxide	Air Temp.	10°C	45°C	
		Substrate Temp.	10°C	45°C	
		Relative Humidity		85%	
COMPONENTS	Two	COATING THICKNESS (MICRONS)			
VOLUME SOLIDS	28%		Min	Max	Recommended
VOC LEVEL	<640 g/L	Wet film per coat (µm)	70	140	90
FLASH POINT	4°C	Dry film per coat (µm)	20	40	25
POT LIFE	8 hours (20 litre kit, 25°C)	SUITABLE SUBSTRATES	Abrasive blast cleaned steel		
MIXING RATIO V/V	Part A : 3 Part B : 1	PRIMERS	Not applicable		
THINNER	920-08925 Dulux® Epoxy Thinner	TOPCOATS	Most single and two pack Dulux® topcoats		
PRODUCT CODE	731-63050 Part A 976-63100 Hardener	APPLICATION METHODS	Conventional, airless spray or air assisted spray		

DRYING CHARACTERISTICS AT 25 µm DRY FILM THICKNESS*

Temperature	Humidity	Touch	Handle	Full Cure	OVERCOAT	
					Min	Max ¹
25° C	50%	5 Minutes	8 Hours	7 Days	8 Hours	6 months

*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.

NOTE: Figures shown are for non-immersion conditions. When used for immersion conditions the maximum overcoat interval is **3 days** at 25°C. The coating MUST be fully cured and solvent free prior to being placed in immersion. Refer to PRECAUTIONS section.

SPREADING RATE 11.6 square metres per litre equals 25 µm dry film thickness

ASSUMING NO LOSSES

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

LUXEPOXY® 66

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 OR MAINTENANCE	Immersion	Abrasive blast clean AS1627.4 Class 3.0	1 st Coat Luxepoxy® 66 2 nd Coat Durebild® HSE 3 rd Coat Durebild® HSE	25 µm 200 µm 200 µm
STEEL NEW OR MAINTENANCE	Immersion	Abrasive blast clean AS1627.4 Class 3.0	1 st Coat Luxepoxy® 66 2 nd Coat Duremax® GPE 3 rd Coat Duremax® GPE	25 µm 125 µm 125 µm
STEEL – NEW	Fabrication yard	Abrasive blast clean AS1627.4 Class 2.5	1 st Coat Luxepoxy® 66	25 µm

NOTE: After storage of the fabricated and blast primed steel, the steel must be abrasive blast cleaned to remove the holding primer. This should be a relatively quick process, as the steel had already been blasted and the holding primer is of a fairly low film thickness.

SURFACE PREPARATION	<p>Steel: Round off all rough welds, sharp edges and remove weld spatter. Remove grease, oil and other contaminants in accordance with AS1627.1. Degrease with Gamlen CA 1 (a free-rinsing, alkaline detergent) according to the manufacturer's written instructions and all safety warnings. Abrasive blast clean to a minimum of AS1627.4 Class 2.5 with a blast profile of 40 – 70 microns. Remove all dust brushing or vacuum.</p> <p>Immersion steel: Abrasive blast clean to AS1627.4 Class 3. Remove all dust by brushing or vacuum cleaning.</p>												
APPLICATION	<p>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.</p>												
BRUSH/ROLLER	Not recommended												
CONVENTIONAL SPRAY	<p>Thinning is not normally required, but up to 100 ml/litre of Dulux® Epoxy Thinner (920-08925) can be added to aid atomization.</p> <table border="0"> <tr> <td>Typical Set-up</td> <td>Graco AirPro:</td> <td>1.8mm (239543)</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>340-410 kPa (50-60 p.s.i.)</td> </tr> </table>				Typical Set-up	Graco AirPro:	1.8mm (239543)		Pressure at Triton 308:	70-100 kPa (10-15 p.s.i.)		Pressure at Gun:	340-410 kPa (50-60 p.s.i.)
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AIRLESS SPRAY	<p>Standard airless spray equipment such as a Graco Xtreme 28:1 pump ratio with a fluid tip of 15 -19 thou (0.38-0.48mm) 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 ease application</p>												
PRECAUTIONS	<p>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 10°C. Do not apply at relative humidity above 85% or when the surface is less than 3°C above the dewpoint. When used for immersion conditions the maximum overcoat interval is 3 days at 25°C. The coating MUST be fully cured and solvent free prior to being placed under immersion conditions.</p>												
CLEAN UP	Clean all equipment with Dulux® Epoxy Thinner (920-08925) immediately after use												
OVERCOATING	<p>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.</p>												
SAFETY PRECAUTIONS	<p>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</p>												
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

DuluxGroup (Australia) Pty Ltd
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DuluxGroup (New Zealand) Pty Ltd
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A.B.N. 55 133 404 118

PACKAGING, TRANSPORT AND STORAGE

PACKAGING	Available in 20 litre packs
TRANSPORTATION WEIGHT	1.26 kg/litre (Average of components)
DANGEROUS GOODS	Part A: Class 3 UN 1263 Part B: Class 3 UN 1866

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