LUXEPOXY® FILLER
Two component epoxy filler for steel and concrete
PC 241

FEATURES
• SHRINK FREE AND SOLVENT FREE
• CHEMICAL RESISTANT
• SUITABLE FOR CONTACT WITH POTABLE WATER
• CONVENIENT, EASY TO USE CARTRIDGE PACK

USES
LUXEPOXY® FILLER is a versatile, non-shrink epoxy filler. LUXEPOXY® FILLER is ideal for filling cracks and defects in concrete in areas subject to aggressive chemical and marine environments, such raw and treated sewage and off shore structures. It is also suitable to repair construction defects in steel and concrete such as porous and discontinuous welds, blow holes and other isolated defects. It is highly efficient at filling in and around steel concrete joints to prevent moisture ingress. It can also be applied to damp concrete surfaces.

LUXEPOXY® FILLER is ideally suited for the repairs of concrete to be coated in epoxy tank lining products in waste treatment plants and potable water storage tanks.

SPECIFICATIONS
AS4020 for use with potable water.

RESISTANCE GUIDE

WEATHERABILITY
Epoxies yellow with time and chalk on exterior exposure. Neither yellowing nor chalking detracts from the protective properties of the product. Use a weatherable topcoat if required for appearance.

SOLVENTS
Suitable for immersion in aromatic and aliphatic hydrocarbons and refined petroleum products.

HEAT RESISTANCE
Up to 120°C dry heat

WATER
Excellent resistance to immersion in fresh and salt water

SALTS
Excellent resistance to neutral and alkali 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

APPLICATION CONDITIONS
Air Temp. Substrate Temp. Relative Humidity Concrete Moisture
Min 10°C 10°C 85% <10%
Max 45°C 45°C 85%

FINISH
Low sheen

SUITEABLE SUBSTRATES
Abrasive blast cleaned steel and prepared concrete

COLOUR
Light grey

TOPCOATS
Most Dulux® Two pack topcoats

COMPONENTS
Two

APPLICATION METHODS
600 ml Cartridge Pack

VOLUME SOLIDS
100%

PRODUCT CODE
N95PC022 Grey

VOC LEVEL
<10 g/L

DRYING CHARACTERISTICS @ 3,000 μm DRY FILM THICKNESS*

<table>
<thead>
<tr>
<th>Temperature</th>
<th>Humidity</th>
<th>Touch</th>
<th>Handle</th>
<th>Full Cure</th>
<th>Min</th>
<th>Max1</th>
</tr>
</thead>
<tbody>
<tr>
<td>10° C</td>
<td>50%</td>
<td>10 Hours</td>
<td>30 Hours</td>
<td>7 Days</td>
<td>30 Hours</td>
<td>48 Hours</td>
</tr>
<tr>
<td>15° C</td>
<td>50%</td>
<td>7 Hours</td>
<td>24 Hours</td>
<td>7 Days</td>
<td>24 Hours</td>
<td>36 Hours</td>
</tr>
<tr>
<td>25° C</td>
<td>50%</td>
<td>4 Hours</td>
<td>13 Hours</td>
<td>7 Days</td>
<td>13 Hours</td>
<td>24 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.
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.

USAGE
ASSUMING NO LOSSES

When filling a crevice 2mm wide x 3mm deep a 600ml kit of Luxepoxy® Filler will fill up to 100 lineal metres

NOTE: Practical usage will vary depending on ambient conditions and surface roughness.
**LUXEPOXY® FILLER**

**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.

<table>
<thead>
<tr>
<th>SURFACE</th>
<th>ENVIRONMENT</th>
<th>PREPARATION GUIDE</th>
<th>SYSTEM</th>
<th>DFT (μm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>STEEL NEW OR</td>
<td>Interior -</td>
<td>Abrasive blast clean AS1627.4</td>
<td>REPAIRS</td>
<td>N/A</td>
</tr>
<tr>
<td>MAINTENANCE</td>
<td>immersion</td>
<td>Class 3.0</td>
<td>1st Coat</td>
<td>LuxePOXY® Filler 2,000 μm</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>2nd Coat</td>
<td>LuxePOXY® UHB</td>
</tr>
<tr>
<td>CONCRETE</td>
<td>Interior -</td>
<td>Remove release agents and other surface contaminants. Whip blast to remove laitance.</td>
<td>REPAIRS</td>
<td>N/A</td>
</tr>
<tr>
<td></td>
<td>immersion</td>
<td></td>
<td>1st Coat</td>
<td>LuxePOXY® Filler 40 μm</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>2nd Coat</td>
<td>LuxePOXY® Sealer 2,500 μm</td>
</tr>
<tr>
<td>CONCRETE</td>
<td>Exterior</td>
<td>Remove release agents and other surface contaminants</td>
<td>REPAIRS</td>
<td>N/A</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>1st Coat</td>
<td>LuxePOXY® Filler 125 μm</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>2nd Coat</td>
<td>Weathermax® HBR 100 μm</td>
</tr>
</tbody>
</table>

**NOTE:** If application is by brush or roller, additional coats will be necessary to achieve the minimum DFT and full opacity. Ensure repair area is clean and dry.

**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. 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.

**Immersed steel:** Abrasive blast clean to AS1627.4 Class 3. Remove all dust by brush or vacuum cleaning.

**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.

**APPLICATION**

**CARTRIDGE MIX**

Remove the black retaining nut from the cartridge and take out the plug from each cylinder, (if whole kit is not to be used ensure plugs do not get mixed up). Attach the static mixer nozzle to the cartridge with the nut and tighten firmly. Load the cartridge into the dispensing gun and extrude a small amount of epoxy until a uniform grey streak free, consistency is achieved. Put the mixing nozzle into the hole/area to be filled and dispense the required amount of epoxy. If required, it can be made smooth with a trowel moistened with Dulux® Epoxy Thinner (920-08925).

Clean all tools and equipment immediately after use with Dulux® Epoxy Thinner (920-08925). Do not reuse the static mixing nozzle. The cartridge may be resealed with the original plugs for future use. Do not mix the plugs from A to B.

**PRECAUTIONS**

This is an industrial product designed for use by experienced Protective Coating applicators. Where conditions may require variation from the recommendations, please contact our Customer Service (13 23 77) or www.duluxprotectivecoatings.com.au

**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 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 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. Do not use this product in a static environment. Risk of explosion. 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

DuluxGroup (New Zealand) Pty Ltd

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