

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 as 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		
FINISH	Low sheen		Min	Max
COLOUR	Light grey	Air Temp.	10°C	45°C
		Substrate Temp.	10°C	45°C
		Relative Humidity		85%
		Concrete Moisture		<10%
COMPONENTS	Two	SUITABLE SUBSTRATES	Abrasive blast cleaned steel and prepared concrete	
VOLUME SOLIDS	100%	TOPCOATS	Most Dulux® Two pack topcoats	
VOC LEVEL	<10 g/L	APPLICATION METHODS	600 ml Cartridge Pack	
FLASH POINT	> 150°C			
POT LIFE	20 Min (25°C)			
MIXING RATIO V/V	Part A : 1 Part B : 1			
THINNER	920-08925 Dulux® Epoxy Thinner			
PRODUCT CODE	N95PC022 Grey			

DRYING CHARACTERISTICS @ 3,000 µm DRY FILM THICKNESS*

Temperature	Humidity	Touch	Handle	Full Cure	OVERCOAT	
					Min	Max ¹
10° C	50%	10 Hours	30 Hours	7 Days	30 Hours	48 Hours
15° C	50%	7 Hours	24 Hours	7 Days	24 Hours	36 Hours
25° C	50%	4 Hours	13 Hours	7 Days	13 Hours	24 Hours

*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.

SURFACE	ENVIRONMENT	PREPARATION GUIDE	SYSTEM	DFT (µm)
STEEL NEW OR MAINTENANCE	Interior – immersion	Abrasive blast clean AS1627.4 Class 3.0	REPAIRS 1 st Coat Luxepoxy® Filler Luxepoxy® UHB	N/A 2,000 µm
CONCRETE	Interior – immersion	Remove release agents and other surface contaminants. Whip blast to remove laitance.	REPAIRS 1 st Coat 2 nd Coat Luxepoxy® Filler Luxepoxy® Sealer Flexituff®	N/A 40 µm 2,500 µm
CONCRETE	Exterior	Remove release agents and other surface contaminants	REPAIRS 1 st Coat 2 nd Coat Luxepoxy® Filler Durebild® STE Weathermax® HBR	N/A 125 µm 100 µm

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	<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>Immersed steel: Abrasive blast clean to AS1627.4 Class 3. Remove all dust by brushing or vacuum cleaning.</p> <p>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.</p>
APPLICATION CARTRIDGE MIX	<p>This system requires a special application dispenser gun available from Dulux® Protective Coatings.</p> <p>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.</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. 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. Concrete tanks will need to be emptied in advance of the filler being applied to allow the moisture content of the concrete to fall below the maximum of 12%. Do not apply over water proofing compounds. The filler MUST be fully cured prior to being placed under immersion conditions. This material MUST NOT be thinned. This product is a rigid filler and is not suitable for use on flexible substrates or in construction and movement joints.</p>
CLEAN UP	Clean all tools and equipment immediately after use with Dulux® Epoxy Thinner (920-08925)
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	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. 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 600ml Kits
TRANSPORTATION WEIGHT	1.14 kg/litre (Average of components)
DANGEROUS GOODS	Part A: Non Dangerous Goods Part B: Non Dangerous Goods

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