

DURECURE[®] PAC

Direct to Prepared Metal Polyaspartic Coating

PC 750

- FEATURES**
- CONTAINS CORROSION INHIBITING PIGMENT
 - INCREASE PRODUCTIVITY, NO PRIMER REQUIRED IN MILD CORROSIVE CONDITIONS
 - GOOD UV RESISTANCE AND GLOSS RETENTION
 - EXCELLENT DRYING AND RECOAT PROPERTIES
 - AVAILABLE IN GLOSS FINISH

USES DURECURE[®] PAC is a two-component polyaspartic coating that incorporates rust inhibitive pigmentation, allowing for direct application to abrasive blast or power tool cleaned steel. For more severe corrosive environments (C4) DURECURE[®] PAC can be used over a specified Dulux[®] Protective Coatings range of zinc rich primer as a fast drying intermediate/topcoat. In mild to moderate (C1-3) environments, one coat of DURECURE[®] PAC provides an alternative to a two-coat system. The fast curing and direct to metal properties of DURECURE[®] PAC allows for the fast coating of steel – allowing for quicker return to service of assets and improve throughput. Typical areas of application of DURECURE[®] PAC include structural frames and trusses for factories and warehouses, farm and heavy engineering equipment.

SPECIFICATIONS
RESISTANCE GUIDE

WEATHERABILITY	Good 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 incidental splash and spillage of most common alkalis
ACIDS	Good resistance to incidental splash and spillage of most common acids	ABRASION	Good when fully cured

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Two pack polyaspartic coating		APPLICATION CONDITIONS			
FINISH	Gloss			Min	Max	
COLOUR	White and an extensive range of tinted colours		Air Temp.	10°C	40°C	
			Substrate Temp.	10°C	40°C	
			Relative Humidity		80%	
COMPONENTS	Two		COATING THICKNESS (MICRONS)			
VOLUME SOLIDS	72 ± 4%			Min	Max	Recommended
VOC LEVEL	<260 g/L		Wet film per coat (µm)	115	170	140
FLASH POINT	25°C		Dry film per coat (µm)	80	120	100
POT LIFE	30 minutes (4 litre kit, 25°C)					
MIXING RATIO V/V	Part A : 3	Part B : 1	SUITABLE SUBSTRATES	Abrasive blast cleaned, hand cleaned or power tool cleaned metal		
THINNER –BRUSH	965-H0189	Dulux [®] Duthin 799	PRIMERS	Dulux [®] Protective Coatings range of epoxy primers		
THINNER –SPRAY	965-H0189	Dulux [®] Duthin 799	APPLICATION METHODS	Conventional and airless spray		
PRODUCT CODE	768-63001	Gloss Light Base				
	768-63003	Gloss Clear Base				
	768-00026	Gloss White Base				
	976-H0225	Standard Hardener				

DRYING CHARACTERISTICS AT 100 µm DRY FILM THICKNESS

Temperature	Humidity	Touch	Handle	Full Cure	OVERCOAT*	
					Min	Max**
10° C	50%	3 Hours	9 Hours	7 Days	9 Hours	7 days
15° C	50%	2 Hours	6 Hours	7 Days	6 Hours	7 days
25° C	50%	1 Hour	3 Hours	7 Days	3 Hours	7 days

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

** If the maximum recoat time has been exceeded, then the surface MUST be abraded to ensure intercoat adhesion.

SPREADING RATE

ASSUMING NO LOSSES

7.2 square metres per litre equals 100 µm dry film thickness

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

DURECUR® PAC

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 Representative.

SURFACE	ENVIRONMENT	PREPARATION GUIDE	SYSTEM	DFT (µm)
STEEL – NEW	High (AS2312.1 Cat C4). Equivalent to PUR4	Abrasive blast clean Class 2.5	AS1627.4 1 st Coat Zincode® 402 2 nd Coat Durecure® PAC 3 rd Coat Durecure® PAC	75 µm 100 µm 100 µm

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

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 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. 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.
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 with a power mixer (minimum 5 mins) 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. Thin with up to 100 ml/litre with Dulux® Duthin 799 (965-H0189) to aid application. When brushing and rolling additional coats may be required to attain the specified thickness.
CONVENTIONAL SPRAY	Thin up to 150ml/litre with Dulux® Duthin 799 (965-H0189) to aid atomisation. Apply in multiple wet coats overlapping each pass 50%. Typical Set-up Graco AirPro 1.8mm (239543) 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 15-17 thou (0.38-0.43mm) 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 100 ml/litre of Dulux® Duthin 799 (965-H0189) may be added to aid application.
PRECAUTIONS	This is an industrial product designed for use by experienced Protective Coating applicators. Ensure that you read and understand the safety precautions on the relevant Safety Data Sheets before using. The surface to be coated must be totally free of moisture and contaminants. Do not apply at temperatures below 10°C. Do not apply at relative humidity above 80% or when the surface is less than 3°C above the dewpoint. The rate of cure is dependent upon temperature. Where application conditions are outside the parameters stated in this Product Data Sheet, or where any variation to the recommendations are sought, contact your Dulux® Consultant for written specifications prior to application. 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® Duclean® 646 (965-H0226) 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 must be worn while handling and using. Always wash hands before smoking, eating, drinking or using the toilet.
USING	Use with good ventilation and avoid inhalation of spray mists and fumes. When spraying, wear combined organic vapour/particulate respirator. Users must always comply with their 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	PACKAGING, TRANSPORT AND STORAGE							
Dulux Protective Coatings a division of DuluxGroup (Australia) Pty Ltd 1956 Dandenong Road, Clayton 3168 A.B.N. 67 000 049 427	<table border="1"> <thead> <tr> <th>PACKAGING</th> <td>Available in 15 litre packs</td> </tr> <tr> <th>TRANSPORTATION WEIGHT</th> <td>1.68 kg/litre (Average of components)</td> </tr> <tr> <th rowspan="2">DANGEROUS GOODS</th> <td>Part A: Class 3 UN 1263</td> </tr> <tr> <td>Part B: Class 3 UN 1263</td> </tr> </thead> </table>	PACKAGING	Available in 15 litre packs	TRANSPORTATION WEIGHT	1.68 kg/litre (Average of components)	DANGEROUS GOODS	Part A: Class 3 UN 1263	Part B: Class 3 UN 1263
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DuluxGroup (New Zealand) Pty Ltd 150 Hutt Park Road, Lower Hutt, NZ A.B.N. 55 133 404 118								

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