

LUXAPRIME® ETCH

Industrial Etch Primer

PC 629

- FEATURES**
- RAPID DRY AND FAST RECOAT
 - IDEAL FOR PRIMING MOST FERROUS AND NON FERROUS METALS
 - WIDE RANGE OF TOPCOAT TYPES CAN BE USED

USES LUXAPRIME® ETCH is a fast dry etch primer for shop or site application over suitably prepared metal substrates including mild steel, zinc coated steel, aluminium and other non-ferrous metals.

LUXAPRIME® ETCH is designed for applications where high adhesion, fast turn around and single pack convenience are required. LUXAPRIME® ETCH can be used as a full primer or spot primer under a range of topcoats.

SPECIFICATIONS

RESISTANCE GUIDE

WEATHERABILITY	Will chalk on exterior exposure. Use a weatherable topcoat.	SOLVENTS	Resists splash and spillage of aliphatic and aromatic hydrocarbons with a suitable topcoat
HEAT RESISTANCE	Up to 65°C dry heat with a suitable topcoat	WATER	Resists rain and condensation when suitably topcoated. Not recommended for permanently damp or immersed exposure
SALTS	Unaffected by splash and spillage of most salt solutions with a suitable topcoat	ALKALIS	Suitable for splash and spillage exposure to weak alkalis with suitable topcoat
ACIDS	Suitable for splash and spillage exposure to weak acids with suitable topcoat	ABRASION	Fair with a suitable topcoat

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Industrial etch primer	APPLICATION CONDITIONS			
FINISH	Low Sheen		Min	Max	
COLOUR	Light Grey Medium Dark Grey (MTO) Black (MTO)	Air Temp.	10°C	40°C	
		Substrate Temp.	10°C	40°C	
		Relative Humidity		85%	
COMPONENTS	One	COATING THICKNESS (MICRONS)			
VOLUME SOLIDS	17%		Min	Max	Recommended
VOC LEVEL	<750 g/L	Wet film per coat (µm)	60	90	60
FLASH POINT	11.7°C	Dry film per coat (µm)	10	15	10
POT LIFE	Not applicable	SUITABLE SUBSTRATES	Mild steel, aluminium and galvanized steel		
MIXING RATIO V/V	Single pack	PRIMERS	N/A		
THINNER – BRUSH	Not applicable	TOPCOATS	Specified Dulux® Protective Coatings topcoats		
THINNER – SPRAY	920-81942 Dulux® Duthin® 450 965-63023 Dulux® Urethane Thinner	APPLICATION METHODS	Conventional spray and HVLP spray		
PRODUCT CODE	866-H0183 Light Grey 866-H0191 Medium Dark Grey (MTO) 866-00070 Black (MTO)				

DRYING CHARACTERISTICS AT 10 µm DRY FILM THICKNESS*

Temperature	Humidity	Touch	Handle	Full Cure	OVERCOAT	
					Min	Max ¹
25°C	50%	10 Minutes	30 Minutes	45 Minutes	10 Minutes	4 Weeks

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

SPREADING RATE ASSUMING NO LOSSES

17.0 square metres per litre equals 10 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)
STEEL – NEW	Low corrosivity (AS2312.1 Cat C1-2)	Power tool clean AS1627.2	1 st Coat Luxaprime® Etch 2 nd Coat Metalshield® Premium Enamel	10 µm 50 µm
NON FERROUS METALS	Exterior/Interior	Clean, degrease and abrade surface	1 st Coat Luxaprime® Etch 2 nd Coat Metalshield® Premium Enamel	10 µm 50 µm
NON FERROUS METALS	Exterior/Interior	Clean, degrease and abrade surface	1 st Coat Luxaprime® Etch 2 nd Coat Luxathane® HPX	10 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	<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 cleaning not normally required. If abrasive blasting then prepare to a minimum of AS1627.4 Class 2.5. Blast profile will typically exceed primer film thickness and care must be taken to avoid pinpoint rusting of exposed profile. Remove all dust by brushing or vacuum. Steel where abrasive blast cleaning is not viable: Rust, mill scale, oxide deposits and old paint films on metal surfaces must be removed by power tool cleaning according to AS1627.2 Class 2. Coating performance is proportional to the degree of surface preparation.</p> <p>Hot Dipped Galvanized (HDG) Surfaces: Round off all sharp edges and repair galvanizing defects. 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. Whip (sweep) blast in accordance with AS 2312.2, Section 7.5.3.2. NOTE: It is important that this procedure be performed carefully to ensure that no more than 10µm of zinc is removed. Where abrasive blasting is not viable degrease as above. Rinse off and prime as soon as the surface is dry.</p> <p>Other 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.</p>																					
APPLICATION	Mix thoroughly using a power mixer until the contents are uniform. Remix thoroughly before application.																					
EQUIPMENT	<p>Brush / Roller: Recommended only for spot patching on rivets, seams, etc.</p> <p>Air Spray: Thinning not required but up to 50ml/litre or 5% per litre with Dulux® Duthin® 450 (920-81942) or Dulux® Urethane Thinner (965-63023) may be used to aid atomisation. Apply in multiple wet coats overlapping each pass 50%.</p> <table border="1"> <thead> <tr> <th colspan="7">Typical air spray set up – Graco Triton 308</th> </tr> <tr> <th>Gun</th> <th>Fluid Tip</th> <th>Air Cap</th> <th>Air Hose ID</th> <th>Mat'l Hose ID</th> <th>Atomising Pressure</th> <th>Pot Pressure</th> </tr> </thead> <tbody> <tr> <td>Graco Air Pro or Equivalent</td> <td>1.4 mm (0.055")</td> <td>Graco 289773</td> <td>7.9 or 9.5 mm (5/16" or 3/8")</td> <td>(9.5 or 12.7 mm) 3/8" or 1/2"</td> <td>55 to 60 PSI (3.79–4.14 Bar)</td> <td>10 to 15 PSI (0.7–1.03 Bar)</td> </tr> </tbody> </table> <p>Airless Spray: Not recommended</p>	Typical air spray set up – Graco Triton 308							Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomising Pressure	Pot Pressure	Graco Air Pro or Equivalent	1.4 mm (0.055")	Graco 289773	7.9 or 9.5 mm (5/16" or 3/8")	(9.5 or 12.7 mm) 3/8" or 1/2"	55 to 60 PSI (3.79–4.14 Bar)	10 to 15 PSI (0.7–1.03 Bar)
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PRECAUTIONS	This is an industrial product designed for use by experienced Protective Coatings applicators. Where conditions may require variation from the recommendations on this Product Data Sheet contact your nearest Dulux® Protective Coatings Consultant for advice prior to painting. Do not apply in conditions outside the parameters stated in this document without the written consent of Dulux® Protective Coatings Australia. Do not apply at temperatures below 5°C. Do not apply at relative humidity above 85% or when the surface is less than 3°C above the dewpoint. Do not apply over scale bearing steel. Abrasive blast cleaned surfaces must be primed within 4 hours. Excessive film thickness should be avoided as this may result in delamination.																					
CLEAN UP	Clean all equipment with Dulux® Duthin® 450 (920-81942) or Dulux® Urethane Thinner (965-63023) immediately after use.																					
OVERCOATING	For atmospheric service: Degrease with Gamlen CA 1 according to the data sheet. Test adhesion of existing coating by standard cross hatch adhesion test in accordance with AS3894.9. If the coating has an adhesion rating worse than "2" as per Table 1 in this Standard, remove it. High-pressure water wash at 8.3 to 10.3 MPa (1,200-1,500 p.s.i.) using a 25" or greater tip 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 bunded 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 to beyond the heat affected zone before welding. Repair this area following the surface preparation and coating recommendations of this technical data sheet.																					

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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PACKAGING, TRANSPORT AND STORAGE

PACKAGING Available in 15 litre cans
 TRANSPORTATION WEIGHT 1.08 kg/litre
 DANGEROUS GOODS Class 3 UN 1263

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