

DUREPON® 66

Two Pack Epoxy Holding Primer

PC 202

- FEATURES**
- PREFABRICATION HOLDING PRIMER
 - PROTECT STEEL FROM CORROSION FOR AN EXTENDED PERIOD
 - CAN BE OVERCOATED WITH A WIDE RANGE OF SINGLE AND TWO PACK COATINGS

USES DUREPON® 66 is recommended for use over freshly abrasive blast cleaned steel to protect against corrosion during transport or storage.

DUREPON® 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, conventional alkyds and polyurea.

SPECIFICATIONS AS/NZ 4020:2018 – compliant for use in potable water when used in conjunction with a certified coating system. Refer to a Dulux Protective Coatings Consultant for details of the system.

RESISTANCE GUIDE

WEATHERABILITY	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	Very good resistance to neutral and alkaline salts when suitably topcoated	ALKALIS	Good resistance to splash and spillage of most common alkalis when suitably topcoated.
ACIDS	Good resistance to splash and spillage of weak solutions of inorganic acids	ABRASION	Fair when fully cured

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Two pack epoxy primer		APPLICATION CONDITIONS			
FINISH	Matt			Min	Max	
COLOUR	Red Oxide		Air Temp.	10°C	40°C	
			Substrate Temp.	10°C	40°C	
			Relative Humidity		85%	
COMPONENTS	Two		COATING THICKNESS (MICRONS)			
VOLUME SOLIDS	25%			Min	Max	Recommended
VOC LEVEL	<670 g/L		Wet film per coat (µm)	70	160	100
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	Recommended	Dulux®	Protective Coatings topcoats
PRODUCT CODE	410-H0307	Part A	APPLICATION METHODS	Conventional or airless spray only		
	976-H0315	Standard Hardener				

DRYING CHARACTERISTICS AT 25 µm DRY FILM THICKNESS*

Temperature	Humidity	Touch	Handle	Full Cure	OVERCOAT	
					Min	Max ¹
25° C	50%	10 Minutes	8 Hours	7 Days	8 Hours	Extended

*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 10.0 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.

DUREPON® 66

SURFACE PREPARATION	<p>After storage of the fabricated and blast primed steel, the steel must be abrasive blast cleaned to remove the holding primer.</p> <p>Steel: Round off all rough welds, sharp edges and remove weld spatter. Degrease in accordance with AS1627.1. Abrasive blast clean to a minimum of AS1627.4 Class 2.5</p> <p>Immersed steel: Abrasive blast clean to AS1627.4 Class 3. Remove all dust by brushing or vacuum cleaning.</p> <p>Profile: The required uniform angular anchor profile will depend upon the Dulux system being used. Consult your Dulux Protective Coatings Consultant.</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. Remix thoroughly before application.</p>																						
APPLICATION EQUIPMENT	<p>Airless Spray: Graco Z45 spray pump or equivalent Thinning is not normally required but up to 50 ml/litre or 5% of Dulux® Epoxy Thinner (920-08925) may be added to aid application. Apply in multiple wet coats overlapping each pass 50%.</p> <table border="1"> <thead> <tr> <th>Tip Orifice</th> <th>Atomising Pressure</th> <th>Mat'l Hose ID</th> <th>Pump Manifold Filter</th> </tr> </thead> <tbody> <tr> <td>0.015" – 0.019" (381 - 483 microns)</td> <td>1,500 – 2,000 psi (103 – 138 bar)</td> <td>1/4" or 3/8" (6.35 or 9.5 mm)</td> <td>60 mesh (250 microns)</td> </tr> </tbody> </table> <p>NOTE: A 2 metre x 1/4" (6.35mm) whip hose is allowed at the end of a 3/8" material hose for greater ease of application.</p> <p>Air Spray: Graco 308 Triton equivalent. Thinning is not normally required but up to 50 ml/litre or 5% of Dulux® Epoxy Thinner (920-08925) may be added to aid application. Apply in multiple wet coats overlapping each pass 50%.</p> <table border="1"> <thead> <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>1.8 mm (0.070)</td> <td>Graco 192318</td> <td>5/16" or 3/8" (7.9 or 9.5 mm)</td> <td>3/8" or 1/2" (9.5 or 12.7 mm)</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>NOTE: Low temperatures and/or long hose lengths require higher material pressure.</p> <p>Roller: Not recommended.</p> <p>Brush: Not recommended.</p>	Tip Orifice	Atomising Pressure	Mat'l Hose ID	Pump Manifold Filter	0.015" – 0.019" (381 - 483 microns)	1,500 – 2,000 psi (103 – 138 bar)	1/4" or 3/8" (6.35 or 9.5 mm)	60 mesh (250 microns)	Gun	Fluid Tip	Air Cap	Air Hose ID	Mat'l Hose ID	Atomising Pressure	Pot Pressure	Graco Air Pro or Equivalent	1.8 mm (0.070)	Graco 192318	5/16" or 3/8" (7.9 or 9.5 mm)	3/8" or 1/2" (9.5 or 12.7 mm)	55 to 60 PSI (3.79 – 4.14 Bar)	10 to 15 PSI (0.7 – 1.03 Bar)
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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® Protective Coatings 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® Protective Coatings 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 in conjunction with an immersion grade Dulux coating, 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. Do not use this product for this application without consulting a Dulux® Protective Coatings Consultant.</p>																						
CLEAN UP	<p>Clean all equipment with Dulux® Epoxy Thinner (920-08925) immediately after use</p>																						
OVERCOATING	<p>Only recommended for application to a freshly prepared steel surface as part of a coating system specification.</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	<p>Store as required for a flammable liquid Class 3 in a bunded area undercover. Store in a well-ventilated area away from sources of heat or ignition. Keep containers closed at all times.</p>																						
HANDLING	<p>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.</p>																						
USING	<p>Use with good ventilation and avoid inhalation of spray mists and fumes. If the 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.</p>																						
FLAMMABILITY	<p>This product is flammable. All sources of ignition must be eliminated in, or near the working area. DO NOT SMOKE. Fight fire with foam, CO₂ or dry chemical powder. On burning will emit toxic fumes.</p>																						
WELDING	<p>Avoid inhalation of fumes if welding surfaces coated with this paint. Grind off coating before welding.</p>																						

COMPANY INFORMATION

Dulux Protective Coatings a division of
 DuluxGroup (Australia) Pty Ltd
 1956 Dandenong Road, Clayton 3168
 A.B.N. 67 000 049 427

DuluxGroup (New Zealand) Pty Ltd
 150 Hutt Park Road, Lower Hutt, NZ
 A.B.N. 55 133 404 118

PACKAGING, TRANSPORT AND STORAGE

PACKAGING	Available in 20 litre packs
TRANSPORTATION WEIGHT	1.22 kg/litre (Average of components)
DANGEROUS GOODS	Part A: Class 3 UN 1263
	Part B: Class 3 UN 1263

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