Dulux PROTECTIVE COATINGS

LUXEPOXY® UHB

Ultra High Build Epoxy — PC 240

FEATURES
- SOLVENT FREE
- 100% VOLUME SOLIDS
- ULTRA HIGH BUILD – UP TO 3,000 MICRONS IN ONE COAT

USES LUXEPOXY® UHB is designed for long life protection of steel and concrete in areas subject to aggressive chemical or marine environments, including water and soil immersion. Due to its tough, abrasion resistant feature, LUXEPOXY® UHB is recommended as a single-coat protection for oil platform conductors, jacket legs and difficult to maintain seabed installations.

LUXEPOXY® UHB is also suited for the protection of concrete the water and wastewater treatment industry.

SPECIFICATIONS AS/NZ 4020:2005 – suitable for use with potable water when using untinted Light Grey cured with Standard Hardener only. Refer to your Dulux Protective Coatings Consultant for details.

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**	Suitable for immersion in aromatic and aliphatic hydrocarbons and refined petroleum products.
		WATER	Excellent resistance to immersion in fresh and salt water.
HEAT RESISTANCE	Up to 120°C dry heat.	**ALKALIS**	Excellent resistance to splash and spillage of most common alkalis.
SALTS	Excellent resistance to neutral and alkaline salts.	**OILS & FATS**	Excellent resistance to mineral and vegetable oils and fats. Not suitable for prolonged contact with fatty acids.
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
FINISH	Low Sheen
COLOUR	Light Grey (approximate match to AS2700 N35) and a limited range of MTO factory made colours
COMPONENTS	Two
VOLUME SOLIDS	100%
VOC LEVEL	<10 g/L
FLASH POINT	Above 150°C
POT LIFE	20 Min (18 litre kit, 25°C)
MIXING RATIO V/V	Part A : 1 Part B : 1
THINNER	DO NOT THIN
CLEAN UP	920-08925 Dulux® Epoxy Thinner
PRODUCT CODE	742-50688 Light Grey
	742-60469 Black (MTO)
	976-50689 Hardener

APPLICATION CONDITIONS

	Min	Max
Air Temp.	10°C	40°C
Substrate Temp.	10°C	40°C
Relative Humidity		85%
Concrete Moisture		<6%

COATING THICKNESS (MICRONS)

	Min	Max	Recommended
Wet film per coat (µm)	1,000	5,000	3,000
Dry film per coat (µm)	1,000	5,000	3,000

SUITABLE SUBSTRATES	Abrasive blast-cleaned steel or prepared concrete
PRIMERS	Not required
TOPCOATS	Not applicable
APPLICATION METHODS	Single and plural component airless spray

DRYING CHARACTERISTICS AT 3,000 µm DRY FILM THICKNESS

					OVERCOAT	
Temperature	**Humidity**	**Touch**	**Handle**	**Full Cure[1]**	**Min**	**Max[2]**
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.

[1] The coating MUST be fully cured and solvent free prior to being placed under immersion conditions.

[2] **If the maximum overcoat interval is exceeded then the surface MUST be abraded to ensure maximum intercoat adhesion.**

SPREADING RATE ASSUMING NO LOSSES

0.3 square metres per litre equals 3,000 µm dry film thickness

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

LUXEPOXY® UHB

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	Immersion	Abrasive blast clean AS1627.4 Class 3.0	1st Coat	Luxepoxy® UHB	3,000 µm
CONCRETE	Interior	Remove release agents and other surface contaminants	1st Coat 2nd Coat	Luxepoxy® UHB Luxepoxy® UHB	2,000 µm 2,000 µm

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. The surface must be free from grease, oil, dirt, rust and other contaminants. Degrease with Gamlen CA No. 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. **Immersed steel** must be prepared to AS1627.4 Class 3 with a blast profile of 75-100 microns. Remove all dust by brushing or vacuum cleaning. **Concrete**: Concrete must be at least 28 days old before coating. Remove all laitance, form release, curing compounds, oil, grease and other surface contaminants. Fill any large cracks or voids using Luxepoxy Filler. **Horizontal surfaces**: Diamond grind, track or light shot-blast concrete floors to remove laitance and provide suitable profile. Remove all dust by vacuum cleaning.

APPLICATION

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 immediately before use. Once mixed, use without delay. Ensure Dulux® Epoxy Thinner (920-08925) is available for cleaning equipment and lines immediately after use.

BRUSH/ROLLER

Suitable for small areas only such as rivets and seams. When brushing and rolling additional coats may be required to attain the specified thickness.

AIRLESS SPRAY

PLURAL COMPONENT AIRLESS UNITS: Airless spray unit capable of equal volume metering and heating such as a Graco 45:1 or 56:1 Xtreme. Mix with a fluid tip of 31 thou (0.79mm, 3 ¼ Twist Tip) or adjustable tip (Titan) and an air supply capable of delivering 690-830 kPa (100-120 p.s.i.) at the pump and a line size of 12 mm I.D.
PRE-MIX AIRLESS APPLICATION: Standard airless spray equipment such as a Graco 68:1 Xtreme with a fluid tip of 31 thou (79mm) and an air supply capable of delivering 690-830 kPa (100-120 p.s.i.) at the pump and a line size of 12mm I.D. Add the stirred components together in the supplied 1:1 ratio by volume and mix using a power mixer immediately prior to use. Use without further delay.

PRECAUTIONS

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. 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. Concrete tanks will need to be emptied in advance of coating application to allow the moisture content of the concrete to fall below the maximum of 12%. After the coating has cured, check for defects in the coating in accordance with AS 3891.4, and repair. Do not apply over water proofing compounds. The coating MUST be fully cured prior to being placed under immersion conditions. **DO NOT THIN**.

CLEAN UP

Clean all equipment with Dulux® Epoxy Thinner (920-08925) 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.

REPAIR

Within 24 hours at 25°C: Thoroughly solvent wash with Epoxy Thinner, allow the solvent to flash off and apply LUXEPOXY® UHB to the prepared area, overlapping sound coating by 70-100mm. **After 24 hours at 25°C**: Sweep blast or abrade with Grade 150 sandpaper or coarser and then solvent wash using Epoxy Thinner for areas of low film build or pin holes. Apply LUXEPOXY® UHB, overlapping sound coating by 70-100mm.

SAFETY PRECAUTIONS

Read the 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 a 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:

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 18 litre packs
TRANSPORTATION WEIGHT	1.14 kg/litre (Average of components)
DANGEROUS GOODS	Part A: Non Dangerous Goods Part B: Non Dangerous Goods