



Elastomeric Polyurea Lining

Flexituff® PU-1 and DM-8 Application Guide



Protection you can count on.

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1.0 Introduction

Dulux® Flexituff® PU-1 and Flexituff® DM-8 are spray-applied, 100% solids, flexible, two-component, 1:1 pure polyurea systems, designed to provide a seamless lining system via a plural component equipment application. It is ideal for application to steel or concrete in water and water treatment, secondary containment, and other various tank lining opportunities. Dulux® Flexituff® PU-1 is primarily used as a system over concrete, but can also be applied to steel with an appropriate primer. Dulux® Flexituff® DM-8 is mainly used in direct-to-metal applications.

Before starting work, read this guide carefully as it contains basic information necessary for the proper application of Dulux® Flexituff® pure polyurea options: PU-1 and DM-8. This guide is to be read in conjunction with the Technical Data Sheets (TDS) as well as project specifications. Inconsistencies must be resolved before starting work. Contact Dulux® Protective Coatings for more information.

1.1 What is Dulux® Flexituff® Polyurea and where is it used?

Dulux® Flexituff® is a two-component pure polyurea elastomer coating.

- Part A – 1 part isocyanate
- Part B – 1 part mixture of polyol and polyamine reactants. For this application guide this side will be referred to as the polyol side.

Product is applied via plural component equipment as described within the equipment recommendations stated below.

The aim of this manual is to provide relevant information to the applicator of Dulux® Flexituff® polyurea technology, helping to ensure the completed project is fit for purpose.

Applicators must not deviate from these guidelines without written agreement from Dulux® Protective Coatings.

1.2 Product Quality Assurance

All raw materials are subjected to ISO 9001:2015 registered quality testing systems before being released for manufacture.

1.3 Technical Support

To support our customers in the field we have experienced Technical Service who work in conjunction with our Dulux® Protective Coatings Consultants.

Note: Dulux® Flexituff® polyurea is an approved applicator product which training can only be carried out by Dulux® Protective Coatings Technical Services.

2.0 Surface Preparation and Priming

2.1 Steel Surface Preparation

Surface preparation and painting should be carried out in line with best industry practice as indicated in many publications by organisations such as NACE, SSPC, AMPP, ISO, ASTM, AS, etc. The standards of surface preparation contained herein are to be considered minimum requirements. Where other client or project specifications demand a higher level of surface preparation and/or cleanliness, then the higher level should be adopted. All steel surfaces to be protected by Dulux® Flexituff® polyurea must be correctly prepared.

All steel surfaces must be clean, dry and free from all surface contamination, refer to AS 1627.1 (similar to SSPC - SP1) and AS 3894-6 as may be specified, prior to abrasive blast cleaning per AS 1627.4 to a minimum standard of ISO 8501-1:2007 Sa 2½, (similar to NACE No.2 / SSPC-SP10). When abrasive blasting has been completed, all dust and debris created through this process must be removed from the prepared surface by use of a vacuum cleaner, dry, oil and moisture free compressed air and/or brush. Dulux® Flexituff® DM-8 can be applied directly to blast cleaned steel with an angular anchor surface profile of 75 to 100 µm.

2.2 Concrete Surface Preparation

Concrete must be at least 28 days old before coating. Remove all laitance, form release agents, curing compounds, oil, grease, and other surface contaminants. Diamond grind, track blast, light shot-blast or employ other mechanical method recommended within ICRI Guideline No. 310.2R which will provide a suitable profile for intended surface - ICRI CSP 2-3 for secondary containment walls and floors, ICRI CSP 5-6 for primary containment concrete tanks. Remove all dust by vacuum cleaning or other manner which fully removes the resultant debris.

Fill any bugholes, cracks or voids using appropriate and approved filler or resurfacer to create a monolithic surface to coat over. The actual filler(s) will be determined by the Dulux® Protective Coatings specification.

To minimise the risk of moisture interference, Dulux® Protective Coatings recommends the following qualitative test be performed prior to coating –

- ASTM D 4263 “Standard Test Method for Indicating Moisture in Concrete by the Plastic Sheet Method” (no visible moisture present).

If there is any concern about moisture problems with the concrete, or for projects greater than 500m², at least one of the below more accurate quantitative test methods should be utilised and the concrete pass the below requirements before moving forward with the coating application –

- ASTM F 1869 “Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete Subfloor Using Anhydrous Calcium Chloride” (moisture vapor transmission should not exceed 1.4 kilograms (3 pounds) per 93 square metres (1,000 square feet) in a 24-hour period).
- ASTM F 2170 “Standard Test Method for Determining Relative Humidity in Concrete using in situ Probes” (as referred to in AS 1884 2012, relative humidity should be less than 75%)

Note: The testing listed above cannot guarantee avoidance of future moisture related problems particularly with existing concrete slabs. This is especially true if the use of an under-slab moisture vapor barrier cannot be confirmed or concrete contamination from oils, chemical spills, unreacted silicates, chlorides or Alkali Silica Reaction (ASR) is suspected.

2.3 Primer

Consult your local Dulux® Protective Coatings Representative and/or project specification to determine if a primer is required. Refer to the specific product data sheets for recommended primers.

2.4 Coating over approved primers and/or properly prepared surfaces

Before application of Dulux® Flexituff® polyurea, ensure the primed surfaces to be coated over are dry and free from all traces of surface contaminants, especially grease and soluble salts. Ensure that the overcoating time/temperature intervals are in line with the primer data sheet.

3.0 Product Storage

The polyol (Part B) has a nominal storage life of 12 months at a recommended storage temperature of 20-25°C. The polyol should be kept properly closed and stored indoors in a well-ventilated area under normal factory conditions. Storage at 20-25°C also provides a convenient viscosity for handling. Storage at low temperatures (below 10°C) is not recommended. Protect this material from frost. Storage temperatures above 30°C are not recommended since they can accelerate the formation of insoluble solids and increase the viscosity of extended storage. Material elevated to a temperature above 30°C will also contribute to lost sag resistance.

Under the recommended storage conditions and in properly sealed containers, the isocyanate (Part A) has a nominal storage life of 12 months. The isocyanate should be kept properly closed and stored indoors in a well-ventilated area under normal factory conditions. Storage at 20-25°C also provides a convenient viscosity for handling. Storage at low temperatures (below 10°C) is not recommended because it may lead to crystallization; therefore, protect this material from frost. Storage temperatures above 30°C are not recommended since they can accelerate the formation of insoluble solids and increase the viscosity of extended storage.

If either component is opened and partially used, it should be purged with nitrogen to displace moisture.

4.0 Application

4.1 Required Equipment

The proportioning pump shall be capable of delivering of 3,500 PSI (241 BAR) static material pressure. Preferred equipment starting base is a Graco Reactor 3, EXP-2 plural component pump. Consult Dulux® Protective Coatings Technical Services first for advice on other pieces of equipment or configurations proposed to apply these materials.

Modify the Graco Reactor 3 EXP-2 plural component unit as follows:

- **Drum Feed:**

- o The proportioner pump should be supplied by two each Graco T3 SST 3:1 ratio transfer pump (or larger) kit with air pressure regulator and air pressure gauges. A low pressure ¾" ID nylon lined transfer hose should connect each transfer pump to the proportioner. There should also be an inline WYE 40 mesh screen filter in place between each transfer pump and the proportioner.
 - Other technology options do exist such as the Graco electric head Core E1 Transfer Pumps. Consult Dulux® Protective Coatings Technical Services for advice before applying these materials.
- o One each 1.75 HP air driven agitator with expanding blades (large blade assembly kit) used for the Part B (Polyol). The Part B should be thoroughly & uniformly mixed prior to any application. The agitator should be designed for the container in which it will be used. *** DO NOT AGITATE the Part A (ISO) ***
- o Two each flexible 1000W adjustable band heaters or drum heater blankets with thermostats can be used to condition materials in drums to the optimum temperature.
- o Four each 3/8" inch ID air lines for the feed pumps and agitator.
- o An additional set of drum blanket heaters and drum agitator may be needed for preheating and premixing the next drum set in order to maintain a desirable rate of production.
- o The poly side drum will need to have three openings on the top – one for the drum feed pump, one for the drum mixer, and one for the desiccant/recirculation kit.
- o The ISO side drum will need to have two openings on top – one for the drum feed pump and one for the desiccant/recirculation kit.
 - The polyol/resin drum mixer w/ air regulator inserts into the 2-inch centre bung of the drum.
*** DO NOT AGITATE the ISO/catalyst side ***
 - The drum pump w/ air regulator inserts into the 2 inch outside bung of the drum.
 - Desiccant and recirculation kits mount to the ¾ inch ID outside bung.

- **Pump Ratio:** Dulux® Flexituff® polyureas have a ratio of 1A:1B.

- **Primary Heaters:** Primary heaters are necessary to reduce and maintain material viscosities at optimum levels. These heaters should be capable of raising to and maintaining the required material temperature for proper application of the product. DO NOT overheat material as sag resistance and/or other properties could be lost. The primary heaters should be rated to withstand the maximum pressures the system can develop, be thermostatically controlled, and include temperature gauges. 15.3 kW heaters are included with the Reactor 3 E-XP2.

- **Heated Hose Bundle:** Graco's Reactor 3, EXP2 can have up to 310 ft (94.5M) of heated hose, including whip hose. For heated hose, use either Graco's "Scuff Guard" or Graco's "Xtreme-Wrap". Each section of heated hose is 50 ft (15 M). Up to 5 sections of hose can be used. Add to the end of the heated hose a heated whip hose assembly (10 ft, 3 M).

- **Spray Gun:** Use a plural component spray gun utilising impingement mixing and air purge. A suitable spray gun includes Graco's Fusion PC. Spray tip commentary follow below:

- R/ound Tips – For areas where fine finish is not needed, the following is recommended –
 - o For large volumes of product during application, use Graco mix chamber AR 4242.
 - o For more control of product, use Graco mix chamber AR 2929 & AR 2020.
- Flat Tips – For fine finish & coating complex structures, the flat tip combination is recommended. The following flat tip combination recommended is –
 - o Mix chamber - 20FL & Flat Spray Tip - 624 Flat
 - o Other combinations are possible and would need to be evaluated in the field to see if they are fit for purpose.
 - o It is advisable to have several back up tips and mix chambers with large projects to keep production going.

4.2 Application Information

Setting Up to Spray

- For new equipment, individual components (examples - feed pumps, recirculation kits, agitator, air lines and so on) should be connected as recommended by the equipment manufacturer and Dulux® Protective Coatings Technical Services. Be sure to lubricate all pumps and follow all the equipment manufacturer's instructions for assembly of equipment.
- Provided used equipment meets Dulux®'s equipment recommendations and is good working order, there should not be a concern using that equipment.
 - For existing equipment thoroughly clean the system including the line filters. Flush the system and fill (using transfer pumps) with inert plasticiser such as Mesamoll and test by slowly bringing the unit up to full pressure and heat.

Note: Do not use equipment where there is potential for cross contamination between other technologies and polyurea.

- Check and clean all fluid filters, air traps and gun filters.
- Have a qualified electrician check the electrical system to ensure proper power requirements are satisfied and there is complete continuity in all circuits.
- Ensure an air compressor of sufficient size (approximately 30 CFM) to run the pneumatic elements of the application equipment is connected and operating correctly. Items to be run through pneumatic means include feed pumps, agitator, and gun purge air.
- Identify and mark which side will contain the isocyanate component, and which side will contain the polyol.
 - Mark all isocyanate pumps, inlets, outlets, heaters, hose fittings, and gun inlets "A-Side" (with Reactor 3 – always the red, left side).
 - Mark all polyol pumps, inlets, outlets, hose fittings, and gun inlets "B side" (with Reactor 3 – always the blue, right side).
 - Retain this identification and use only as indicated to avoid cross contamination.
- Perform an initial flush of the system with Dulux® CR Reducer, followed by a final purge with Dulux® Urethane Thinner. DO NOT use any moisture containing solvents. Ensure that all moisture, equipment oils, etc. is removed from filters, hoses, etc.

Note: Any moisture present in the equipment has the potential to react with the isocyanate causing blockages in valves, filters, hoses and beyond.

- Perform a pressure check of the system to ensure there are no loose or leaking connection points. Repair any issues found through the test.
- Ensure the control board is working as expected.

Spraying Material

- In cooler weather it is recommended to precondition the material 24-48 hours ahead of time to a material core temperature of 25°C or higher to allow the equipment heaters to more efficiently heat the material up to the needed material temperature for application of the product.
- Once the equipment system is clean and leak free, push all solvent out of the system and material lines to waste into a grounded waste bucket.
- Recirculate both sides until the ISO material temperature is at 60°C and the polyol material temperature is 65°C. The heated hose bundle should be set between 60°C and 65°C (with the Reactor 3 EXP2, the heated hose bundle automatically sets its temperature to the material temperature set points). Some adjustment to heat is acceptable in cooler/cold weather. Consult Technical Services where this situation may arise.
- Once the correct material temperature has been achieved, switch from recirculation mode to spray mode and push out any residual solvent left in the lines out into a waste bucket until a solid flow of Part A and Part B comes out of each material line.
 - Once this step has been achieved, close the material valves at the gun manifold and clean off any excess material with clean rags, avoiding any cross contamination.
 - Install the Graco Fusion gun onto the gun manifold, connect the airline to the spray gun, disengage the safety, and increase spray pressure to begin spraying product.
 - Spray on a waste item such as flat cardboard until a proper spray pattern has been achieved. The initial spray pressure may be high until warm material starts to come through the spray gun. As the warmer material comes through the spray gun and the viscosity of the mixed fluid decreases, reduce the spray pressure to the level needed to properly deliver the product to the surface.

- When checking to see what number of passes and the rate of travel across a surface is needed to meet the specified dry film thickness (DFT), one or both methods are suggested –
 - o Spray over a bare blasted steel substrate. After 15 to 30 minutes check the DFT using a Type 2 Electronic DFT gauge with appropriate DFT probe for film thickness measuring capability. Ensure no impression is made on the surface of the coating before recording film thickness achieved.
 - o Spray over a surface to create a free film. After 15 to 30 minutes check the DFT using a micrometer with the ability to check for the film build trying to be achieved for the project. Ensure no impression is made on the surface of the coating before recording film thickness achieved.
 - o Adjust the number of passes and the rate of travel across the surface as needed to achieve the specified film build.
- The material inside the whip will cool down during periods when not spraying and therefore will be below the temperature required to yield a satisfactory spray pattern. Spray onto a waste surface or into a waste bucket until a satisfactory spray pattern is re-established before spraying on target. The temperature of the material at the gun can be checked using an IR gun pointed at the stream of the material.
- Start all spraying off target, moving over the target to avoid spot build-up of material on the edges of the spray pattern. Use a 50% overlap to ensure an evenly coated surface. Spray continuously as much as possible and minimise triggering the gun.
- Whenever there is even a small change in pressure, spray pattern, colour or consistency of the material, the applicator should stop coating activity immediately, identify the source of the problem, and the issue resolved before moving forward. All off-ratio material should be remediated in accordance with Section 5 of this application guide.
- Fluid filters and the Fusion gun should be checked periodically for any build-up of material. If build up is found, clean and/or replace to ensure the project is not slowed down. At a minimum, fully clean fluid filters and spray gun every four hours and when completed for the day.

Overnight Shutdown Procedures

If you are simply shutting down for a short period such as overnight, the material may be left in the system so as not to waste materials. Shutdown procedure is as follows:

- Shut off the transfer pumps and proportioner and turn off the heaters (disconnect air and power supply).
- Depressurise the system and shut off all in-line valves at proportioner and gun.
- Remove, disassemble, and thoroughly clean the spray gun and store.
- Nitrogen purge and blanket any partially filled coating containers and seal tightly if not connected.
- You may leave the transfer pumps wetted out in their respective materials.
- If all the material was used, then the transfer pumps should be wiped clean and placed in a sufficient amount of plasticiser to cover the lower portion of the pump.

Clean up of Equipment for Long Term Storage

If you anticipate not using the equipment for more than a week, then the material should be flushed from the entire system. In this case, a different set of procedures is followed:

- Turn off the heaters, hose heat, and any drum heaters.
- Remove the transfer pumps from their respective materials and wipe them clean. Place them in separate pails of the thinner to flush the system. Thoroughly flush the entire system with Dulux® Urethane Thinner.
- Once system is cleaned, place transfer pumps into separate pails of a plasticiser such as Mesamoll and flush plasticiser through system.
 - o The transfer pumps alone should be able to flush the system. The proportioner can be used with caution to assist in the flushing process.
 - o Recycle clean plasticiser through the entire system until no colour or evidence of material is left.
 - o Once a quarter plasticiser should be run through the equipment to ensure it is still operational.
- Remove and clean filters, reassemble.
- Shut off all air and power supplies and plug or cap any open inlets or outlets.
- Clean gun and tip thoroughly and store.
- Nitrogen purge and seal any partially filled material containers and store at room temperature indoors.

Caution: Prior to introducing any 100% solids coating, plasticiser such as Mesamoll must be used to flush the system. The system must be free of solvent to avoid any potential foaming of the coating resulting from the reaction of solvent with the solventless coating.

Mixing/Thinning

- No thinning of the product is allowed. Ensure all solvent in the lines and the pump is pushed out to waste, ensuring the system is free of solvent before coating application begins.
- Using the recommended material agitator, premix the Part B (polyol) side for a minimum time of 60 minutes before use. The Part A (isocyanate) side does not get premixed.
- The product is mixed together through an injection system within the Fusion gun.

5.0 Spot Repair, Removal & Reinstall, and Process of Recoating over Itself past Maximum Recoat Window

5.1 Spot Repair (including random blisters)

When removing blisters, cut back to sound underlying coating or substrate. Sound coating is considered to be coating that cannot be removed with a dull putty knife.

If the blister has uncured material, remove all resins by scraping and then wiping fully clean with solvent such as MEK or Xylene and clean rags, to remove all uncured resin and residue

For Steel:

If the steel substrate is exposed, the surface should be prepared to the original specification, or in the absence of a specification, to AS 1627.4 to Class Sa 2 ½, "Near White Metal" blast cleanliness appearance per ISO 8501-1. Then prime (if required) as per the specification. The primer must be applied and cured as per the specific Dulux® Protective Coatings' latest technical datasheet.

Scarify and feather the edges of the existing, and sound Flexituff® DM-8 or PU-1 coating approximately 100-125mm or 4-6 inches out and around the area to be repaired. This may be achieved by using wire cup wheels attached to right angle power drills.

After abrasion is complete, wipe the prepared area to be coated with MEK to remove debris and contaminants and allow it to dry. Confine the application of Flexituff® DM-8 or PU-1 polyurea to the cleaned and prepared repair areas.

For Concrete:

If the concrete substrate is exposed, the surface should be prepared to the original specification, or in the absence of a specification, to SSPC SP13 "Severe Service" and a concrete surface profile of ICRI CSP 5. Fill voids in the concrete with an approved filler and/or resurfacer. Then prime with an appropriately specified primer. The primer must be applied and cured as per the specific Dulux® Protective Coatings' latest technical datasheet.

If the prime coat is exposed, but determined to be intact and allowed to remain, it will need to be thoroughly and uniformly scarified to receive the subsequent coat of Flexituff® PU-1. Scarify and feather the edges of the existing, and sound Flexituff® PU-1 coating approximately 100-125mm or 4-6 inches out and around the area to be repaired. This may be achieved by using wire cup wheels attached to right angle power drills.

After abrasion is complete, wipe the prepared area to be coated with MEK to remove debris and contaminants and allow it to dry. Confine the application of Flexituff® PU-1 polyurea to the cleaned and prepared repair areas.

To the properly prepared, clean, dry, and contaminant free surface apply Flexituff® PU-1 at the specified thickness, ensuring the application remains confined to the area(s) that have been sacrificed and prepared.

If Flexituff® PU-1 cannot be used for the repair coating, appropriate and approved filler or resurfacer may be used when the surface preparation procedures outlined above are followed.

Note: The colour of the filler and/or resurfacer may differ from Flexituff® PU-1 and DM-8. They may also be not suitable for AS/NZS 4020 potable water application. Please contact Dulux® Protective Coatings Technical Service for advice.

5.2 Complete Removal of Flexituff® PU-1 and DM-8

Completely remove Flexituff® polyurea by any means feasible and evaluate the condition of the primer (if applicable). Depending upon condition of primer, as well as any relevant regulations (i.e. Potable water certifications, DFT constrictions), the primer may need to be removed and reinstalled or scarified sufficiently to receive the subsequent coat of Flexituff® polyurea.

For Steel:

For steel substrates, the surface should be prepared to the original specification, or in the absence of a specification, to AS 1627.4 to Class Sa 2 ½, “Near White Metal” blast cleanliness appearance per ISO 8501-1. Then prime as per the specification is applicable. The primer must be applied and cured as per the specific Dulux® Protective Coatings’ latest technical datasheet.

For Concrete:

For concrete substrates, the surface should be prepared to the original specification, or in the absence of a specification, to SSPC SP13, “Severe Service” and a surface profile of ICRI CSP 5. Fill voids in the concrete with an appropriate filler and/or surfacer. Then prime with the appropriate specified primer. The primer must be applied and cured as per the specific Dulux® Protective Coatings’ latest technical data sheet.

To the properly prepared, clean, dry, contaminant free, and primed (when applicable/specified) surface, apply Flexituff® PU-1 at the specified thickness, ensuring the application remains confined to the area(s) that have been properly cleaned and prepared.

5.3 Process of Recoating over Flexituff® PU-1 and DM-8 “Drop” past its Maximum Recoat Window

- If the recoat window has elapsed, then thoroughly and uniformly abrade 100-125mm or 4 to 6 inches into the existing, and sound Flexituff® polyurea. This may be achieved by using wire cup wheels attached to right angle power drills.
- After abrasion is complete, wipe the prepared area to be coated with MEK to remove debris and contaminants and allow it to dry.
- To the properly prepared, clean, dry, and contaminant free Flexituff® polyurea surface apply Flexituff® PU-1 or DM-8 (depending upon the system being used) at a minimum DFT 500-microns over the previously coated area, ensuring the application remains confined to the area(s) that have been scarified and prepared. Flowing out from the “drop” connection point, continue to apply Flexituff® polyurea to the remaining surfaces as specified. Ensure all areas meet the specified minimum requirements.

6.0 Safety

- All necessary measures should be adopted under the requirements of all Health & Safety Acts or other nationally recognised legislation. In particular, lighting, grounding, ventilation, and protective clothing shall be adequate for the safe and proper execution of the work.
- Before work commences, refer to the product specific Technical Data Sheet (TDS) and Safety Data Sheet (SDS).

7.0 Product Packaging & Properties

7.1 Packaging

| Product | Kit Size | Part A (Isocyanate) | Part B (Poly-) |
|-----------------|------------|---------------------|-----------------|
| Flexituff® PU-1 | 425 kg kit | 1 × 225 kg drum | 1 × 200 kg drum |
| Flexituff® DM-8 | 425 kg kit | 1 × 225 kg drum | 1 × 200 kg drum |

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