

ENVIROPOXY[®] WBE

Water Borne Acrylic Epoxy Finish

PC 295

- FEATURES**
- LOW ODOUR
 - EXCELLENT APPLICATION PROPERTIES
 - GOOD GLOSS AND COLOUR RETENTION
 - SUITABLE FOR USE OVER A WIDE RANGE OF SUBSTRATES
 - TINTABLE - AVAILABLE IN AN EXTENSIVE RANGE OF PASTEL COLOURS

USES ENVIROPOXY[®] WBE is a water borne acrylic epoxy topcoat that has been locally developed specially for the Australasian conditions. It displays superior gloss retention and resistance to chalking and yellowing when compared to traditional solvent based epoxies. ENVIROPOXY[®] WBE with its very low odour is ideal for use in areas such as treatment and operating rooms in hospitals, doors and door jambs in schools and commercial areas, wineries, pharmaceutical plants and the food and beverage industry.

SPECIFICATIONS

RESISTANCE GUIDE

HEAT RESISTANCE	90°C Continuous dry heat. 120°C Intermittent dry heat.	ALKALIS	Excellent resistance to splash and spillage weak solutions of most common alkalis.
WEATHERABILITY	Good gloss and colour retention on exterior exposure. Some colours may chalk on exterior exposure.	SALTS	Excellent resistance to neutral, acid and alkali salts.
SOLVENTS	Resists most common alcohols and cleaning solutions, however prolonged exposure must be avoided.	WATER	Excellent resistance to fresh and salt water but not suitable for immersion.
ACIDS	Suitable for splash and spillage exposure to weak solutions of inorganic acids.	ABRASION	Good when fully cured.

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Water borne acrylic epoxy	APPLICATION CONDITIONS			Min	Max	
FINISH	Semi Gloss	Air Temperature	10°C	40°C			
COLOUR	White and an extensive range of pastel colours using the DECORAMA [®] tint system.	Substrate Surface Temperature	10°C	40°C			
COMPONENTS	Two	Relative Humidity				85%	
SOLIDS BY VOLUME	38% (White)				Min	Max	Recom.
VOC LEVEL	<50 g/L (White, untinted)	Wet film per coat (microns)	105	160	130		
FLASH POINT	Water Based	Dry film per coat (microns)	40	60	50		
POT LIFE	8 Hours (4L, 25°C)	SUITABLE SUBSTRATES	Suitably primed steel, aluminium, zinc coated steel, concrete, fibreglass or MDF.				
MIXING RATIO (V/V)	Part A : 9 Part B : 1	PRIMERS	DULUX [®] Acrylic Sealer Undercoat DULUX [®] Acrylic Primer Undercoat Two Pack Epoxy primers				
THINNER	Water	APPLICATION METHODS	Brush, roller, conventional, airless spray or air assisted spray.				
PRODUCT CODE	714-84638 White/Light Base 976-84639 Hardener						

Drying characteristics at 50 microns dry film thickness

Temperature	Humidity	Touch	Handle	Full Cure	Overcoat	
					Min	Max
10° C	50%	1.5 Hours	8 Hours	7 Days	8 Hours	4 Weeks
15° C	50%	1 Hours	6 Hours	7 Days	6 Hours	4 Weeks
25° C	50%	30 Mins	4 Hours	7 Days	4 Hours	4 Weeks

These figures are given as a guide only, as ventilation, film thickness, humidity, thinning and other factors will influence the rate of drying. If the maximum overcoat interval is exceeded then the surface MUST be abraded to ensure maximum intercoat adhesion.

TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD

A spreading rate of 7.6 sq. metres per litre corresponds to 50 microns dry film thickness assuming no losses. Practical spreading rates will vary depending on such factors as method and conditions of application and surface roughness.

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TYPICAL SYSTEMS

(The typical systems are offered as a guide only and are not to be used as a specification. It is recommended that the specific needs of a project be discussed with a Dulux Protective Coatings Consultant.)

SURFACE	PREPARATION GUIDE	SYSTEM		DRY FILM THICKNESS
STEEL	Abrasive blast AS1627.4 Class 2.5	1st Coat	DUREPON® P14	75 Microns
		2nd Coat	ENVIROPOXY® WBE	50 Microns
CONCRETE	Clean surface to remove contaminants. Diamond grind, track or light-shot blast. Remove dust.	1st Coat	LUXEPOXY® 4 White Primer	50 Microns
		2nd Coat	ENVIROPOXY® WBE (Thin first coat 10-15%)	50 Microns
HARDWOOD & MDF	Sand and dust down before and after first coat.	1st Coat	Acrylic Primer Undercoat	30 Microns
		2nd Coat	ENVIROPOXY® WBE	50 Microns
PLASTERBOARD	Dust down before painting.	1st Coat	Acrylic Sealer Undercoat	30 Microns
		2nd Coat	ENVIROPOXY® WBE	50 Microns
COMPRESSED FIBRO CEMENT	Dust down before painting.	1st Coat	Sealer Binder	30 Microns
		2nd Coat	ENVIROPOXY® WBE	50 Microns
ALUMINIUM	Clean, degrease and abrade surface	1st Coat	LUXEPOXY® 4 White Primer	50 Microns
		2nd Coat	ENVIROPOXY® WBE	50 Microns
		3rd Coat	ENVIROPOXY® WBE	50 Microns

SURFACE PREPARATION It is recommended that specifiers follow the guidelines for surface preparation from the data sheet for the primer selected. The primer surface must be free from grease, oil, dirt and other loosely adhering materials.

APPLICATION Stir each can thoroughly until the contents are uniform. Use of a power mixer is recommended. Ensure bases have been tinted to the correct colour – DULUX ASSUMES NO RESPONSIBILITY FOR THE APPLICATION OF AN INCORRECT COLOUR. Mix the contents of both packs together thoroughly using a power mixer and allow to stand for 15 minutes. Box all containers before use to ensure colour consistency. Remix thoroughly before using.

BRUSH/ROLLER Apply two even coats of the mixed material to the prepared surface. Up to 200ml/litre of clean potable water can be added to ease application. When brushing and rolling additional coats may be required to attain the specified thickness.

CONVENTIONAL SPRAY Prior to using the spray equipment, flush with Dulux® Epoxy Thinner followed by fresh warm water. Up to 200ml/litre of clean potable water can be added to ease application.

Typical Set-up

Graco Delta Gun: 1.8mm (239543)
Pressure at Pot: 70-100 kPa (10-15 p.s.i.)
Pressure at Gun: 380-415 kPa (55-60 p.s.i.)

AIRLESS SPRAY Standard airless spray equipment such as a Graco 30:1 President with a fluid tip of 17-21 thou (0.43-0.53mm) and an air supply capable of delivering 550-690 kPa (80-100 p.s.i.) at the pump. Up to 200ml/litre of clean potable water can be added to ease application.

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® representative 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.

CLEAN UP Clean all equipment with clean warm water followed by Dulux® Epoxy Thinner (920-08925).

OVERCOATING Aged coating should be tested for lifting by a method appropriate for the coating thickness, for example 'X' cut or cross-hatch methods. If it lifts, remove it. The surface must be free of oil, grease and other contaminants. High-pressure water wash at 8.3 to 10.3 MPa (1,200 - 1,500 p.s.i.) to remove loosely adhering chalk and dust. Abrasion may be required depending on surface condition. If the maximum overcoat interval is exceeded then the surface MUST be abraded to ensure maximum intercoat adhesion.

SAFETY PRECAUTIONS **Read Data Sheet, Material Safety Data Sheet and any precautionary labels on containers.**
Store in well-ventilated area away from sources of heat or ignition. Keep containers closed at all times.
STORAGE
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 combined organic vapour/particulate respirator. When spray painting, users should comply with the provisions of the respective State Spray Painting Regulations.
FLAMMABILITY This product is not flammable. On burning will emit toxic fumes.
WELDING Avoid inhalation of fumes if welding surfaces coated with this paint. Grind off coating before welding.

MATERIAL SAFETY DATA SHEET is available from Customer Service (132377) or www.duluxprotectivecoatings.com.au

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PACKAGING	Available in 4 litre pack
TRANSPORTATION WEIGHT	1.28 kg/litre (Average of components)
DANGEROUS GOODS	Part A: Non Dangerous Goods
	Part B: Non Dangerous Goods

Any advice, recommendation, information, assistance or service provided by DULUX Australia in relation to goods manufactured by it or their use and application is given in good faith and is believed by Dulux to be appropriate and reliable. However, any advice, recommendation, information, assistance or service provided by Dulux is provided without liability or responsibility PROVIDED THAT the foregoing shall not exclude, limit, restrict or modify the right entitlements and remedies conferred upon any person or the liabilities imposed upon Dulux by any condition or warranty implied by Commonwealth, State or Territory Act or ordinance void or prohibiting such exclusion limitation or modification. Products can be expected to perform as indicated in this sheet so long as applications and application procedures are as recommended. Specific advice should be sought from Dulux for application in coastal areas and for large projects to ensure proper performance.