

LUXACHLOR[®] Finish

Tintable Chlorinated Rubber Finish

PC 524

- FEATURES**
- EXCELLENT WATER IMPERMEABILITY & SALT SPRAY RESISTANCE
 - RESISTANT TO MOULD & MILDEW
 - FULLY TINTABLE – AVAILABLE IN OVER 5,000 COLOURS
 - SINGLE PACK RECOATABLE FINISH

USES LUXACHLOR[®] Finish is recommended for the protection of steel structures such as cranes, bridges, conveyors, barges, dredges etc. especially under marine conditions. LUXACHLOR[®] coatings are also frequently specified in fertiliser plants, plating shops, paper mills, breweries, exterior coatings on chemical storage tanks and in the mining industry. Also on masonry buildings and cold rooms under conditions of high humidity and condensation. Because of their thermoplastic nature, chlorinated rubber should be coated on site.

SPECIFICATIONS AS/NZS 3750.11 Type 3

RESISTANCE GUIDE

HEAT RESISTANCE	Up to 65°C dry heat.	ALKALIS	Good resistance to splash and spillage of most common alkalis.
WEATHERABILITY	Some chalking will occur with exterior exposure if not topcoated. This will not detract from the resistance properties of the coating.	SALTS	Unaffected by splash and spillage of most salt solutions.
SOLVENTS	Resists splash and spillage of aliphatic solvents and mineral oils. Poor resistance to other solvents.	WATER	Excellent resistance to fresh and salt water but not suitable for immersion.
ACIDS	Suitable for splash and spillage exposure to most solutions of inorganic acids.	ABRASION	Good for single pack coating.

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Tintable chlorinated rubber finish	APPLICATION CONDITIONS	Min	Max	
FINISH	Gloss	Air Temperature	5°C	40°C	
COLOUR	White, a full range of tinted colours and MTO factory made colours.	Substrate Surface Temperature	5°C	40°C	
COMPONENTS	One	Relative Humidity		85%	
SOLIDS BY VOLUME	35% (White/Light Base, untinted)		Min	Max	Recom.
VOC LEVEL	<580 g/L (White/Light Base, untinted)	Wet film per coat (microns)	115	170	145
FLASH POINT	24°C	Dry film per coat (microns)	40	60	50
POT LIFE	Not applicable	SUITABLE SUBSTRATES	Suitably primed steel, aluminium, zinc coated steel and concrete.		
MIXING RATIO (V/V)	Single Pack	PRIMERS	Two pack epoxy, inorganic zinc and selected single pack primers.		
THINNER	965-63020 Dulux [®] CR Reducer	APPLICATION METHODS	Roller, conventional, airless spray or air assisted spray.		
PRODUCT CODE	252-63001 White/Light Base 252-63002 Deep Base 252-63003 Clear Base				

Drying characteristics at 50 microns dry film thickness

Temperature	Humidity	Touch	Handle	Full Cure	Min	Overcoat	Max
25° C	50%	4 Hours	24 Hours	7 Days	6 Hours		Indefinite

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

TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD

A spreading rate of 7.0 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	ZINCANODE® 304	75 Microns
		2nd Coat	FERREKO® No.3	100 Microns
		3rd Coat	LUXACHLOR® Finish	50 Microns
		1st Coat	LUXAPRIME® UMP ZP	50 Microns
		2nd Coat	LUXACHLOR® HB	90 Microns
		3rd Coat	LUXACHLOR® Finish	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	LUXACHLOR® Finish	50 Microns
		3rd Coat	LUXACHLOR® Finish	50 Microns
			(Thin first coat 10-15%)	

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 before use – DULUX ASSUMES NO RESPONSIBILITY FOR THE APPLICATION OF AN INCORRECT COLOUR. Box all containers before use to ensure colour consistency. Remix thoroughly before using.

BRUSH/ROLLER Application is satisfactory under all but the hottest conditions. Apply even coats of the mixed material to the prepared surface. When brushing and rolling additional coats may be required to attain the specified thickness. Do not overwork, as wet edge properties are limited. Thin if necessary with Dulux® CR Reducer (965-63020).

CONVENTIONAL SPRAY Thin up to 150ml/litre with Dulux® CR Reducer (965-63020) to aid atomisation.

Typical Set-Up

Graco Delta Gun: 1.4mm (239542)
 Pressure at Pot: 70-100 kPa (10-15 p.s.i.)
 Pressure at Gun: 410-490 kPa (60-70 p.s.i.)

AIRLESS SPRAY Standard airless spray equipment such as a Graco 33:1 Bulldog or 45:1 Xtreme with a fluid tip of 13 -15 thou (0.33-0.38mm) and an air supply capable of delivering 550-690 kPa (80 -100 p.s.i.) at the pump. Thinning is not normally required but up to 100 ml/litre of Dulux® CR Reducer (965-63020) may 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. 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 on structures subject to sustained surface temperatures above 65°C or where spillage of solvent may occur. Do not weld or flame cut through chlorinated rubber coatings. Due to their thermoplastic nature, chlorinated rubber coatings are more suited to on site application. If transporting shortly after application care should be taken to ensure painted surfaces are not in contact.

CLEAN UP Clean all equipment with Dulux® CR Reducer (965-63020) immediately after use.

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.

SAFETY PRECAUTIONS Read Data Sheet, Material Safety Data Sheet and any precautionary labels on containers.

STORAGE Store as required for a flammable liquid Class 3 in a bonded 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 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 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.

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 and 15 litre containers.
 TRANSPORTATION WEIGHT 1.30 kg/litre (Average of components)
 DANGEROUS GOODS Class 3 UN 1263

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