

# LUXAFLOOR<sup>®</sup> ROLLCOAT<sup>™</sup>

## High Build High Solids Epoxy Floor Coating

PC 227

- FEATURES**
- EXTREMELY TOUGH, DAMAGE RESISTANT FLOOR COATING
  - EXCELLENT ADHESION TO CONCRETE
  - GOOD CHEMICAL RESISTANCE
  - EASY TO CLEAN
  - LOW VOC
  - AVAILABLE IN A RANGE OF FACTORY MADE AND TINTED COLOURS

**USES** LUXAFLOOR<sup>®</sup> RollCoat<sup>™</sup> is a high build, high solids, two pack epoxy floor coating that provides a hardwearing surface. It is ideal for use in areas subject to foot and rubber-tired vehicle traffic. Can be applied as a slip resistant finish to provide maximum safety by using either a stir in or a broadcast aggregate. Refer Product Data Sheet PC940 LUXAFLOOR<sup>®</sup> Aggregates. LUXAFLOOR<sup>®</sup> RollCoat<sup>™</sup> is ideal for use in internal floor areas of factories, warehouses etc. It provides an attractive appearance that is easily cleaned.

**SPECIFICATIONS** AS/NZS 4586 (with the addition of a suitable Luxafloor<sup>®</sup> Aggregate)

### RESISTANCE GUIDE

<b>WEATHERABILITY</b>	Epoxy coatings yellow with time and chalk on exterior exposure. Neither yellowing nor chalking detracts from the protective properties of the coating.	<b>SOLVENTS</b>	Good resistance to splash and spillage of aromatic and aliphatic hydrocarbon solvents and alcohols
<b>HEAT RESISTANCE</b>	Up to 120°C dry heat	<b>WATER</b>	Excellent resistance to fresh and salt water but not suitable for immersion
<b>SALTS</b>	Excellent resistance to neutral and alkaline salt solutions	<b>ALKALIS</b>	Good resistance to splash and spillage of most common alkalis
<b>ACIDS</b>	Good resistance to splash and spillage of dilute acids	<b>ABRASION</b>	Excellent when fully cured. 133 mg per 1000 cycles (CS-17, 1000 gm load/wheel)
		<b>ADHESION</b>	10 MPa (1458 p.s.i.) (Adhesion Pull-off Test, AS1580.408.5)

### TYPICAL PROPERTIES AND APPLICATION DATA (STANDARD HARDENER)

<b>CLASSIFICATION</b>	High build high solids epoxy coating	<b>APPLICATION CONDITIONS</b>			
<b>FINISH</b>	Gloss		Min	Max	
<b>COLOUR</b>	Light Grey, Blue Grey, Pewter and a range of colours tinted from Light Base	<b>Air Temp.</b>	15°C	35°C	
<b>COMPONENTS</b>	Two	<b>Substrate Temp.</b>	15°C	35°C	
<b>VOLUME SOLIDS</b>	88 % (Mid Base)	<b>Relative Humidity</b>		85%	
<b>VOC LEVEL</b>	140 g/L (Mid Base, untinted)	<b>Concrete Moisture</b>		<10%	
<b>FLASH POINT</b>	24°C	<b>COATING THICKNESS (MICRONS)<sup>1</sup></b>			
<b>POT LIFE</b>	60 Minutes (4Litre kit, 25°C)		Min	Max	Recommended
<b>MIXING RATIO V/V</b>	Part A : 3    Part B : 1	<b>Wet film per coat (µm)</b>	115	230	145
<b>THINNER</b>	920-08925    Dulux <sup>®</sup> Epoxy Thinner*	<b>Dry film per coat (µm)</b>	100	200	125
<b>PRODUCT CODE</b>	707-89815    Mid Base 707-38678    Light Grey 707-38661    Pewter 707-38716    Blue Grey 976-H0000    Standard Hardener 976-H0001    Cold Cure Hardener 976-H0002    Hot Weather Hardener	<b>SUITABLE SUBSTRATES</b>	Diamond ground or track blasted concrete		
		<b>PRIMERS</b>	Not applicable		
		<b>TOPCOATS</b>	Not Applicable		
		<b>APPLICATION METHODS</b>	Brush, roller, conventional and airless spray		

\*Thinner not normally required – Contact your DULUX<sup>®</sup> Consultant before use

### DRYING CHARACTERISTICS AT 125 µm DRY FILM THICKNESS (STANDARD HARDENER)

Floor Temperature	Humidity	Touch	Light Traffic	Full Cure	OVERCOAT	
					Min	Max <sup>2</sup>
15° C	50%	4 Hours	20 Hours	7 Days	10 Hours	30 Hours
25° C	50%	2 Hours	16 Hours	7 Days	6 Hours	18 Hours

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

<sup>1</sup> Higher film builds can be achieved by spray application but this will extend drying times.

<sup>2</sup> If the maximum overcoat interval is exceeded then the surface MUST be abraded to ensure maximum intercoat adhesion.

### SPREADING RATE 7.0 square metres per litre equals 125 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.

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## COLD CURE HARDENER

### COATING THICKNESS (MICRONS)

	Min	Max	Recommended
Wet film per coat (µm)	115	230	145
Dry film per coat (µm)	100	200	125

### APPLICATION CONDITIONS

	Min	Max
Air Temperature	10°C	25°C
Substrate Surface Temperature	10°C	25°C
Relative Humidity		85%
Concrete Moisture Content		<10%

  

SOLIDS BY VOLUME	88% (Mid Base)
VOC LEVEL	<140 g/L (Mid Base, untinted)
POT LIFE	45 Minutes (4 litre kit, 25°C)

## DRYING CHARACTERISTICS AT 125 µm DRY FILM THICKNESS\*

Floor Temperature	Humidity	Touch	Light Traffic	Full Cure	OVERCOAT	
					Min	Max*
10° C	50%	4 Hours	22 Hours	7 Days	12 Hours	36 Hours
15° C	50%	3 Hours	18 Hours	7 Days	10 Hours	30 Hours
25° C	50%	1½ Hours	14 Hours	7 Days	6 Hours	18 Hours

These figures are 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.

Use of fast or low temperature hardeners may result in increased yellowing and a reduction of gloss level.

### SPREADING RATE

with Cold Cure Hardener  
assuming no losses

**7.0 square metres per litre equals 125 µm dry film thickness**

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

## HOT WEATHER HARDENER

### COATING THICKNESS (MICRONS)

	Min	Max	Recommended
Wet film per coat (µm)	115	230	145
Dry film per coat (µm)	100	200	125

### APPLICATION CONDITIONS

	Min	Max
Air Temperature	20°C	45°C
Substrate Surface Temperature	20°C	45°C
Relative Humidity		85%
Concrete Moisture Content		<10%

  

SOLIDS BY VOLUME	88% (Mid Base)
VOC LEVEL	<140 g/L (Mid Base, untinted)
POT LIFE	90 Minutes (4Litre kit, 25°C)

## DRYING CHARACTERISTICS AT 125 µm DRY FILM THICKNESS\*

Temperature	Humidity	Touch	Light Traffic	Full Cure	OVERCOAT	
					Min	Max
25° C	50%	2.5 Hours	6 Hours	7 Days	6 Hours	4 Weeks*

These figures are 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.

### SPREADING RATE

with Hot Weather Hardener  
assuming no losses

**7.0 square metres per litre equals 125 µm dry film thickness**

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

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## 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)
CONCRETE	Interior	Remove curing agents and other surface contaminants. Diamond grind or track blast	1 <sup>st</sup> Coat Luxafloor® RollCoat™ 2 <sup>nd</sup> Coat Luxafloor® RollCoat™	125 µm 125 µm
CONCRETE	Interior	Remove curing agents and other surface contaminants. Diamond grind or track blast	1 <sup>st</sup> Coat Luxafloor® RollCoat™ 2 <sup>nd</sup> Coat Luxafloor® RollCoat™ + Stir-In Aggregate Coarse @ 30g/L	125 µm 125 µm
CONCRETE	Interior	Remove curing agents and other surface contaminants. Diamond grind or track blast	1 <sup>st</sup> Coat Luxafloor® RollCoat™ 2 <sup>nd</sup> Coat While wet scatter Broadcast Aggregate No. 36 at 50g/m <sup>2</sup> Luxafloor® RollCoat™	125 µm 125 µm

NOTE: If application is by brush or roller, additional coats will be necessary to achieve the minimum DFT and full opacity

<b>SURFACE PREPARATION</b>	<b>Concrete:</b> Concrete must be at least 28 days old before coating. Remove all laitance, curing compounds, oil, grease and other surface contaminants. Diamond grind, track or light shot-blast to remove laitance and provide suitable profile. Remove all dust by vacuum cleaning. Fill any large cracks or voids using Luxepoxy® Filler.
<b>APPLICATION</b>	Mix each can thoroughly using a power mixer until the contents are uniform. Ensure bases have been tinted to the correct colour before use. DULUX® ASSUMES NO RESPONSIBILITY FOR THE APPLICATION OF INCORRECT COLOUR. Mix the contents of both packs together thoroughly with a power mixer and let stand for 10 minutes. Box all containers before use to ensure colour consistency. Remix thoroughly before application.
<b>BRUSH/ROLLER</b>	Use brush only to cut in around perimeter of floor. Apply even coats of mixed material to the prepared surface by roller. Typical "X" and "Y" roller patterns are recommended, working in small areas of up to 10m <sup>2</sup> at a time, keeping a wet-edge. When brushing and rolling additional coats may be required to attain the specified thickness.
<b>CONVENTIONAL SPRAY</b>	Thinning is not normally required but up to 50ml/litre with Dulux® Epoxy Thinner (920-08925) may be used to aid atomisation. Apply in multiple wet coats overlapping each pass 50%. Typical Set-up Graco Delta Gun 1.8mm (239543) Pressure at Pot: 70-100 kPa (10-15 p.s.i.) Pressure at Gun: 380-410 kPa (55-60 p.s.i.)
<b>AIRLESS SPRAY</b>	Standard airless spray equipment such as a Graco Xtreme 56:1 with a fluid tip of 19-21 thou (0.48- 0.53mm) 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 50 ml/litre of Dulux® Epoxy Thinner (920-08925) may be used to aid atomisation.
<b>PRECAUTIONS</b>	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 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, or where the surface temperature is below 10°C. Do not apply at relative humidity above 85% or when the surface is less than 3°C above the dewpoint. To minimise colour variation, ensure all product is mixed, boxed and thinned correctly and do not mix hardener types on one job. To minimise variations in appearance topcoat must be applied in one session using a uniform/consistent application technique.
<b>CLEAN UP</b>	Clean all equipment with Dulux® Epoxy Thinner (920-08925) immediately after use.
<b>OVERCOATING</b>	Remove oil, grease, dirt and other surface contaminants. 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 (1,200-1,500p.s.i.) to remove chalk and dust. Abrade to remove gloss and provide a key for the new coating. Epoxies must be abraded if recoated outside the recoat window.
<b>SAFETY PRECAUTIONS</b>	<b>Read Data Sheet, SAFETY DATA SHEET and any precautions on container labels. SAFETY DATA SHEET is available from Customer Service (132377) or www.duluxprotectivecoatings.com.au</b>
<b>STORAGE</b>	Store as required for a flammable liquid Class 3 in a banded area under cover. Store in well-ventilated area away from sources of heat or ignition. Keep containers closed at all times.
<b>HANDLING</b>	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.
<b>USING</b>	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 spraying, users must comply with their respective State Spray Painting Regulations.
<b>FLAMMABILITY</b>	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 <sub>2</sub> or dry chemical powder. On burning will emit toxic fumes.
<b>WELDING</b>	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  
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### PACKAGING, TRANSPORT AND STORAGE

PACKAGING	Available in 10 litre packs
TRANSPORTATION WEIGHT	1.36 kg/litre (Average of components)
DANGEROUS GOODS	Part A: Class 3 UN 1263 Part B: Class 3 UN 1760

Dulux and Luxafloor are registered trade marks of DuluxGroup (Australia) Pty Ltd. Rollcoat is a trade mark.

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