

LUXEPOXY[®] 4 White Primer

Non Inhibitive Two Pack Epoxy Primer

PC 200

- FEATURES**
- NON TOXIC PIGMENTATION
 - RECOMMENDED PRIMER OVER GALVANISED STEEL, ALUMINIUM AND CONCRETE
 - EXCELLENT TIE COAT OVER INORGANIC ZINC COATINGS
 - EXCELLENT ADHESION PROPERTIES FOR A WIDE RANGE OF SUBSTRATES
 - POTABLE WATER APPROVAL OVER ZINCANODE 304

USES LUXEPOXY[®] 4 White Primer is recommended on all galvanised steel, non-ferrous metals, concrete, hardwood and MDF as the primer for high performance epoxy, polyurethane, enamels and water borne acrylics. It displays the same high degree of solvent, chemical and abrasion resistance as LUXEPOXY[®] 4 Finish.
LUXEPOXY[®] 4 White Primer is typically used over appropriate substrates in the chemical and petroleum industry, food and beverage plants, abattoirs, and canneries and in conjunction with inorganic zinc as a lining for steel potable water storage tanks.

SPECIFICATIONS The use of film forming components of LUXEPOXY[®] 4 WHITE PRIMER when applied as directed is authorised by Section 175.300 of the U.S. Code of Federal Regulation (Food & Drugs) as the food contact surface of articles intended for use in producing, manufacturing, packing, processing, preparing, treating, packaging, transporting or holding food, subject to the limitation and conditions of use prescribed in that Section.

RESISTANCE GUIDE

| | | | |
|------------------------|--|-----------------|---|
| HEAT RESISTANCE | Up to 105°C dry heat. | ACIDS | Suitable for splash and spillage exposure to weak solutions of inorganic acids. |
| WEATHERABILITY | Epoxy coatings may yellow with time. On exterior exposure some chalking may also occur. This will not detract from the protective properties of the coating. Use a weatherable topcoat if required for appearance. | ALKALIS | Excellent resistance to splash and spillage of most common alkalis. |
| SOLVENTS | Resists splash and spillage of most hydrocarbon solvents, refined petroleum products and most common alcohols. | SALTS | Excellent resistance to neutral and alkali salts. |
| | | WATER | Suitable for immersion in fresh and salt water when suitably topcoated. |
| | | ABRASION | Excellent when fully cured. |

TYPICAL PROPERTIES AND APPLICATION DATA

| | | | | | |
|---------------------------|--|-------------------------------|---|------|--------|
| CLASSIFICATION | Two pack epoxy primer | APPLICATION CONDITIONS | | | |
| FINISH | Low Gloss | | Min | Max | |
| COLOUR | White | Air Temperature | 10°C | 45°C | |
| COMPONENTS | Two | Substrate Surface Temperature | 10°C | 45°C | |
| SOLIDS BY VOLUME | 43% | Relative Humidity | | 85% | |
| VOC LEVEL | <490 g/L | Concrete Moisture Content | | <10% | |
| FLASH POINT | 15°C mixed | | Min | Max | Recom. |
| POT LIFE | 8 hours (4L, 25°C) | Wet film per coat (microns) | 95 | 140 | 125 |
| MIXING RATIO (V/V) | Part A : 4 Part B : 1 | Dry film per coat (microns) | 40 | 60 | 50 |
| THINNER | 920-08925 Dulux [®] Epoxy Thinner | SUITABLE SUBSTRATES | Prepared concrete, polyester composite, MDF, aluminium and most non-ferrous metals. | | |
| PRODUCT CODE | 731-63011 Part A 976-50732 Hardener | TOPCOATS | Single and two pack products | | |
| | | APPLICATION METHODS | Brush, roller, conventional or airless spray. | | |

Drying characteristics at 50 microns dry film thickness

| Temperature | Humidity | Touch | Handle | Full Cure | Overcoat | |
|-------------|----------|-----------|----------|-----------|----------|------------|
| | | | | | Min | Max* |
| 10° C | 50% | 2 Hours | 15 Hours | 7 Days | 15 Hours | Indefinite |
| 15° C | 50% | 2 Hours | 9 Hours | 7 Days | 9 Hours | Indefinite |
| 25° C | 50% | 1.5 Hours | 4 Hours | 7 Days | 8 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.

When used for non-immersion conditions. Refer to PRECAUTIONS section for overcoating intervals and requirements for immersion service.

TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD

A spreading rate of 8.6 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 Immersion – Freshwater | Abrasive blast AS1627.4 Class 3.0 | 1st Coat Mist Coat | ZINCANODE [®] 304 LUXEPOXY [®] 4 White Primer | 75 Microns 10 - 15 Microns |
| CONCRETE | Clean surface to remove contaminants. Diamond grind, track or light-shot blast. Remove dust. | 1st Coat 2nd Coat | LUXEPOXY [®] 4 White Primer LUXEPOXY [®] 4 | 50 Microns 50 Microns |
| HARDWOOD & MDF | Sand and dust down before and after first coat. | 1st Coat 2nd Coat | LUXEPOXY [®] 4 White Primer LUXEPOXY [®] 4 | 50 Microns 50 Microns |
| ALUMINIUM | Clean, degrease and abrade surface | 1st Coat 2nd Coat 3rd Coat | LUXEPOXY [®] 4 White Primer LUXATHANE [®] R LUXATHANE [®] R | 50 Microns 50 Microns 50 Microns |

SURFACE PREPARATION

Steel: 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. Not recommended for direct application to ferrous metals.

Concrete: Remove all laitance, form release, curing compounds, oil, grease and other surface contaminants. Diamond grind, track or light shot-blast to provide suitable profile. Remove all dust by vacuum cleaning. Fill any large voids exposed using Luxepoxy Filler. Cement based substrates should be at least 21 days old before coating.

MDF and hardwood: Sand thoroughly and remove all dust.

Non ferrous metals: Round off all rough welds, sharp edges and remove weld spatter. Remove grease, oil and other contaminants in accordance with AS1627.1. Abrade the surface with abrasive paper or whip blast. Remove all dust by vacuum cleaning.

APPLICATION

Stir each can thoroughly until the contents are uniform. Use of a power mixer is recommended. Mix the contents of both packs together thoroughly using a power mixer and allow to stand for 10 minutes. Remix thoroughly before using.

BRUSH/ROLLER

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.

CONVENTIONAL SPRAY

Thin up to 150 ml/litre with Dulux[®] Epoxy Thinner (920-08925) 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: 380-410 kPa (55-60 p.s.i.)

AIRLESS SPRAY

Standard airless spray equipment such as a Graco 30:1 President 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 50 ml/litre of Dulux[®] Epoxy Thinner (920-08925) 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. 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. When used for immersion conditions the maximum overcoat interval is 3 days at 25°C. The coating MUST be fully cured and solvent free prior to being placed under immersion conditions.

CLEAN UP

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

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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| Dulux Protective Coatings a division of DuluxGroup (Australia) Pty Ltd 1956 Dandenong Road, Clayton 3168 A.B.N. 67 000 049 427 Dulux, Luxepoxy, Luxathane and Zincanode are registered trademarks. DuluxGroup is a trademark. | PACKAGING Available in 4 litre and 20 litre packs TRANSPORTATION WEIGHT 1.36 kg/litre (Average of components) DANGEROUS GOODS Part A: Class 3 UN 1263 Part B: Class 3 UN 1263 |
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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.