

LUXAFLOOR® ROLLCOAT

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
 - AVAILABLE IN A RANGE OF FACTORY MADE AND TINTED COLOURS

USES LUXAFLOOR® RollCoat 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 improve safety by using either a stir in or a broadcast aggregate. Refer Product Data Sheet PC940 LUXAFLOOR® Aggregates.

LUXAFLOOR® RollCoat 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® Aggregate)

RESISTANCE GUIDE

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

TYPICAL PROPERTIES AND APPLICATION DATA (STANDARD HARDENER)

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

*Thinner not normally required – Contact your DULUX® Consultant before use

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

Floor Temperature	Humidity	Touch	Light Traffic	Full Cure	OVERCOAT	
					Min ¹	Max ²
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.

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

² 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
SOLIDS BY VOLUME	88% (Mid Base)		
VOC LEVEL	<140 g/L (Mid Base, untinted)		
POT LIFE	45 Minutes (4 litre kit, 25°C)		

APPLICATION CONDITIONS

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

DRYING CHARACTERISTICS AT 125 µm DRY FILM THICKNESS*

Floor Temperature	Humidity	Touch	Light Traffic	Full Cure	OVERCOAT	
					Min	Max ¹
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%	1.5 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

¹If the maximum overcoat interval is exceeded then the surface MUST be abraded to ensure maximum intercoat adhesion.

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

APPLICATION CONDITIONS

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

DRYING CHARACTERISTICS AT 125 µm DRY FILM THICKNESS*

Temperature	Humidity	Touch	Light Traffic	Full Cure	OVERCOAT	
					Min	Max ¹
25° C	50%	2.5 Hours	18 Hours	7 Days	8 Hours	20 Hours

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

¹If 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.

LUXAFLOOR® ROLLCOAT

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 st Coat Luxafloor® RollCoat 2 nd Coat Luxafloor® RollCoat	125 µm 125 µm
CONCRETE	Interior	Remove curing agents and other surface contaminants. Diamond grind or track blast	1 st Coat Luxafloor® RollCoat 2 nd Coat Luxafloor® RollCoat Mix in 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 st Coat Luxafloor® RollCoat While wet scatter Broadcast Aggregate No. 36 at 50g/m ² 2 nd Coat 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

SURFACE PREPARATION	Concrete Floors: Concrete must be at least 28 days old before coating. Remove curing compounds, oil, grease and other oily contaminants with Gamlen CA 1 detergent (according to the manufacturer's written instructions and all safety warnings). Diamond grind, track or light shot-blast concrete floors to remove laitance and to provide a suitable profile. Remove all dust by vacuum cleaning. Fill any large cracks or voids using Luxepoxy® Filler.
APPLICATION	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.
BRUSH/ROLLER	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 ² at a time, keeping a wet edge. When brushing and rolling additional coats may be required to attain the specified thickness.
CONVENTIONAL SPRAY	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 AirPro: 1.8mm (239543) Pressure at Triton 308: 65-100 kPa (10-15 p.s.i.) Pressure at Gun: 385-420 kPa (55-60 p.s.i.)
AIRLESS SPRAY	Standard airless spray equipment such as a Graco Xtreme 45:1 or Graco Xtreme 56:1 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. Thinning is not normally required but up to 50 ml/litre of Dulux® Epoxy Thinner (920-08925) may be used to aid atomisation.
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 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 consistent application technique.
CLEAN UP	Clean all equipment with Dulux® Epoxy Thinner (920-08925) immediately after use.
OVERCOATING	Degrease with Gamlen CA 1 according to the manufacturer's written instructions and all safety warnings. Test adhesion of existing coating by standard cross hatch adhesion test. If the coating fails, remove it. Fill any cracks or defects in the concrete with Dulux® Luxepoxy® Filler. Spot prime bare areas with your chosen floor coating. Mechanically grind the existing coating to remove any gloss and create a good key for the new coating. Vacuum clean to remove all dust.
SAFETY PRECAUTIONS	Read Data Sheet, SAFETY DATA SHEET and any precautions on container labels. SAFETY DATA SHEET is available from Customer Service (13 23 77) or www.duluxprotectivecoatings.com.au
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 spraying, users must comply with their 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, CO ₂ 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.

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

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