

Epoxy Powder Coating			
Product Code:		938 Line	
Description			
Durepoxy® is an epoxy powder coating with a high flow finish suitable for a wide range of interior applications. Durepoxy® is easy to apply to many substrates, and results in a film with exceptional wear and damage resistance.			
Features		Benefits	
Film integrity	Long intact life of coating		
Excellent surface hardness	Hard wearing/serviceable finish		
No solvents or emissions	Less waste and pollution to the environment		
Very good flow	Excellent for bathroom fittings, appliances		
Good chemical resistance	Resists oil and general chemical spills		
Uses			
Durepoxy® has a wide range of applications over various substrates including steel and aluminium. Examples include: bathroom fittings, tapware, interior joinery components, computer equipment, electrical equipment, shelving, white goods, office equipment and automotive components.			
Performance Guide			
Weather	Durepoxy® is not recommended for exterior use. It contains epoxy which will chalk on exterior exposure.	Salt Spray	Very good salt spray resistance. 2 - 3mm adhesion loss at scribe after 250 hours salt spray on steel.
Heat	Excellent resistance to 120°C continuous service conditions.	Humidity	Excellent resistance to 38°C/100% humidity for 250 hours on steel or chromated aluminium.
Acid	Resistant to spills of dilute acid.	Abrasion	Excellent resistance to abrasion.
Alkali	Resistant to spills of dilute alkali.	Pencil Hardness	Min 3H
Flexibility	Pass 80 inch/lb	Cross Hatch Adhesion	No removal
Chemical Resistance			
Excellent resistance to oils and general chemicals.			
Ethyl Acetate	Softens after prolonged contact	White Spirits	Resistant
Ethanol	Resistant	Xylene	Slight softening/limit contact
Methyl Ethyl Ketone	Softens after prolonged contact		

Durepoxy®

Product Guide			
Colour	A range of made to order colours available.	Specific gravity	1.3 - 1.7 @ colour
Gloss Level	5 - 98% at 60°, as required	Shelf life	12 months when stored below 25°C/dry conditions
Application Data			
Application Method	Electrostatic spray.		
Clean Up	Dust or vacuum loose powder. Avoid use of compressed air.		
Cure Schedule	Metal Temperature (°C)	Time (minutes)	
	200	5	
	190	10	
	180	15	
Cured Film Thickness	Recommended:	80 µm	
	Range:	50 – 120 µm	
Note: Curing below metal temperatures of 160°C, or above metal temperatures of 200°C are not recommended.			
Theoretical spreading rate at recommended film thickness			
A coverage rate of 8 - 10m ² /kg is commonly experienced. Practical spreading rates will vary due to such factors as method and conditions of application and surface profile and texture.			
Application Guide			
Surface Preparation			
All surfaces should be degreased and pre-treated for optimal performance. Suitable pre-treatment includes:			
Aluminium	Yellow chromate or green chromate/phosphate	(refer AS3715-2002 and/or BS6496)	
Ferrous metals	Zinc phosphate or Iron phosphate	(refer BS6497)	
Zinc Coated Metals (eg. galvanising)	Zinc phosphate or chromate	(refer BS6497)	
Application Procedure and Equipment			
1a)	For fluidised bed, ensure uniform fluidisation of powder. Fluidised powder should resemble “simmering liquid”. Aged or compacted powder may require pre-conditioning for several minutes to fluidise evenly.		
1b)	For box feeders, ensure probe is fully inserted in powder and operated as per manufacturer’s recommendations.		
2.	Apply by electrostatic spray.		
3.	Cure as per recommendations outlined above.		
4.	Test for cure of the coating by contact with a drop of Corsol PGMA (available from Dulux Powder Coatings) for 30 seconds. Surface should be wiped dry and immediately checked for softening. Only slight surface softening should occur.		

Durepoxy®

Care and Maintenance

To maintain the attractive appearance of the Durepoxy® film, it should be regularly washed with warm water and mild liquid detergent, followed by a fresh water rinse.

The use of abrasive cleaners is not recommended, nor is the use of active organic solvents.

Health and Safety

The MSDS is an integral part of using this product as it contains information on the potential health effect of exposure, personal protective equipment needed and other relevant SH&E information.

For detailed information, refer to product label and the current Chemical Data Sheet (No. 13542702) available through Sales and Customer Service Offices.

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Precautions and Limitations

- As a result of possible wide application variations and stoving conditions, Durepoxy® may show variation between Dulux Powder Coatings prepared samples and production applied material. Therefore, it is the applicator and/or their customer's responsibility to ensure the product conforms to their requirements.
- For optimum corrosion performance ensure recommended dry film thickness is obtained.
- Not recommended for use in highly corrosive environments such as severe marine or industrial locations.
- Not recommended for exterior applications.

Transport and Storage

Sizes:	20 kg	Flashpoint:	N/A
Weight:	20 kg	UN:	N/A
Dangerous Goods Class:	N/A	Package Group:	N/A
Shipment Name:	Not dangerous goods. No special transport requirements.		
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