

DULUX TRADE HI-CHEM EPOXY ENAMEL

TECHNICAL DATA SHEET

Version 10 – 2025 JUNE

THIS ISSUE SUPERSEDES ALL PREVIOUS PUBLICATIONS

PRODUCT DESCRIPTION

Semi-gloss epoxy enamel for interior industrial and home use (e.g. garage floors, etc.)

PRODUCT USES

- For application on concrete floors, cement plaster walls and suitably primed metal surfaces.

FEATURES AND BENEFITS

- Good resistance to a wide range of chemicals and most solvents.
- Cures to a hard film with good adhesion and abrasion resistance.
- Provides an economical alternative to tiling in bathrooms, showers, kitchens, toilets and low-cost housing.
- Suitable for surfaces that require frequent cleaning with solvents, detergents or alkaline cleaners.

PRODUCT INFORMATION

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| Appearance | Semi- gloss |
| Colour | White, Light Grey, Dark Grey and Brilliant Green |
| Binder Type | Polyamide cured Epoxy |
| Density at 23°C | Approx. 1.30 |
| Solids Content | By weight: Approx. 60% By volume: Approx. 44% |
| Packaged Viscosity | Viscosity at 23°C: Approx. 70 KU |
| Spreading Rate at 35µm DFT | Brush: Approx. 9 m ² per litre, depending on surface porosity, profile and application method |
| Recommended DFT per coat | Min. 50µm. Max. 60µm. |
| Recommended WFT per coat | Min. 110µm. Max. 140µm (Higher film build will increase resistance) |
| Flash Point | 25°C |

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APPLICATION INFORMATION

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| Mixing Ratio | 4 parts <u>BASE</u> (coloured) to 1 part <u>CURING AGENT</u> (clear) by volume. | | |
| Mixing | Stir the BASE and CURING AGENT separately until homogeneous with a flat paddle. Then add the CURING AGENT to the BASE and stirring until homogeneous with a flat paddle. | | |
| Application Surface conditions | Surface Temperature between 10 - 35°C. Relative Humidity between 10 - 85 % OR 2°C above dew point minimum. | | |
| Application methods | <p>Dulux Trade Hichem Epoxy Enamel is packaged in two components in the proper proportions which must be mixed together until homogenous before use. See Mixing</p> <p><u>Airless Spray</u>: Ready for use</p> <p><u>Air Spray</u>: After mixing, thin 10% by volume</p> <p><u>Brush</u>: Can be used on small areas where joining is not a problem e.g. signs, pipes, colour bands, etc.</p> <p><u>Roller</u>: Short nap roller maintaining a wet edge.</p> <p><u>Self-Priming on porous masonry</u>: The product can only be over coated with itself. If a primer is required on concrete or cement plaster, Dulux Trade Hichem Epoxy Enamel thinned 10% by volume can be utilised as a primer coat.</p> <p>N.B. Mix the paint first, then stir in the thinners.</p> | | |
| Thinner | <p>Dulux Trade Heavy Duty Thinners for spraying to maximum of 10% of product volume <u>and should only be added after mixing the Curing Agent with the Base and stirred homogeneous with a flat paddle.</u></p> | | |
| Induction Period | 30 minutes at 23°C (Do not paint immediately after mixing regardless of the application method). | | |
| Pot Life to gelation | Approx. 4 hours at 23°C after induction period, pot life decreases at higher ambient temperatures. | | |
| Drying Time | Dry to handle: 24 hours at 23°C. | | |
| Recoating Time | 6 hours minimum; up to 7 days maximum at 23°C. (Drying times will be extended during cold, wet or humid conditions.) | | |
| Applied product ready for use | Temperature +23°C | Foot Traffic 48 Hours | Light Vehicle Traffic 7 Days |

APPLICATION INFORMATION

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| Cleaning of equipment | After use, remove as much product as possible, and then clean immediately with Dulux Trade Heavy Duty Thinners . |
| Substrates | Correctly prepared cement plaster, concrete and correctly prepared and primed mild steel and iron |

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APPLICATION INFORMATION

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| Precautions: | <p>Do not apply during cold (below 10°C) or wet weather.</p> <p>Do not apply directly to bare metal surfaces.</p> <p>Recommended for interior surfaces only, as the film will chalk on exterior exposure.</p> <p>Cure is slow at low temperatures; below 15°C it takes some days to reach handling and recoating hardness.</p> <p>The pot life is short above 35°C; shield pressure pots and fluid lines from direct sun.</p> <p>Equipment and brushes must be cleaned immediately.</p> <p>Heat resistant to $\pm 120^{\circ}\text{C}$ (continuous) although some yellowing occurs above 100°C.</p> <p>Not suitable for direct application to powdery or friable surfaces whether previously painted or not.</p> |
| Coats Required | <p>Apply two to three finishing coats to new surfaces to achieve a minimum continuous film of 70µm microns to produce closed film and solid colour.</p> <p>For non-skid pedestrian areas, three full coats will be required. See "SURFACE PREPARATION".</p> |

SURFACE PREPARATION

Ensure that surfaces are sound and free from dust, oil, grease, dirt, and debris. Surfaces must be thoroughly dry - no more than 12% moisture content.

NEW SURFACES

Cement Plaster, Concrete (non-friable)

- Freshly rendered concrete should have dried/cured for a minimum of 6 weeks, the moisture content of the concrete should be below 12% before any preparation and painting is attempted.
- It is recommended that fresh plaster should be allowed 1 week drying for every 5mm thickness; and longer in cold or damp weather.
- Ensure the entire surface is sound and clean. Remove any plaster spills, and all loose debris from the surface, ensuring an evenly profiled and clean surface.
- To chemically profile the concrete floor: Acid etch with a solution of hydrochloric acid to remove laitance, uncured cement, etc. as follows:
 - ✓ On steel or power floated concrete (very smooth), use one volume hydrochloric acid to two volumes water. More than one application may be necessary to achieve a paintable surface.
 - ✓ On wood floated concrete (rough), use one volume hydrochloric acid to four volumes water.

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SURFACE PREPARATION

NEW SURFACES

Cement Plaster, Concrete (non-friable) - Continue

- Allow the acid solution to react for 15 minutes and then wash away all acid with copious amounts of clean water. **N.B.** Hydrochloric acid is corrosive - please wear protective clothing, gloves, masks and eye goggles against splashes.
- Remove excess water and allow thorough drying – no more than 12% moisture content.

Floors Concrete – NON-SKID Pedestrian areas (walkways and passages)

- Follow the cleaning and etching instructions under surface preparation, new surfaces, Cement Plaster, Concrete (non-friable)
- Coat 1 – Apply and, while it is still wet, sprinkle dry, silica sand over the surface. (The silica sand should be sifted through a 250µm sieve and retained on a 210µm sieve. A practical spreading rate is 500 grams of sand per square meter of painted floor.)
- Coat 2 - The following day, sweep off any excess sand and apply a further coat to seal the surface. Allow overnight drying again
- Coat 3 – Apply 3rd coat
- Observe chemical curing times as stated in this technical data sheet.

Mild Steel and Iron

- Inspect shop-primer thoroughly for damage by installation. Abrade new surfaces lightly and remove rust, mill scale by sanding, scraping or with steel wire brushes back to sound mild steel and iron or sandblast to SA 2½.
- Ensure that the sanded areas are dry and free of grease and dust. A solvent wash (rags dipped in lacquer thinner) may be used. Change the rags frequently. Allow drying, OR clean with **Dulux Galvanised Iron Cleaner** according to technical data sheet.
- Prime immediately after preparation with one or two coats **Dulux Trade Corrocote 1 Metal Etch Primer**, depending on the severity of the conditions. Two coats are preferred for coastal conditions.

PREVIOUSLY PAINTED SURFACES

- The existing coating system should be dry and free of contaminants such as oil, grease and loose paint.
- Test that the surface will accept epoxy by allowing a cloth soaked with **Dulux Trade Heavy Duty Thinners** to rest on it for 15 minutes - it must not lift or wrinkle. If lifting or wrinkling occurs, the paint must be removed with paint stripper or any other suitable means.
- Abrade damaged or failed areas back to a sound substrate and treat as new.
- Aged or weathered epoxies or urethanes must be well sanded to a matt finish to provide a profile for adhesion.

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HEALTH AND SAFETY INFORMATION

Warning. Flammable liquid and vapor. Causes skin irritation. May cause an allergic skin reaction. Causes serious eye irritation. Suspected of causing cancer. May cause damage to organs through prolonged or repeated exposure. Harmful to aquatic life with long lasting effects.

Solvent based paints are flammable. Dulux Trade paints contain no added lead. Avoid contact with skin or eyes. Keep out of reach of children. If accidentally swallowed, seek medical advice immediately and show this container to the doctor. Dry sanding, flame cutting and/or welding of the dry paint film will give rise to dust and/or hazardous fumes. Wet sanding should be used wherever possible. If exposure cannot be avoided by the provision of local exhaust ventilation, suitable respiratory protective equipment should be used. Do not empty into drains or watercourses. Ensure good ventilation during application and drying. It is recommended to use suitable protective clothing and equipment.

Safety and Technical Datasheets available on request or visit www.duluxtrade.co.za. Call a POISON CENTRE or doctor/physician if you feel unwell. Dispose of contents and container in accordance with all local, regional, national or international regulations.

To avoid the risk of spillage, transport containers in a secure upright position. Always store under ambient conditions.

ADDITIONAL INFORMATION

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| Packaging | 5 Litre (4L base in large tin, 1L curing agent). |
| Storage Conditions | Store under cool dry conditions away from direct sunlight, heat and extreme cold. |
| Disclaimers | <p>Colour references are as accurate as modern printing will allow. Please refer to colour cards for an accurate representation of the colour.</p> <p>Among others, the following factors may affect final colour appearance: product sheen and texture, colour and light reflections, application, surface texture and preparation.</p> <p>For best colour and sheen consistency, it is advisable to use containers of the same batch number, to mix different batches together in a large container, or to finish in a corner before starting a new container.</p> |

TDS STANDARD DISCLAIMER

The recommendations contained herein are given in good faith and meant to guide the specifier or user in accordance with good painting practices. They are gained from our tests and experiences and are believed to be accurate and reliable. No warranty/guarantee is implied by the recommendations contained herein since the conditions of use; application method, substrate and cleanliness of the substrate are beyond Dulux control.

Important Note; Technology may change with time, necessitating changes to this Technical Data Sheet (TDS).

It is the responsibility of the user to ensure that the latest TDS is being used for reference. Dulux Technical Data Sheets are available on our website www.duluxtrade.co.za or please contact: Dulux On-Line on 0860 330 111. Email ZA.Helpline@akzonobel.com

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