

LUXSICO®



**Industrial
Coatings**

LUXSICO® 521-302 U-122BU blue epoxy enamel

ADVANTAGES

- Good exterior resistance.
- Good chemical resistance.
- Meets Ontario Hydro specification W23M-82.

USES

- A one coat system for interior and exterior application such as: transformers, transportation, heavy machinery, containers, structural steel.
- This product has an excellent adhesion.
- It has also an excellent resistance to water and humidity.

STORAGE

This product may be stored for a minimum period of 12 months in its original unopened container at a maximum of 35°C (95°F).

RESTRICTION

Do not apply at temperatures below 10°C (50°F).

DRY FILM PROPERTIES

Tests performed on cold rolled steel coated with the primer 525-634 (1 mil/25 microns D.F.T.) and the topcoat 521-302 (2 mils/50 microns D.F.T.).
The curing period is 7 days at 25°C (77°F).

Adhesion to substrate: 100% - 5B (ASTM D-3359B)

Gloss (60°): 70° < (ASTM D-523)

Hardness: B - HB (ASTM-3363)

Corrosion resistance: Passes 500 hours with primer 525-634
(ASTM B-117)

Humidity resistance: Passes 1000 hours with primer 525-634
(ASTM D-2247)

Gloss /color retention: 250 hours - >65% retention
(ASTM G-53/D-523)

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LUXSICO® 521 -302 U-122BU blue epoxy enamel

CHARACTERISTICS (of sprayable mix)

Viscosity delivered at 25°C (77°F): 60-65 KU
Weight solids: 39±2%
Volume solids: 30±1%
VOC: 598.8 g/litre (4.99 lbs/US gal.)
Spreading rate: 12.1 m²/litre (495 ft²/US gal.)
Dielectric strength (dry): over 1500 vI/mil
Dielectric strength (wet): over 700 vI/mil

(1) Calculation based on volume solids at a dry film thickness of 1 mil (25 microns).

SURFACE PREPARATION

- The surface must be clean, dry free from dust, oil, rust or any other contaminant.
- Metal surfaces must be chemically cleaned, sandblasted or primed.

MIX AND DILUTION

Reduce from 10 to 25% by volume with the diluent:

- . 599-011 (medium evaporation) or
 - . 500-014 (slow evaporation)
- depending on spray equipment used.

APPLICATION METHOD

By spray, using either:

- air-assisted
- airless
- H.V.L.P.
(or their electrostatic versions)
- dipping
- flow coat
- brush

Application recommendations:

- Normal application temperature: 15-30°C (59-86°F).
- Dry film thickness: 1.5 to 2.0 mils (37.5 to 50 microns).

DRYING SCHEDULE

Tests performed at a wet film thickness of 4.5 mils (112.5 microns), a temperature of 25C (77°F) and a relative humidity of 50%.

	Air dry	Force dry at 120°F	Force dry at 250°F
To handle	90 minutes		
Full cure	4-6 hours	30 minutes	10 minutes
Recoat	30 minutes	30 minutes	10 minutes

RECOMMENDED PRIMER

Luxsico® series 525.

CLEAN UP

Clean the equipment immediately after use with the lacquer thinner 300-011.

SAFETY MEASURES

Refer to material safety data sheet and product label before use.

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