Light Pole Protective Coating Specifications

Dulux Specification V04/062
Version 3

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Dulux Protective Coatings

Date: **27th July 2004**

Version 3 sees the change of wording in the scope to reflect that atmospheric corrosivity definitions in Australia reflect that in New Zealand

PROTECTIVE COATINGS SPECIFICATION **ORICA IS A QUALITY ENDORSED COMPANY** **INTERNATIONAL STANDARDS ISO 9001:2000**	**Specification Number**	**V04/062**
	Schedule	**1**
	Substrate	**Steel**
	Other	**Galvanised**

PROJECT:	General Work
SITE:	Not specified
SCOPE:	Specification is for the preparation and painting of galvanised steel surfaces. System approximates AS/NZS 2312:1994 System GZLP-E and is recommended for mild environments as designated in that standard

Surface Preparation:

1. Degrease all surfaces in accordance with AS1627.1 Dulux Duthin 020 may be used
2. Power Tool Clean all surfaces to be coated to create a dull, slightly roughened surface ..
3. Degrease all surfaces in accordance with AS1627.1. Dulux Duthin 020 may be used
4. All surfaces must be clean and dry before coating.

Notes

- All surfaces are to be coated within 4 hours of surface preparation completion. All edges, bolts, nuts and difficult to spray areas require brushing in & stripe coating to achieve adequate coating thicknesses. Bevel all sharp edges 2mm radius and remove any weld spatter.

Surface Profile **Uniformly rough & no lustre** **Total System DFT** **125 µm**

	PRIME COAT	SECOND COAT	THIRD COAT
MATERIAL:	**Ultraetch RFU** PVB Etch primer	**Acrathane IF** Catalysed Acrylic Coating	As per second if required
PRODUCT CODE:	466 88924	446 -Line	
DATA SHEET:	PC627	PC218	
THINNER CODE:	Dulux Epoxy Thinner 920 08925	Dulux Urethane Thinner 965 63023	
COLOUR:	Medium Grey	To Colour	
APPLICATION:	CS,AS,B,R	CS,AS,B,R	
% VOL. SOLIDS:	16%	43% (White)	
DRY FILM: (microns)	Minimum 10µm Maximum 15µm **Recommended** 12µm	Minimum 50 Maximum 70 **Recommended** 60µm	
CATALYST:	Single pack product	Acrathane hardener 976 51087	
THEORETICAL COVERAGE M2/L:	16 square metres per litre	7.2 square metres per litre	
RECOAT TIME: @ 25 C & 50% RH	minimum: 10 minutes maximum: 24 hours	minimum: 8 hrs maximum: 1 month	

APPLICATION METHODS: **B = Brush R = Roller CS = Conventional Spray AS = Airless Spray HG = Hopper Gun HT = Hawk & Trowel TRLP = Textured Roller Low Profile TRHP = Textured Roller High Profile SC = Serrated Comb**

NOTES:	1. This is an abridged specification and must be read in conjunction with the technical data sheets. 2. Applicator to ensure that all colours supplied match the approved standard prior to commencement. 3. The use of other thinner than nominated herein may impair performance of the coating. 4. System life is dependent upon service conditions. 5. Refer to Dulux for additional information.
DISCLAIMER:	All information contained in this specification is as accurate and up to date as possible. Products can be expected to perform as indicated in this specification, as long as preparation and application procedures are followed as recommended. However, there are no expressed or implied warrranty s set out in this information other than implied by the Commonwealth, State or Territory legislation.

PREPARED BY: Tony Leard **DATE: 21st June 2004**

PROTECTIVE COATINGS SPECIFICATION

ORICA IS A QUALITY ENDORSED COMPANY
INTERNATIONAL STANDARDS ISO 9001:2000

Specification Number	**V04/062**
Schedule	**2**
Substrate	**Steel**
Other	**Galvanised**

PROJECT:	Coastal Work
SITE:	Not specified
SCOPE:	Specification is for the preparation and painting of galvanised steel surfaces. System is designed for coastal or chemical exposure where the corrosivity is defined as moderate in AS/NZS2312:1994. This standard acknowledges that atmospheric corrosivity in both countries are in the same order and as such is applicable to New Zealand as well as Australia

Surface Preparation:

1. Degrease all surfaces in accordance with AS1627.1 Dulux Duthin 020 may be used
2. Whip Abrasive blast clean all surfaces to uniformly etch the surface.
3. Degrease all surfaces in accordance with AS1627.1. Dulux Duthin 020 may be used
4. All surfaces must be clean and dry before coating.

Notes

- All surfaces are to be coated soon after surface preparation completion. All edges, bolts, nuts and difficult to spray areas require brushing in & stripe coating to achieve adequate coating thicknesses. Bevel all sharp edges 2mm radius and remove any weld spatter.

Surface Profile **Uniformly rough & no lustre** **Total System DFT** **185 µm**

	PRIME COAT	SECOND COAT	THIRD COAT
MATERIAL:	**Duremax GPE ZP** Epoxy ZP Primer	**Acrathane IF** Catalysed Acrylic Coating	As per second coat if required
PRODUCT CODE:	78052033	446 -Line	
DATA SHEET:	PC215	PC218	
THINNER CODE:	Dulux Epoxy Thinner 920 08925	Dulux Urethane Thinner 965 63023	
COLOUR:	Lightbox Grey	To Colour	
APPLICATION:	CS,AS,B,R	CS,AS,B,R	
% VOL. SOLIDS:	71%	43% (White)	
DRY FILM: (microns)	Minimum 100µm Maximum 150µm **Recommended** 125 µm	Minimum 50 Maximum 70 **Recommended** 60µm	
CATALYST:	GPE Standard Part B 976 84577	Acrathane hardener 976 51087	
THEORETICAL COVERAGE M2/L:	5.7 square metres per litre	7.2 square metres per litre	
RECOAT TIME: @ 25 C & 50% RH	minimum: 8 hrs maximum: 24 hours	minimum: 8 hrs maximum: 1 month	

APPLICATION METHODS: **B = Brush R = Roller CS = Conventional Spray AS = Airless Spray HG = Hopper Gun HT = Hawk & Trowel TRLP = Textured Roller Low Profile TRHP = Textured Roller High Profile SC = Serrated Comb**

NOTES:	1. This is an abridged specification and must be read in conjunction with the technical data sheets. 2. Applicator to ensure that all colours supplied match the approved standard prior to commencement. 3. The use of other thinner than nominated herein may impair performance of the coating. 4. System life is dependent upon service conditions. 5. Refer to Dulux for additional information.
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