

# EPOCOAT 21 HB

## High Build Epoxy Primer

### DATA SHEET 2/08

#### PROPERTIES AND RECOMMENDED USAGE

##### Paint type:

EPOCOAT 21 HB is a two-component high build polyamide cured fast drying epoxy primer. It meets with the Swedish standard SS 1852 01 for two-component paints.

##### Typical uses:

EPOCOAT 21 HB is an adherent primer, recommended to be used on abrasive blast cleaned structural steel, pipe bridges and conveyors. etc in environment classes C2-C4 and C5-I/ C5-M. Suitable for a variety of substrates. Can also be coated with polyurethane topcoats.

##### Most common SFS-EN ISO 12944-5 systems:

- A2.06 EPPUR120/2-FeSa2½
- A4.13 EPZn(R)EP160/3-FeSa2½
- A4.08 EPPUR240/3-FeSa2½
- A5I.02 EPPUR320/4-FeSa2½

##### Chemical resistance:

Used in recommended paint systems EPOCOAT 21 HB withstands occasional splashes and spillage of water and a wide range of weak process chemicals.

#### TECHNICAL DATA

<b>Volume solids:</b>	approx. 62 vol.%
<b>Total mass of solids*:</b>	approx. 1060 g/l
<b>VOC value*:</b> (Volatile organic compound)	approx. 320 g/l

(\*Values are calculated.)

##### Mixing ratio:

Resin            4 parts by volume  
Cure             1 part by volume

##### Pot life: at +23°C

with Standard Comp.B: approx. 6 h after mixing  
with S-Comp.B:            approx. 3 h after mixing

Drying times: 80 µm	Standard Comp.B		S-Comp.B	
	+10°C	+23°C	+10°C	+23°C
Surface dry	2 h	1 h	1 h	½ h
To touch	10 h	4 h	6 h	2½ h
To recoat				
- same type of paint	10 h	4 h	7 h	3 h
- Normadur HB / 65 HS /				
90 HS / 80 Aluminium	16 h	5 h	12 h	4 h
- immersion service	24 h	16 h	24 h	16 h
Fully cured	12 d	7 d	12 d	7 d

##### Calculated theoretical coverage and recommended film thickness:

Dry	Wet	Coverage
80 µm	130 µm	7,7 m <sup>2</sup> /l
120 µm	195 µm	5,1 m <sup>2</sup> /l
150 µm	245 µm	4,1 m <sup>2</sup> /l

##### Practical coverage:

Depends on wind conditions, structure to be painted, roughness of the surface and application method.

**Colour:** Red, grey, beige, black

**Thinner and cleaner:** OH 17

**Finish:** Semimatt

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### APPLICATION INSTRUCTIONS

**Surface preparations:**

Ice, concrete, plaster and other solids should be removed by scraping or brushing. Remove salt and other water soluble contaminants by water cleaning with brush, high pressure, steam or alkali cleaning. Grease and oil should be removed by alkaline-, emulsion- or solvent cleaning (SFS-EN ISO 8504-3, SFS-EN ISO 12944-4).

**Steel surfaces:**

Blast cleaning to minimum of Sa2½ (SFS ISO 8501-1, SFS-EN ISO 8504-2).

**Shop primed surfaces:**

Damaged or corroded surfaces should be blast cleaned to a minimum of Sa2½ (SFS ISO 8501-2, SFS-EN ISO 12944-4).

**Aluminium surfaces:**

Remove grease and other contaminants. Sand-sweeping before painting improves adhesion.

**Galvanized surfaces:**

Remove grease, zinc salts and other impurities. Sand-sweeping before painting improves adhesion.

**Primer:**

EPOCOAT 21 PRIMER,  
EPOCOAT 21 HB,  
NORMAZINC SE, RESIST 86

**Top coat:**

EPOCOAT 210, EPOTEX HB,  
NORMADUR HB, NORMADUR 65 HS,  
NORMADUR 80 AL, NORMADUR 90 HS

1-comp. products are not recommended.

**Environmental conditions during application:**

The surface should be dry and clean. During application and drying time the temperature of the paint, air, and surface should be above +10°C and the relative humidity below 80 %. The surface temperature should be min 3°C above the dew point of the air.

**Method of application:**

Use high pressure airless spray or brush. Stir resin and cure separately and then mix both components thoroughly. The mixing ratio is 4:1 (resin:cure) by volume. Thin only as needed for workability with no more than 15 % of OH 17. High pressure airless spray with a nozzle tip of 0,013" - 0,018" orifice. Spray angle depending on the object to be painted.

**SAFETY**

Please follow the environmental and safety instructions displayed on the container and Safety Data Sheet.

Use under well ventilated conditions. Do not breathe or inhale mist, use respirator mask. Avoid skin contact. Spillage on the skin should immediately removed with suitable cleanser, soap and water. In case of contact with eyes, rinse immediately with plenty of clean water and if necessary seek medical advice.

For specific information on hazardous constituents and more detailed safety measures see Safety Data Sheet.

**DISCLAIMER**

The above information is given to the best of our knowledge based on laboratory tests and practical experience. However, as the paint is often used under conditions beyond our control, we cannot guarantee anything but the quality of the paint itself. We reserve the right to change the given data without notice.