

EPOTEX HB

Resin Modified Epoxy Coating

DATA SHEET 6/09

PROPERTIES AND RECOMMENDED USAGE

Paint type:

EPOTEX HB is a two-component epoxy coating, modified with chemical resistant hydrocarbonresin. It meets the requirements of the swedish standard SS 1852 05 and SSG 1005 for two-component paints.

Typical uses:

Steel surfaces:

EPOTEX HB is recommended for use as a under or top coat on zinc epoxy primer or other two-component epoxy primers in environment classes C2-C4 and C5-I/C5-M. EPOTEX HB is suitable for water immersion when the surface is blast cleaned to Sa2½. EPOTEX HB is suitable for single coat system without primer in environment classes C1-C3.

Concrete surfaces:

EPOTEX HB is recommended for use in chemical processing industry and damp warehouses etc. interior use on concrete walls and machine beds as a protective coating for environment classes C2-C4 and C5-I. This product meets the vapour barrier requirements of paper industry when applied over 250 µm thickness.

Most common SFS-EN ISO 12944-5 and SFS 5873 systems:

- A2.06 EP120/2-FeSa2½
- A3.11 EPZn(R)EP160/2-FeSa2½
- A4.08 EP240/3-FeSa2½
- A5I.02 EP320/4-FeSa2½
- F20.04 EP100/1-FeSa2

Chemical resistance:

EPOTEX HB is resistant to occasional water-, oil- and diluted chemical splashes and spillage in recommended paint systems and when correctly applied. Withstands water in immersion service.

Weather resistance:

EPOTEX HB will loose its gloss under the influence of UV-radiation, which also may cause slight yellowing in light colours.

TECHNICAL DATA

Volume solids:	approx. 65 vol.%
Total mass of solids*:	approx. 1070 g/l
VOC value*: (Volatile organic compound)	approx. 310 g/l

(*Values are calculated.)

Mixing ratio:

Resin 4 parts by volume
Cure 1 part by volume

Pot life: at +23°C

with Epotex Comp.B: approx. 5 h after mixing
with S-Comp.B: approx. 3 h after mixing

Drying times: 80 µm	Epotex 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	125 µm	8,1 m²/l
125 µm	190 µm	5,2 m²/l
200 µm	310 µm	3,2 m²/l

Practical coverage:

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

Colour: RAL-, NCS-, KY-, SSG-colours (with limitations)

Thinner and cleaner: OH 17

Finish: Semimatt

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APPLICATION INSTRUCTIONS

Surface preparations:

Steel surfaces:

Dust, oils, grease and other foreign matter that could prevent adhesion should be removed using a suitable method (SFS-EN ISO 12944-4). If the paint is applied directly on to steel surfaces the recommended cleaning standard is Sa2½.

New concrete surfaces:

The concrete must be dry and at least 4 weeks old, and humidity no more than 4 %. Uneven surfaces should be smoothed down by grinding. Dust should be brushed off. Abrasive blasting is recommended to remove laitance and other contaminants. If required a 15-20 % hydrochloric acid solution can be used.

Old concrete surfaces:

Grease and oil should be removed by emulsion cleaning. Grease removal can be boosted by flame cleaning. Light abrasive blasting or grinding is recommended to remove all previous and laitance.

Primer: (Steel surfaces)

NORMAZINC SE, EPOCOAT 21 HB, EPOCOAT 21 PRIMER, EPOTEX HB

Top Coat:

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

Environmental conditions during application:

The surface should be dry and clean. During application and drying time the temperature of the paint should be above +10°C and air and surface temperature above +5°C (for immersion service +10°C) and the relative humidity below 80 %. The surface temperature should be min 3°C above the dew point of the air. Exhaust gases during drying time may cause yellowing of the paint film.

Method of application:

Use 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. If needed, 5-15 % thinner OH 17 may be added. High pressure airless spray with a nozzle

tip of 0,013"-0,018" orifice. Spray angle depending on the object to be painted.

Priming:

Concrete surfaces:

Thinned EPOTEX HB is applied on wall with plenty of impregnation. Impregnation can be continued after approx. 8 hours to the objects which has remained thin (+23°C). **If the concrete is damp or new, the primer recommended is NORMAFLOOR 105 Epoxy Primer.**

Top coat:

Concrete surfaces:

Next treatment is recommended to be done between 8 hours and 3 days after priming (+23°C).

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.