

EPOTEX HB

TECHNICAL DATA SHEET 5/24

PROPERTIES AND RECOMMENDED USAGE

Paint type

EPOTEX HB is a two-component epoxy coating, modified with chemical resistant hydrocarbon resin.

Typical and recommended uses

EPOTEX HB is recommended to use as a mid or top coat on zinc epoxy primer or other two-component epoxy primer in environmental classes C2 - C5. It is suitable for water immersion when the surface is blast cleaned to Sa 2½. EPOTEX HB is also suitable to single coat (DTM) systems without primer in environmental classes C1 - C3.

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

Epoxy paints have a natural tendency to chalk and discolor on exterior exposure.

Colour

RAL-, NCS-, KY-, SSG-colours with limitations. The objects painted with the same shade, but using different paint types, might have differences in the appearance and shade due to the variation in the paint properties, gloss levels and application methods.

Finish

Semi gloss

TECHNICAL DATA

Volume solids*	65 ± 2 %
Total mass of solids*	1070 g/l
VOC value*	310 g/l

* Values are calculated

Mixing ratio

Resin	4 parts by volume
Cure	1 parts by volume

Pot life (+23 °C)

approx. 4 h after mixing (Epotex HB Comp. B)

Packaging

	Volume (l)	Size of container (l)
Epotex HB	16	20
Epotex HB Comp. B	4	4

Drying time 80 µm

	Epotex HB Comp. B	
	+10 °C	+23 °C
Surface dry	2 h	1 h
To touch	6 h	4 h
To recoat		
- same type of paint	8 h	4 h
- polyurethanes	16 h	5 h
- immersion service	24 h	16 h
Fully cured	12 d	7 d

Drying times are typical on recommended film thicknesses at given temperatures.

Calculated theoretical coverage and recommended film thickness

Dry	Wet	Coverage
80 µm	125 µm	8.0 m²/l
100 µm	155 µm	6.5 m²/l
120 µm	185 µm	5.4 m²/l

Practical coverage

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

Thinner

OH 17, OH 31 (slow)

Cleaner

OH 17

APPLICATION INSTRUCTIONS

Surface preparations

All solid impurities that could prevent adhesion should be removed from the surfaces to be painted. Remove salts and other water soluble impurities using fresh water with brush, high pressure-, steam- or alkali cleansing. Remove grease and oils by alkali-, emulsion- or solvent cleansing (SFS-EN ISO 8504-3, SFS-EN ISO 12944-4). The surfaces should be rinsed carefully with fresh water after cleansing. Old, painted surfaces, in which maximum overcoating interval has expired, additional roughening with suitable method is recommended. The place and time for the surface preparation should be chosen correctly, to avoid contamination and moistening of the treated surface before the paint application.

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 Sa 2½.

Galvanized surfaces

Remove grease, zinc salts and other impurities. Sand sweeping before painting improves adhesion. Thinning is recommended.

Primer

EPOCOAT 21 HB, EPOCOAT 21 PRIMER, EPOTEX HB, NORECOAT FD PRIMER, NORMAZINC SE, PENGUARD EXPRESS, NORECOAT HS PRIMER

Top coat

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

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. Please contact our office for more specific information. The product is intended for professional use only. If there are deviations in the different language versions of the technical data sheets, the English version applies.

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 process 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, 0 - 10 % thinner OH 17 may be added. High pressure airless spray with a nozzle tip of 0.013" - 0.015" orifice. Spray angle depending on the object to be painted. In order to ensure the best possible performance of the product, it is recommended that the paint is at room temperature before the application.

Storage and shelf life

The product must be stored in original sealed containers at temperatures from 5 °C to 30 °C. The storage conditions are to keep the containers in a dry, well ventilated space away from source of heat and ignition. When stored as described above, the unopened component A will keep up to 3 years and unopened component B to 3 years from the date of manufacture. The manufacturing date found in the label is also the batch number of the paint.

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 or water. In case of contact with eyes, rinse immediately with plenty of clean water and if necessary seek medical advice.