

Epifanes Epoxy HB Coat

Two-component high build epoxy paint



PRODUCT DESCRIPTION

Two-component high build coating with high anti-corrosive properties on steel and provides excellent protection against osmosis on fiberglass/GRP. The quick drying and high solid contents allow rapid building of epoxy dry film thickness.

Field of use: Fiberglass/GRP - Steel - Plywood - aluminum: fast building of a watertight coating inside and outside, above and below the waterline. For repairing and as anti-osmosis coating on fiberglass. Also for maintenance of existing epoxy systems and coating of concrete surfaces.

PRODUCT INFORMATION

Type	Chemical drying						
Base	Modified epoxy resin						
Gloss	Semi gloss						
Colour	Black - Light Grey						
Density at 20°C.	1.68gr. / dm ³ (mixed product)						
Viscosity	100 seconds DIN-cup 4 mm						
Solids Contents	87 ± 2 vol. %						
VOC-level	213 grams/liter (mixed product)						
Packing	625ml. Component A + 125ml. Component B = 750ml. 3335ml. Component A + 625ml. Component B. = 4000ml.						
Shelf life	In closed unopened container stored between 5 - 25°C Base component A 2 years after production date Curing component B 1 year after production date						
Mixing ratio	By volume :100 parts component A + 20 parts component B (5 : 1) By weight :100 part component A + 12 parts component B						
Rec. filmthickness	100 - 200 µm wet = 85 - 175 µm dry						
Potlife after mixing	<table border="1"> <thead> <tr> <th>15°C.</th> <th>20°C.</th> <th>25°C.</th> </tr> </thead> <tbody> <tr> <td>4 hours</td> <td>3 hours</td> <td>1.5 hours</td> </tr> </tbody> </table>	15°C.	20°C.	25°C.	4 hours	3 hours	1.5 hours
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Thinner brush	Epifanes D-601 Epoxy Thinner						
Thinner spray	Epifanes D-601 Epoxy Thinner						
Thinning in general	Thinning ratio depends on product temperature and working area. Avoid overthinning. For thinning ratios, refer to the Epifanes paint systems.						

Drying times at 65% RLV	12°C.	15°C.	20°C.	25°C.
Dust Dry	5 hours	3hours	2 hours	1 hour
Recoatable	15 hours	10 hours	6 hours	4 hours
	48 houts	36 hours	24 hours	20 hours

If subsequent coat is applied within 24 hours, intercoat sanding is not required. After 24 hours always sand with P120 before applying a fresh coat Epoxy HB Coat. Do not apply Epifanes Epoxy HB Coat below 12°C. The above mentioned drying times are indicative at 65% RAH and 85 µm dry film thickness. Drying also depends on the amount of ventilation and applied wet film thickness. Higher wet film thickness and/or limited ventilation results in longer drying times. Especially flat surfaces may take longer to dry due to high wet film thickness. Allow each paint coat sufficient time to dry. Do not apply wet-on-wet!



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APPLICATION

Conditions during application Temperature **minimal 12°C. - maximal 28°C.**
 Relative air humidity **minimal 50% - maximal 75%**

Best results are achieved by roller, longhaired soft brush or by spray. Evenly distribute the paint over the surface and do not retip. Do not apply wet-on-wet. Do not apply excessive wet film thickness to avoid the formation of curtains and drying problems. Avoid painting in direct sunlight or too much wind. A rapid loss of solvents will occur under these conditions and decrease the flowing ability. The maximum difference in temperature between the surface and the paint is 3°C. In case the product “pulls” and is difficult to apply, 10% Thinner D-601 may be added. After drying, firmly sand the surface with P120 before applying the next coat.

Guidelines for spray application	Nozzle	Pressure	Thinning ratio
Air spray	1.3 - 1.6mm	2 - 2.5 Bar	5 - 25%.
Airless Spray	0,016 - 0,018	170-250 bar	0-5%

Surface conditions steel Completely remove rust, grease, dirt and other contaminants. Remove salt and other water-soluble dirt by thoroughly rinsing with clean water and high-pressure cleaner or an emulsifier. Remove grease and oil by cleaning with water and ammonia or another suitable cleaning agent. Coarse sanding P 60-80

GRP Degreased with Epifanes Polyester Degreaser and sanded P240

Additional remark Sand every coat Epoxy HB Coat with dry sandpaper P120
 On new aluminium it is recommended to apply 1 coat of Epifanes Wasprimer AQ.

Existing painted surface Clean the surface well and degrease with Epifanes Spray Thinner. Follow by sanding the surface with P180-220. Always clean and degrease again with Epifanes Spray Thinner for Paint & Varnish.

Theoretical coverage 6m² per liter @ 85 µm dry filmthickness

Practicle coverage The total coverage is dependent on the wet film thickness, surface, application technique and use of any thinners.

Above the waterline	Below the waterline	Inside superstructure	Wet bilge area
170 µm	340 µm	170 µm	340 µm

Remark on coverage Brush application : 90% of technical coverage
 Spray application : 70% of technical coverage (large surfaces)
 50% of technical coverage (small surfaces)

Suitable Primer Epifanes Epoxy Primer, dry, clean, degreased and sanded P120-150.
 On existing old epoxy systems thin first coat Epoxy HB Coat by 20-25%

Recoatable above waterline Epifanes Epoxy Primer - Epifanes Poly-urethane Primer
 Epifanes Poly-urethane Yacht Coating

Recoatable below waterline Epifanes Interimcoat + antifouling

Suitable fillers After degreasing and sanding P120
 Epifanes Epoxy Filler 1500 - Epifanes Epoxy Finishing Filler

Safety The user of this product should obey all national laws and legislation concerning health, safety and environmental hazard. For more information on health and safety, refer to the Material Safety Data Sheet of this product.

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