



EPOXY HB

Two Pack High Build High Solids Epoxy Primer

Description

- 2-pack high solids high build epoxy mastic coating for protection of steel & concrete against corrosion.

Properties

- Low temperature curing
- High corrosion, solvent and abrasion resistance
- Finish with 2-pack or 1-pack coatings

Typical Applications

- Steelwork & Steel structures, bridges, tank exteriors, oil refineries, pipe work, Etc. also can be used as a finish for concrete floors

General Data

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|---------------------|--|
| Weather resistance | Good (will chalk and yellow on prolonged exterior exposure, however film integrity is not compromised) |
| Solvent resistance | Resists splashes of most common solvents; not recommended for continuous immersion |
| Chemical resistance | Good |
| Abrasion resistance | Good |
| Suitable topcoats | Rhinamel [®] , Rhinothane [®] T, Rhinothane [®] AC, Rapid Enamel, Purlenamel, Implement Enamel, Auto Enamel |

Specifications (at 25°C and 50% relative humidity)

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| Resin type..... | 2 Pack Epoxy Mastic. |
| Mixing ratio..... | 1: 1 |
| Solids content..... | 85% +/- 2% (by volume) |
| Typical film thickness (per coat)..... | 150 - 200 microns (dry)
175 – 235 microns (wet) |
| Theoretical coverage..... | 5m ² / L @ 170 microns dry film thickness |
| Touch dry..... | 14 h @ 10 °C, 2 h @ 30 °C |
| Hard dry..... | 20 h @ 10 °C, 3 h @ 30 °C |
| Full cure..... | 7 days (will not cure at temperatures below 5°C) |
| Maximum Recoat Time @ 20 °C | With 1-pack products a 24 hours, with 2-pack products 72 hours, beyond |
| with | these times sanding is required before recoating, these times will vary with temperature, longer at low temperatures & shorter at high temperatures. |
| Pot life..... | 500 mL mix 1 h @ 25 °C (will vary with temperature, size of mix, and level of thinner added) |
| Gloss..... | Semi Gloss |
| Colour..... | White |
| Shelf life..... | minimum 12 months (in cool, dry conditions) |

Surface Preparation

- New Steel: Degrease, then abrasive blast to AS 1627.4 Class 2½ or equivalent abrasion with a suitable power cleaning tool (e.g. disc sander)
- Previously coated steel: Degrease then high pressure wash with fresh water to remove soluble salts, then abrasive blast to AS 1627.4 Class 1 or equivalent abrasion with power tools or hand tools.
- Concrete: Allow 28 days curing of new concrete then acid etch or captive shot blast. Old concrete: Degrease then wash with fresh water to remove soluble salts.

Mixing recommendation

EPOXY HB

- Mix only the quantity required for the job
- Mix Pack A with Pack B in the ratio 1:1
- Stir thoroughly with a broad paddle or mechanical mixer to ensure even mixing of the two parts
- Thin as required with Wagon Paints' T3 Epoxy Thinner (see Application directions), and stir as above

Application

- May be spray applied using airless or conventional air spray equipment,
- Small areas may be coated by brush or roller, multiple coats may be required to achieve proper thickness
- **Airless Spray** nozzle size.....0.425 - 0.525 mm
nozzle pressure..... 2800 - 4000 psi (19 - 27mPa)
volume of thinner.....As required
- **Air Spray** nozzle size.....1.6 - 2.0 mm
nozzle pressure.....45 - 60 psi (300 - 400kPa)
volume of thinner..... up to 20%
- **Cleaning solvent**T3 Epoxy Thinner

Safety precautions

- **Refer to the relevant Material Safety Data Sheets for Pack A and Pack B**
- Contents are flammable – keep away from all ignition sources
- Avoid contact with skin and eyes – when mixing, wear gloves and goggles
- When spraying, ensure adequate ventilation and wear appropriate protective clothing and equipment

Packaging Group III UN No. 1263

Pack sizes 2 litre, 10 litre, (Pack A)
2 litre, 10 litre, (Pack B)

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June 2008

These technical data and recommendations are based on tests and information believed to be accurate at the time of printing. They should not be construed as containing any warranty, either expressed or implied. Users should conduct their own tests to determine final suitability of this product.



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