

Epifanes Epoxy HB Coat

Two-component ultra high building coating, based on a modified epoxy resin. For use as high film building coat on steel, aluminum, fiberglass and (ply-)wood. Filling primer coat for any high performance two-component paint system. For interior and exterior use, above and below the waterline.

Type	Chemically drying
Base	Modified epoxy resin
Colour	White - off white
Gloss	Semi gloss
Mixing ratio	
- by volume	5 parts base component A + 1 parts curing component B
- by weight	8.8 parts base component A + 1 parts curing component B
Potlife after mixing	1 hour at 20°C/65% RAH
Density	1,68 kg/dm ³ (mixed product)
Solids content	87.7 ± 2 vol.% (mixed product)

Drying times	
- at 15°C / 65% RAH	Surface dry : 3 hours - through dry : 36 hours - Fully cured : 7 days
- at 20°C / 65% RAH	Surface dry : 2 hours - through dry : 24 hours - Fully cured : 5 days
- at 30°C / 65% RAH	Surface dry : 1 hour - through dry : 20 hours - Fully cured : 4 days

If next coat is applied within 2 days, no sanding is needed. If this overcoating period is missed, first degrease the coat and sand with 120 grit abrasive paper used dry.

Recoatable With all EPIFANES two pack products. Min. 24 hours at 20°C. / 65% RAH

Application	Airless spray	Air spray	Brush / roller
Thinner	Epifanes Epoxy Thinner D-601		
Volume.%	0- 5	5 - 10	0 - 10
Nozzle	0.016" - 0.018"	1.5 - 1.8 mm	
Pressure in Bar	150-180	3-4	

Thinner all applications 3330ml. Base component A + 666ml. Curing component B = 4000ml.

Recommended film thickness Recommended wet film thickness (wft) : 100 - 200 µm
Recommended dry film thickness (dft) : 90—180 µm

Application temperature 12°C / 50°F minimum

Coverage - theoretical 5 m² per litre @ 180 µm dft
- practical Dependent on application method, roughness and condition of substrate, loss of material due to shape of object, circumstances during application, etc.

Guide lines for coverage
- brush application 90% of technical coverage
- spray application 70% of technical coverage on large areas
50% of technical coverage (small areas)

Packing 3330ml. Base component A + 666ml. Curing component B = 4000ml.

Surface conditions Surface must be clean, degreased, dry, well sanded and free of dust.
Remove all salt and other water soluble dirt with fresh water. Remove grease and oil with water and ammonium solution or denaturated alcohol or other suitable detergent.

Application conditions On bare substrates prime with Epifanes Epoxy Primer first. Temperature of paint, object and working area during application and drying should not be lower than 10°C / 50°F. Relative air humidity should not exceed 85%. Temperature of object during application and drying should be at least 3°C / 38°F above dew point.

Handling Handle with care. Stir both components separately prior to mixing. Allow 15 minutes induction time.

Storage Keep container in a dry, cool, well ventilated areas away from heat sources and/or ignition. Keep container tightly closed

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