

# Epifanes Epoxy HB Coat

## Two-component high build epoxy paint

<b>Type</b>	Chemical drying									
<b>Base</b>	Modified epoxy resin									
<b>Properties</b>	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 filmthickness.									
<b>Field of application</b>	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.									
<b>Colour</b>	Light grey - black									
<b>Gloss</b>	semigloss									
<b>Density</b>	1.68 /dm <sup>3</sup> (mixed product)									
<b>Solids contents</b>	87± 2 vol.% (mixed product)									
<b>VOC-level mixed product</b>	213 gram / liter (mixed product)									
<b>Packing</b>	750ml. 4000ml.									
<b>Mixing ratio</b>	<table border="1" data-bbox="624 1048 1439 1182"> <thead> <tr> <th></th> <th>By volume</th> <th>By weight</th> </tr> </thead> <tbody> <tr> <td>Base component A</td> <td>100</td> <td>88</td> </tr> <tr> <td>Curing component B</td> <td>20</td> <td>10</td> </tr> </tbody> </table>		By volume	By weight	Base component A	100	88	Curing component B	20	10
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<b>Induction time at 20°C. / 65% RLV</b>	15-20 minutes									
<b>Potlife after mixing</b>	<table border="1" data-bbox="630 1245 1439 1335"> <thead> <tr> <th></th> <th>at 12°C</th> <th>at 20°C</th> <th>at 28°C</th> </tr> </thead> <tbody> <tr> <td></td> <td>4 hours</td> <td>3 hours</td> <td>1.5 hours</td> </tr> </tbody> </table>		at 12°C	at 20°C	at 28°C		4 hours	3 hours	1.5 hours	
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<b>Shelf life unmixed</b>	In closed container stored in a dark location between 5 - 25°C. approx. 2 years									
<b>Conditions during application and drying</b>	Temperature minimal 12°C. - maximum 28°C. Relative air humidity minimal 50% - maximum 75%  Temperature of substrate must be 3°C. above dew point.									
<b>Thinner brush / roller / spray</b>	Epifanes Thinner D-601									
<b>Thinner guideline</b>	Add thinner after mixing both components. Thinning ratio depends on temperature of mixed product and work area.									
<b>Application tools</b>	Nylon roller - Soft, longhaired brush - conventional air spray.									
<b>Recommended filmthickness / coat</b>	100 - 200 µm wetfilmthickness = 85 - 170 µm dryfilmthickness.									
<b>Application recommendations</b>	Do not apply wet-in-wet. Do not apply excessive wet films to avoid the formation of curtains and drying problems. Avoid applying in direct sunlight or too much wind. A rapid loss of solvents will occur under these conditions and decrease the flowing ability.									

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**Theoretical coverage** 7 m<sup>2</sup> per liter. @ 125 µm dry filmthickness

**Practicle coverage** Dependent on condition of substrate, loss of material due to factors such as application technique, shape of object, circumstances during application.

**Application details**

	Air spray	Airless Spray	Brush / Roller
Thinning volume	5 - 10%	0-5%	5-10%
Nozzle	1.5 - 1.9 mm	0.016 - 0.018"	
Pressure	3 - 4	150-180 bar	
Viscosity DIN-cup 4 mm	20 - 22 sec.	30 - 35 sec.	

**Drying times @ 125 µm dry filmthickness**

	Dustdry	Recoatable	Through hardened
<b>15°C. / 65% RAH</b>	3 hours	10 hours	7 days
<b>20°C. / 65% RAH</b>	2 hours	6 hours	5 days
<b>28°C. / 65% RAH</b>	1 hour	4 hours	4 days

**Intercoat sanding** If subsequent coat is applied within 24 hours (18°C.), intercoat sanding is not necessary. If recoated after 24 hours, sand with P120 dry abrasive paper.

**Required dry film thickness**

Above the waterline	Below the waterline	Inside super-structure	Wet areas
170 µm	340 µm	170 µm	340 µm

**Recommended primer**

Epifanes Epoxy Primer, dry, clean, degreased and sanded P120-150 dry abrasive paper. For optimum adhesion always thin first coat on bare plywood, bare metal and old existing sanded epoxy systems, thin first coat by 20-25% and apply by stiff brush.

**One-component recoatability**

After 24 hours and sanding with P150-180 dry abrasive paper.

**Above the waterline** Epifanes Poly-urethane Yacht Coating - Epifanes Poly-urethane Primer

**Below the waterline** Epifanes Epoxy Primer - Epifanes Interimcoat

**Filler**

Epifanes Epoxy Filler 1500 - Epifanes Epoxy Finishing Filler

**Substrate conditions**

Clean, dry degreased and sanded

**Safety**

The user of this product should obey all 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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