



PRODUCT DATA SHEET

FLOOR COATING SYSTEM

HIGH BUILD EPOXY

1. DESCRIPTION

High build two component polyamide cured epoxy finish.

2. PRINCIPAL CHARACTERISTICS

- Recoatable epoxy finish in the INDUSTRIAL range.
- Suitable for internal steel and concrete structures.
- Suitable for normal and high humidity (maximum 95%) internal atmospheric conditions.
- Will cure at low ambient temperatures.
- Good application properties and can be over coated with two component and conventional paints.
- Good adhesion on most aged, sound alkyd- and epoxy coatings.

3. PACKAGING, COLOURS AND GLOSS

- 4lt and 20lt kits.
- Grey and green (other colours available on request).
- Satin / semi gloss finish.

4. BASIC DATA AT 23°

- Drying time: ± 2hrs surface dry.
± 7days full cure.
- Recoating time: ± min 4hrs for 100µm dft, max unlimited.
- Pot life: ± 6hrs after blending with hardener.
- Induction period: ± 15min – 20min.
- Mass relative density: ± 1.2 – 1.4 g/cm³.
- Solids by volume: ± 71%.
- Viscosity: ± 60 – 75 sec.
- Recommended dft: 100µm per coat. (2 coats recommended.)



PROTECTION WHERE YOU NEED IT!

Limitation of liability applies. Refer to annexure for full disclosure.
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- Theoretical spreading rate: 6 – 8m²/lt for 100µm.
- Practical spreading rate: 5 – 7m²/lt for 100µm.
- Shelf life: at least 12 months in cool and dry conditions.
- Flash point: base 25°C, hardener 28°C.

5. RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

- Previous coat: (epoxy or single pack alkyds) must be free from any contamination and sufficiently abraded if necessary.
- The substrate must be dry before and during application of High Build Industrial epoxy.
- Substrate temperature should be between 10°C and 40°C and at least 3°C above dew point during application and curing.
- Maximum relative humidity during application and curing is 95%.

6. INSTRUCTIONS FOR USE

- Stir well before use.
- Mixing ratio by volume is 3 bases to 1 hardener.
- Product temperature of the mixed base should be above 15°C to achieve application viscosity.
- Epoxy Thinners can be introduced to lower the viscosity if necessary. Do not exceed 10% to volume. Add epoxy thinner only after mixing components.
- Too much solvent will reduce sag resistance and opacity.
- Always ensure adequate ventilation.

- AIRLESS SPRAY:

- Recommended thinner: Epoxy Thinner.
- Volume of thinner: Thinning not recommended.
- Nozzle orifice: ± 0.46 – 0.53mm.
- Nozzle pressure: 13 – 16MPa (± 130 to 160 bar).

- AIR SPRAY:

- Recommended thinner: Epoxy Thinner.
- Volume of thinner: 0 – 5%, depending on required thickness and application



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- Nozzle orifice: $\pm 1.5 - 2\text{mm}$.
- Nozzle pressure: $0.3 - 0.4\text{MPa}$ (± 3 to 4 bar).
- BRUSH / ROLLER: (not recommended)
- Recommended thinner: Epoxy Thinner.
- Volume thinner: $0 - 5\%$, depending on required thickness and application conditions.
- Cleaning solvent: Epoxy Thinner.

7. **SAFETY PRECAUTIONS**

This is a solvent based paint, avoid inhalation of spray mist vapor as well as contact between the wet paint and exposed skin or eyes.



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