EPOCOAT 21 HB

TECHNICAL DATA SHEET 7/17

PROPERTIES AND RECOMMENDED USAGE

Paint type
EPOCOAT 21 HB is a two-component high build polyamide cured fast drying epoxy primer. It meets with the Swedish standard SIS 18 52 05 for two-component paints.

Typical and recommended uses
Recommended to use as a primer and intermediate coat foot steel surfaces in environmental classes C2-C4 and C5-I and C5-M. Suitable also for aluminium and galvanized surfaces. Recommended to be used on industrial frames, pipe bridges, conveyors and supporting structures of process industry. Can also be coated with polyurethane paints. Epocoat 21 HB provides the opportunity to extended recoating times.

Chemical resistance
Used in recommended paint systems and correctly applied withstands water as well as occasional splashes and spillage of weak process chemicals.

Colour
Red, grey, beige, black and white

Finish
Semi matt

TECHNICAL DATA

Volume solids*	62 %
Total mass of solids*	1060 g/l
VOC value*	320 g/l

* Values are calculated

Mixing ratio

Resin	4 parts by volume
Cure	1 parts by volume

Pot life (+23 °C)

Standard Comp. B	approx. 6 h after mixing
S-Comp. B	approx. 3 h after mixing

Packaging

	Volume (l)	**Size of container (l)**
Comp A	4	4
Comp B	4	4

Drying times are typical on recommended film thicknesses at given temperatures.

Drying time 80 µm

	Std. Comp. B		**S-Comp. B**	
	+10 °C	**+23 °C**	**+10 °C**	**+23 °C**
Surface dry	2 h	1 h	1 h	30 min
To touch	10 h	4 h	6 h	2,5 h
To recoat - same type of paint - polyurethanes - immersion service	 10 h 16 h 24 h	 4 h 5 h 16 h	 7 h 12 h 24 h	 3 h 4 h 16 h
Fully cured	12 d	7 d	12 d	7 d

Calculated theoretical coverage and recommended film thickness

Dry	**Wet**	**Coverage**
80 µm	130 µm	7,7 m²/l
100 µm	160 µm	6,3 m²/l
120 µm	195 µm	5,1 m²/l

Practical coverage
Depends on wind conditions, structure to be painted, roughness of the surface and application method.

Thinner
OH 17, OH 31 (slow)

Cleaner
OH 17

APPLICATION INSTRUCTIONS

Surface preparations
All solid impurities that could prevent adhesion should be removed from the surfaces to be painted. Remove salts and other water soluble impurities using fresh water with brush, high pressure-, steam- or alkali cleansing. Remove grease and oils by alkali-, emulsion- or solvent cleansing (SFS-en ISO 8504-3, SFS-EN ISO 12944-4). The surfaces should be rinsed carefully with fresh water after clensing. Old, painted surfaces, in which maximum overcoating interval has expired, additional roughening with suitable method is recommended. The place and time for the surface preparation should be chosen correctly, to avoid contamination and moistening of the treated surface before the paint application.

Steel surfaces
Blast cleaning to minimum Sa 2½ (SFS-ISO 8501-1, SFS-EN ISO 8504-2).

Shop primed surfaces
Damaged surfaces should be blast cleaned to minimum Sa 2½ (SFS-ISO 8501-2, SFS-EN ISO 12944-4).

Aluminium surfaces
Remove grease and other contaminants. Sand sweeping before painting improves adhesion.

Galvanized surfaces
Remove grease, zinc salts and other impurities. Sand sweeping before painting improves adhesion. Thinning is recommended.

Primer
EPOCOAT 21 PRIMER, EPOCOAT 21 HB, NORMAZINC SE

Top coat
EPOCOAT 210, EPOTEX HB, NORMADUR HB, NORMADUR 50 HS, NORMADUR 65 HS, NORMADUR 90 HS, NOREPOX HS
Note that 1-comp. products are not recommended.

Environmental conditions during application
The surface should be dry and clean. During application and drying time the temperature of the paint, air and surface should be above +10 °C ans the relative humidity below 80 %. The surface temperature should be min 3 °C above the dew point of the air.

Method of application
Use high pressure airless spray or brush. Stir resin and cure separately and then mix both components thoroughly. The mixing ratio is 4:1 (resin:cure) by volume. Thin only if needed (0-10 % thinner OH 17). High pressure airless spray with nozzle tip of 0,013”-0,018” orifice. Spray angle depending on the object to be painted. In order to ensure the best possible performance of the product, it is recommended that the paint is at room temperature before the application.

Storage and shelf life
The product must be stored in original sealed containers at temperatures from 5 °C to 30 °C. The storage conditions are to keep the containers in a dry, well ventilated space away from source of heat and ignition. When stored as described above, the unopened component A will keep up to 3 years and unopened component B to 3 years from the date of manufacture. The manufacturing date found in the label is also the batch number of the paint.

Safety
Please follow the environmental and safety instructions displayed on the container and Safety Data Sheet. Use under well ventilated conditions. Do not breathe or inhale mist, use respirator mask. Avoid skin contact. Spillage on the skin should immediately removed with suitable cleanser, soap or water. In case of contact with eyes, rinse immediately with plenty of clean water and if necessary seek medical advice.

Disclaimer
The above information is given to the best of our knowledge based on laboratory tests and practical experience. However, as the paint is often used under conditions beyond our control, we cannot guarantee anything but the quality of the paint itself. We reserve the right to change the given data without notice. Please contact our office for more specific information. The product is intended for professional use only. If there are deviations in the different language versions of the technical data sheets, the English version applies.