

HB Epoxy Undercoat/ Finish

DESCRIPTION AND USES

- A High Build Epoxy polyamide coating with outstanding chemical resistance. The product is formulated using high quality inert pigments.
- It can be applied direct to concrete or also as a build coat for structural steel work in aggressive environments.
- Excellent resistance to fresh and salt water.
- High film build in one coat.
- Low water permeability. Good solvent and chemical resistance.
- High build epoxy for the protection of steel and concrete.
- Suitable for application to pipelines, harbor and shore installation, tanks.
- Suitable as intermediate for upto C4 Environment as per ISO12944 Part 2 along with suitable topcoats.

PRODUCT PROPERTIES

VOLUME SOLIDS (based on ASTM D2697)	56 % ± 2 %
TYPICAL DRY FILM THICKNESS	125 microns
WET FILM THICKNESS	223 microns
THEORETICAL COVERAGE	4.5 m ² /litre @ 125 microns DFT
VOC (ASTM 3960)	385 gms/ltr
COLOUR	As per Shade Card
FINISH	Low Sheen

INSTRUCTIONS FOR USE

1. Surface preparation:

- This product should be applied to a surface that has been blast cleaned and suitably primed (e.g. with **EPILEX** or **ZINCANODE Primers**).
- Remove all wax, oil and grease by solvent cleaning in accordance with the guide lines given by SSPC-SPI.
- Where necessary remove weld spatter and round off all rough weld seams and sharp edges to a smooth surface.
- Abrasive blast clean to a minimum standard of Sa 2½ Swedish Standard SIS 05 59 00 or ISO 8501-1 : 1988
- Any surface defects revealed by blast cleaning should be ground, filled or treated in a suitable manner.
- An average surface profile of 40 microns is acceptable, but this average should not exceed 75 microns.
- After blasting, remove dust from the surface.
- The surface to be coated must also be clean and dry.

• ALUMINIUM

- Degrease and abrade with Solvalux 7 - 45 and wet-or-dry paper. Apply LUXAPRIME 1500 followed by one coat of suitable EPILEX Primers

– CONCRETE

- Ensure that the surface is sound. Remove laitance by thorough wire brushing, acid etching or sweep blasting. Blowholes and other defects should be filled with **EPILEX 829**.
- **EPILEX 218** may be applied directly to the clean sound concrete provided the first coat is thinned up to 20% Solvalux 7 - 45.

2. PRODUCT USE INSTRUCTIONS:

- As common with all epoxies this product will chalk on exposure to direct sunlight.
- If maximum over coating time is likely to be exceeded, apply a «tie coat».
- Dry heat resistant up to 120°C.
- May also be applied between 75 and 150 Microns DFT.
- Contact Berger Representative for suggesting suitable paint system.
- This is the recommended method of application:
- 10 - 60% Thinner may be added to achieve desired DFT Tip Size: 0.48 - 0.53 mm (0.019 - 0.021 in)
- Pressure: 110 - 160 kg/cm² (1600 - 2300 psi)
- This is also a suitable method of application. Maximum 40% Thinner may be added Tip Size: 1.80 mm - 2.20 mm (0.071 - 0.087 in) Pressure: 40-50 psi (2.75 - 3.45 kg/cm²) May be used for difficult shapes or touch-up; however additional coats may be required to achieve the recommended film thickness. This method of application is recommended for stripe coating welds, edges, rivets etc.

3. Application Information:

NO. OF COMPONENTS	Two
Mixing Ratio	3 parts Base to 1 part Hardener (by volume) Do not apply this product if the Relative Humidity
Application Conditions	Exceeds 85% or if the substrate temperature is within 3°C of the dew point
Thinner / Cleaning solvent	Solvalux 7 - 45
Flash Point	Mixed 30°C

4. Drying Time

Surface Temperature	Touch Dry	Hard Dry	Over coating Interval		Pot Life
			Minimum	Maximum	
15°C	5 hours	32 hour	32 hour	10 days	12 hour
25°C	3 hours	16 hour	16 hour	7 days	6 hours
35°C	2 hours	12 hour	12 hour	5 days	3 hours

Our recommendations are based on extensive research as well as 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. Please note that this data sheet supersedes any previous prints. For any additional information, please consult our technical office.

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APPLICATION TOOLS



PACKAGING

5 liters & 20 liters

STORAGE AND SHELF LIFE

12 months from the date of manufacture.
Store in a cool shaded dry area

SAFETY PRECAUTIONS

- Please refer to material safety data sheet (MSDS) before using the product.
- Please revert to technical office for application advice.
- For alternative systems may be specified, depending on area of use.