

## General Description:

EPOBUILD HB is a two-component hi – build two-pack fast drying epoxy primer hardened with amine adduct. It is especially formulated to give high build basecoat with superior adhesion, chemical, abrasion and corrosion resistant.

## Major Uses:

For use as a protection to metals from rust. As a primer and intermediate coat in epoxy system on structural steel at extreme conditions.

## Advantages:

- Abrasion and impact resistant.
- Good flexibility and waterproof.
- Easy to apply.
- Compatible to all types of topcoats. (Vinyl, chlorinated rubber, Epoxy MIO, Polyurethanes and Acrylics)
- Good weathering.
- Provides high build coating.

## Characteristics and Physical Properties:

Colour	Limited colours
Gloss	Eggshell
Solid content (V)	75%
Specific gravity	1.5 kg/L
Flash point	25 <sup>o</sup> C
Coverage	10 m <sup>2</sup> /L
Hardener	Epobuild HB Hardener
Ratio	3 : 1
WFT	100 microns
DFT	75 microns
Pot life	2 hours
VOC	255 g/L
Drying time	
Surface dry	1 - 2 hours
Touch dry	5 - 6 hours
Recoat	2 - 3 hours
Cured	3 - 4 days

## Chemical Resistance:

Distilled water	excellent
Chlorinated water	excellent
Marsh water	excellent
Sewage water	excellent
Kerosene	excellent
40% Sodium hydroxide	excellent
Petrol	very good
Gas oil	very good
10% Phosphoric acid	very good
Nickel solution	very good
1% Lactic acid	very good
30% Hydrochloric acid	good

## Surface Preparation:

### New Steel:

Steel should be degreased with suitable degreasing solvent and then grit blasted to S.S. Sa 2 ½ . Grit blasting is much preferred to wire brushing or other methods of abrasion. Immediately after blasting the surface should be coated with EPOBUILD HB.

### Other metals, GI steel and alloys:

Thorough degreasing and light abrasive to remove all contamination and to provide proper adhesion.

### Maintenance:

Remove all traces of oil, grease, and other contaminants, salt and other foreign matters by high-pressure water, remove all loose debris and laitance by abrasive or by power tool blasting. Touch up to full film thickness.

Apply further coats as necessary, within the recommended over coating time detailed on this data sheet.

This product will not cure adequately below 5<sup>o</sup>C. Difficulties may be encountered while brushing or rolling at low substrate temperatures. For optimum performance the substrate temperature should be above 10<sup>o</sup>C.

*The above information is given to the best of our knowledge based on laboratory test and practical experience. However, as the paint is often used under condition beyond our control, we cannot guarantee anything but the quality of the paint itself. We reserve the right to change the given data without prior notice.*

## MAS PAINTS & CHEMICAL INDUSTRY

P.O. BOX NO: 23085, SAJJAH INDUSTRIAL AREA, SHARJAH, U.A.E

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Method of Application: brush, roller, airless and conventional spray	
<b>Spray Data</b>	
<b>Airless</b>	
Nozzle Orifice	0.38 – 0.46 mm.
Nozzle Pressure	1138 - 1710 psi.
Dilution	0 - 5%
Thinner	EP Thinner # 135
<b>Conventional</b>	
Nozzle Orifice	2-3 mm.
Nozzle Pressure	43 – 57 psi
Dilution	10 – 15%
Thinner	EP Thinner # 135

**Application Condition:** Temperature of the substrate should be min 5°C and relative humidity on the vicinity of the substrate must not exceed 95%.

### Application:

While Epobuild HB cannot be applied to damp surfaces, running water must be excluded from the work area during both application and curing of the product. Where excessive seepage or leaking occurs, consult our Technical Department for recommendation.

### Hand Application

This can be suitably applied by brush or roller. The first coat should be firmly applied and scrubbed well into the surface, ensuring that a continuous film results of uniform thickness.

The second coat will cover more readily than the first and should be applied within the over coating times mentioned above.

### Spray Application

Faster rates of application are possible by using airless spray equipment. Details on the application are mentioned in this data sheet as your guidelines.

### Repairing and over coating

Any applications of Epobuild HB which have become damaged can be readily over coated.

The existing surface should be well abraded, using a stiff wire brush or similar, to ensure that a good mechanical bond will be achieved between the two layers.

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Over coating works can then proceed as for new work.

### Mixing:

The content of the resin base should be thoroughly stirred to disperse any possible settlement.

The entire content of hardener should be poured to the base container and the two materials mixed thoroughly until both uniform colour and consistency are obtained.

It is recommended to mixed the two components mechanically using a slow speed mixer and should be carried out continuously for 3-5 minutes.

### Typical Recommended System:

Epobuild HB	1 x 75 microns
Masdur AS	1 x 50 microns

### Storage:

Shelf life of 12 months minimum if stored below 25°C.

### Cleaning of Tools:

All tools should be cleaned with Wash Thinner or Epoxy Thinner # 135 as soon as possible.

### Packing:

Available in 4 lit. set and 20 lit. set.

### Physiological Hazards:

Keep Resin and Hardener away from eyes and skin contact. Good ventilation should be provided particularly in closed work areas. Avoid inhalation of vapours and wear protective clothing gloves, eye/face protection. In case of contact with eyes or skin occurs; remove immediately the affected area with a removing cream followed by washing with soap and plenty of fresh water. If swallowed seek medical attention.

