

Epoxy HR

Product description

This is a two component polyamine cured phenolic/novolac epoxy coating. It is heat resistant up to 205 °C (401 °F) and can be applied on hot substrates up to 150 °C (302 °F). This product may be used as a primer, mid coat or finish coat, with the exception of the bright aluminium colour which can only be used as a finish coat. Suitable for properly prepared carbon steel, galvanised steel, stainless steel and aluminium substrates.

Typical use

Protective:

Designed as corrosion protection for surfaces operating at elevated temperatures where long corrosion protection is desired. Suitable for insulated and non insulated surfaces.

Colours

aluminium, light grey, red, white, bright aluminium (RAL 9006)

Bright aluminium is a specialty bright aluminium finish similar to RAL 9006. Can only be used as a finish coat.

Product data

| Property | Test/Standard | Description |
|-----------------------|-----------------------------------------------------------------------------|-------------|
| Solids by volume | ISO 3233 | 63 ± 2 % |
| Gloss level (GU 60 °) | ISO 2813 | matt (0-35) |
| Flash point | ISO 3679 Method 1 | 28 °C |
| Density | calculated | 1.6 kg/l |
| VOC-US/Hong Kong | US EPA method 24 (tested) (CARB(SCM)2007, SCAQMD rule 1113, Hong Kong) | 330 g/l |
| VOC-EU | IED (2010/75/EU) (theoretical) | 365 g/l |
| VOC-China | GB/T 23985-2009 (tested) | 330 g/l |
| VOC-Korea | Korea Clean Air Conservation Act (tested) (Max. thinning ratio included) | 383 g/l |

The provided data is typical for factory produced products, subject to slight variation depending on colour.

All data is valid for mixed paint.

Gloss description: According to Jotun Performance Coatings' definition.

Film thickness per coat

Typical recommended specification range

| | |
|----------------------------|-----------------------------|
| Dry film thickness | 100 - 200 μm |
| Wet film thickness | 160 - 320 μm |
| Theoretical spreading rate | 6.3 - 3.2 m ² /l |

Surface preparation

To secure lasting adhesion to the subsequent product all surfaces shall be clean, dry and free from any contamination.

Surface preparation summary table

| Substrate | Surface preparation | |
|-------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------|
| | Minimum | Recommended |
| Carbon steel | St 2 (ISO 8501-1) | Sa 2½ (ISO 8501-1) |
| Stainless steel | The surface shall be hand or machine abraded with non-metallic abrasives or bonded fibre machine or hand abrasive pads to impart a scratch pattern to the surface. | Abrasive blast cleaning to achieve a surface profile using non-metallic abrasive media which is suitable to achieve a sharp and angular surface profile. |
| Aluminium | The surface shall be hand or machine abraded with non-metallic abrasives or bonded fibre machine or hand abrasive pads to impart a scratch pattern to the surface. | Abrasive blast cleaning to achieve a surface profile using non-metallic abrasive media which is suitable to achieve a sharp and angular surface profile. |
| Galvanised steel | The surface shall be clean, dry and appear with a rough and dull profile. | Sweep blast-cleaning using non-metallic abrasive leaving a clean, rough and even pattern. |
| Shop primed steel | Dry, clean and approved inorganic zinc shopprimer. | Sa 2½ (ISO 8501-1) |
| Coated surfaces | Clean, dry and undamaged compatible coating | Clean, dry and undamaged compatible coating |

Optimum performance, including adhesion, corrosion protection, heat resistance and chemical resistance is achieved with recommended surface preparation.

Application

Application methods

The product can be applied by

Spray: Use airless spray.

Brush: Recommended for stripe coating and small areas. Care must be taken to achieve the specified dry film thickness.

Product mixing ratio (by volume)

Epoxy HR Comp A 6.5 part(s)
Epoxy HR Comp B 1 part(s)

Thinner/Cleaning solvent

Thinner: Jotun Thinner No. 23

Guiding data for airless spray

Nozzle tip (inch/1000): 17-21
Pressure at nozzle (minimum): 150 bar/2100 psi

Drying and Curing time

| Substrate temperature | 10 °C | 15 °C | 23 °C | 40 °C | 100 °C |
|---------------------------|-------|-------|-------|-------|--------|
| Surface (touch) dry | 16 h | 12 h | 4 h | 2 h | 30 min |
| Walk-on-dry | 26 h | 20 h | 10 h | 4 h | 1 h |
| Dry to over coat, minimum | 26 h | 20 h | 10 h | 4 h | 1 h |
| Dried/cured for service | 21 d | 14 d | 7 d | 3 d | 1 d |

For maximum overcoating intervals, refer to the Application Guide (AG) for this product.

Drying and curing times are determined under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product.

Surface (touch) dry: The state of drying when slight pressure with a finger does not leave an imprint or reveal tackiness.

Walk-on-dry: Minimum time before the coating can tolerate normal foot traffic without permanent marks, imprints or other physical damage.

Dry to over coat, minimum: The recommended shortest time before the next coat can be applied.

Dried/cured for service: Minimum time before the coating can be permanently exposed to the intended environment/medium.

Induction time and Pot life

| Paint temperature | 23 °C |
|-------------------|--------|
| Induction time | 20 min |
| Pot life | 4 h |

Reduced at higher temperatures.

Heat resistance

| | Temperature | |
|------------------|-------------|------|
| | Continuous | Peak |
| Dry, atmospheric | 205 °C | - |

The temperatures listed relate to retention of protective properties. Aesthetic properties may suffer at these temperatures.

Product compatibility

Depending on the actual exposure of the coating system, various primers and topcoats can be used in combination with this product. Some examples are shown below. Contact Jotun for specific system recommendation.

Previous coat: inorganic zinc shop primer
Subsequent coat: phenolic/novolac epoxy, silicone acrylic

Packaging (typical)

| | Volume (litres) | Size of containers (litres) |
|-----------------|--------------------|--------------------------------|
| Epoxy HR Comp A | 16.3 | 20 |
| Epoxy HR Comp B | 2.5 | 3 |

The volume stated is for factory made colours. Note that local variants in pack size and filled volumes can vary due to local regulations.

Storage

The product must be stored in accordance with national regulations. Keep the containers in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.

Shelf life at 23 °C

| | |
|-----------------|-------------|
| Epoxy HR Comp A | 24 month(s) |
| Epoxy HR Comp B | 24 month(s) |

In some markets commercial shelf life can be dictated shorter by local legislation. The above is minimum shelf life, thereafter the paint quality is subject to re-inspection.

Caution

This product is for professional use only. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly and according to Jotun's technical documentation. Applicators and operators shall use appropriate personal protection equipment when using this product. This guideline is given based on the current knowledge of the product. Any suggested deviation to suit the site conditions shall be forwarded to the responsible Jotun representative for approval before commencing the work.

Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not inhale spray mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

Colour variation

When applicable, products primarily meant for use as primers or antifoulings may have slight colour variations from batch to batch. Such products may fade and chalk when exposed to sunlight and weathering.

Colour and gloss retention on topcoats/finish coats may vary depending on type of colour, exposure environment such as temperature, UV intensity etc., and application quality. Contact your local Jotun office for further information.

Disclaimer

The information in this document is given to the best of Jotun's knowledge, based on laboratory testing and practical experience. Jotun's products are considered as semi-finished goods and as such, products are often used under conditions beyond Jotun's control. Jotun cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Jotun reserves the right to change the given data without further notice.

Users should always consult Jotun for specific guidance on the general suitability of this product for their needs and specific application practices.

If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail.