

## 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). Can be used as primer, mid coat or finish coat in atmospheric environments. RAL 9006 to be used as final coat/finish coat only. 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  
RAL 9006 to be used as final coat/finish coat only.

### 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
VOC-US/Hong Kong	US EPA method 24 (tested)	330 g/l
VOC-EU	IED (2010/75/EU) (calculated)	365 g/l
VOC-China	GB/T 23985-2009 (ISO 11890-1) (tested)	330 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 <sup>2</sup> /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 and to remove all polish from the surface.	Abrasive blast cleaning to achieve a surface profile using approved 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 and to remove all polish from the surface.	Abrasive blast cleaning to achieve a surface profile using approved 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.	Light brush blasting 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 (ISO 12944-4 6.1)	Clean, dry and undamaged compatible coating (ISO 12944-4 6.1)

## 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
Dry to over coat, maximum, atmospheric	30 d	30 d	30 d	30 d	7 d
Dried/cured for service	21 d	14 d	7 d	3 d	1 d

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 shortest time allowed before the next coat can be applied.

Dry to over coat, maximum, atmospheric: The longest time allowed 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	205 °C

Peak temperature duration max. 1 hour.

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	48 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.

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## 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.

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## 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.

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## 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.

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## 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.

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