IJMOPOX HB COATING

DESCRIPTION

IJmopox HB coating is a high solid two component buildcoat for general purposes based on epoxy resins and a polyamide hardener.

PRINCIPAL CHARACTERISTICS

- High solid;
- Contains zinc phosphate as corrosion inhibitor;
- Recommended in paint systems for the protection of steel, aluminium, wood, GRP, etc.;
- Suitable as barrier coat in osmosis prevention or osmosis repair systems for GRP;
- Offers protection against corrosion (steel) and osmosis (GRP);
- Will chalk under atmospheric exposure conditions, but may be recoated with both two component or conventional coatings, even after a long weathering interval;
- Excellent mechanical properties;
- Application and curing at temperatures as low as 5 °C and relative humidifies as high as 80%;
- Excellent resistance to various chemicals and (sea) water;
- Easy to apply by brush or spray. For sufficient protections when applied by brush 4 to 5 layers are recommended

COLOURS AND GLOSS

White (RAL 9016), Grey (RAL 7001) and Black (RAL 9005), other colours on request - Eggshell

BASIC PROPERTIES (AT 23°C AND 50% R.H.)

Density	:	approx. 1,4 g/cm^3 (mixed product)
Solid content	:	approx. 70 % (volume)
Recommended d.f.t.	:	50 - 150 µm (depending on application), see additional information
Dust dry after	:	approx. 2 hours
Full cure after	:	approx. 5 days, see additional information
Recoating interval	:	min. 8 hours, see additional information max. unlimited, provided clean and dry
Shelf life	:	separate components, stored cool and dry in original packaging, minimum 12 months
Flash point (DIN53213)	:	base component 25 °C hardener 30 °C

SPREADING RATE

At 50 µm (d.f.t.)	:	14,0 m^2/l
At 100 µm (d.f.t.)	:	7,0 m^2/l
At 150 µm (d.f.t.)	:	4,7 m^2/l

The practical spreading rate depends on a number of variables, such as: shape and size of object to be painted, the condition and profile of the substrate, the method of application, climatologic conditions and skill of labour.

SUBSTRATE CONDITION AND TEMPERATURE

Steel	:	preferably grit blasted to ISO Sa 2½ or powertool cleaned to ISO St 3 (grit paper P24-36), primed with IJmopox ZF primer;
Aluminium	:	sanded wit grit paper P60, primed with IJmopox ZF primer;
Wood	:	moisture content maximum 12%, sanded with grit paper P120-180, primed with Variopox Injection resin;
Reinforced polyester	:	dry, sanded with grit paper P120-180 and degreased with Double Coat Degreaser;
Previous coatings	:	two component coatings, clean and dry, in good condition, free from any contamination and loose particles, sanded with grit paper P120 – 180. IJmopox HB coating is not compatible with one component coatings;

Other substrates : clean and dry, in good condition, free from any contamination and loose particles, primed with IJmopox ZF primer or Variopox Injection resin.

During application and curing a minimum temperature of 5 °C is allowed. The temperature of the substrate should be minimum 3 °C above dew point.

INSTRUCTIONS FOR USE

Before use, mix base and hardener components thoroughly.

Mixing ratio : 83,0 base : 17,0 hardener (by weight)
75,0 base : 25,0 hardener (by volume)
Do not prepare more material than can be applied within the pot life of the mixture.

Induction time : 10 minutes at temperatures of 15 °C and lower;
none at temperatures above 15 °C

Pot life : 3 hours at 25 °C
5 hours at 20 °C
8 hours at 10 °C

Application with :

	Brush/roller	Air spray	Airless spray
Type thinner	IJmopox thinner	IJmopox thinner	IJmopox thinner
% of thinner	5 - 10 %	10 - 15 %	0 - 10 %
Nozzle orifice	n.a.	1,5 -3,0 mm	0,013 - 0,018 inch
Nozzle pressure	n.a.	3 - 5 bar	150 - 200 bar
Cleaning	IJmopox thinner	IJmopox thinner	IJmopox thinner

ADDITIONAL INFORMATION

- Recoating and curing of IJmopox HB Coating

	5 °C	10 °C	20 °C	25°C
Minimum	24 hours	12 hours	8 hours	5 hours
Maximum, with IJmopox HB coating or Double Coat, without sanding	96 hours	96 hours	48 hours	36 hours
Maximum, with IJmopox HB coating or Double Coat, after sanding and degreasing	unlimited	unlimited	unlimited	unlimited
Maximum, with hard or polishing anti-foulings, without sanding[1]	28 hours	20 hours	12 hours	9 hours
Fully cured after	14 days	14 days	7 days	3 days
[1] See Recoating with anti-fouling				

- Recommended filmthickness
  The recommended filmthickness in this datasheet is for each separate layer and depends on application method. How many layers are recommended depends on the field of application, the exposure conditions and type of substrate. The total necessary number of layers can be found in the paint system recommendation.

- Recoating with anti-fouling
  IJmopox HB coating may be recoated with most types of anti-fouling. When IJmopox HB coating is recoated with a thin layer anti-fouling based on teflon etc., we recommend to sand IJmopox HB coating with grit paper P280-P300. The application of a tiecoat / adhesion primer might be recommended by the producer.
  When self polishing (hard)anti-foulings are applied, we recommended to apply this in the final "fresh" applied IJmopox HB coating layer. The IJmopox HB coating must then be dry (no longer tacky) but not cured. Application of the first layer must be within the above stated maximum

recoat time.

- Application of IJmopox HB coating by brush or roller
  IJmopox HB coating is a high build thixotropic coating enabling application at high filmthickness. When applied by brush or roller this may result in brushmarks or orange peel. We recommend to add 5 to 10% IJmopox thinner to improve levelling. IJmopox HB coating may be applied best using felt rollers.

- Application of IJmopox HB coating by airless spray
  - IJmopox HB coating can be applied without adding additional solvent using a Wagner Cobra 40/10.
  - Use a material pressure of 5 Bar (200 Bar with a pump ratio of 40:1).
  - Use a nozzle of 0,013 inch with angle 40 or 60°.

- Application of IJmopox HB coating by airmix or aircoat system
  - IJmopox HB coating can be applied after adding approx. 10% IJmopox thinner to a viscosity of approx. 110 s DIN 4.
  - Good results are obtained using a Wagner Cobra 40/10 at a material pressure of 4 Bar and air pressure of 3 ½ Bar.
  - Use a nozzle of 0,017 inch with angle 60°.

SAFETY INFORMATION

See the corresponding Material Safety Data Sheet for detailed instructions on safety, disposal and health.

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Disclaimer
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