Technical Data
JOTABUILD HB

Product description
Jotabuild HB is a high solid, high build, two-pack polyamide cured epoxy coating.

Recommended use
Anticorrosive epoxy primer/intermediate coat for steel structures. It can be applied on to bare steel or a suitable primer/shopprimer

Film thickness and spreading rate

	Minimum	Maximum	Typical
Film thickness, dry (µm)	100	200	150
Film thickness, wet (µm)	130	260	200
Theoretical spreading rate (m^2/l)	7.6	3.8	5.1

Physical properties

Colour	Grey, Red and White.
Solids (vol %)*	76 ± 2
Flash point	25ºC ± 2 (Setaflash)
Gloss	Flat
Gloss retention	Fair
Water resistance	Good
Abrasion resistance	Very good
Solvent resistance	Very good
Chemical resistance	Very good
Flexibility	Good

***** Measured according to ISO 3233:1998 (E)

Surface preparation

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504.

Bare steel
Cleanliness: Blast cleaning to Sa 2½ (ISO 8501-1:1988).Roughness: using abrasives suitable to achieve grade Fine to Medium G (30-85 µm, Ry5) (ISO 8503-2)

Shopprimed steel
Clean, dry and undamaged approved blast-primer.

Coated surfaces
Clean, dry and undamaged compatible primer. Please contact your local Jotun office for more information.

Other surfaces
The coating may be used on other substrates. Please contact your local Jotun office for more information.

Condition during application

The temperature of the substrate should be minimum 20ºC and minimum 3ºC above the dew point of the air. The temperature and the relative humidity should be measured in the vicinity of the substrate. Jotabuild HB should not be exposed to water, chemicals or mechanical stress before the paint is fully cured.

Application methods

Mixing ratio (volume)	3 parts Comp. A (base) to be mixed thoroughly with 1 part Comp. B (curing agent)
Pot life (23°C)	3½ hours. (Reduced at higher temp.)
Thinner/Cleaner	Jotun Thinner No. 17
Guiding data airless spray	
Pressure at nozzle	25 MPa (250 kp/cm² 4000 psi)
Nozzle tip	0.46 - 0.69mm (0.018-0.027")
Spray angle	40 - 80°
Filter	Check to ensure that filters are clean.

Drying time

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

* Good ventilation (Outdoor exposure or free circulation of air)
* Typical film thickness
* One coat on top of inert substrate

Substrate temperature	**25°C**	**40°C**
Surface dry	3.5 h	1.5 h
Through dry	12 h	4 h
Cured	7 d	3 d
Dry to recoat, minimum	12 h	4 h
Dry to recoat, maximum [2]		

1 Recommended data given for recoating with the same generic type of paint.

2 Provided the surface is free from chalking and other contamination prior to application, there is normally no overcoating time limit. Best intercoat adhesion occurs, however, when the subsequent coat is applied before preceding coat has cured. If the coating has been exposed to direct sunlight for some time, special attention must be paid to surface cleaning and mattening/removal of the surface layer in order to obtain good adhesion

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

Typical paint system

On bare steel or shopprimer.

Jotabuild HB	**2 x 150 µm**	**(Dry Film Thickness)**
Polyurethane or epoxy topcoat	1 x 50 µm	(Dry Film Thickness)

Other systems may be specified, depending on area of use

Storage

The product must be stored in accordance with national regulations. Preferred storage conditions are to keep the containers in a dry space provided with adequate ventilation. The containers should be sealed tightly.

Packing size

12 L. Comp. A (base) and 4 L. Comp. B (curing agent)
Packing may vary from country to country according to local requirements.

Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale 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.

For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Material Safety Data Sheet.

DISCLAIMER

The information in this data sheet is given to the best of our knowledge based on laboratory testing and 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.

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