

TECHNICAL DATA SHEET

VIBOL® EPOXY PRIMER/COATING HB

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High Solids epoxyprimer/finish pigmented with zinc phosphate and inert fillers.
Easily applicable in large layers.
Easy processing with airless-spray and brush application.
Application and drying possible in relative humidity up to 90%.
Good elasticity and mechanical resistance.
Excellent adhesion to blasted or chemically pre-treated thermally galvanised steel.
Resistant to spilling and splashing of a wide range of chemicals.

Application as coating on steel constructions in aggressive industrial environments and maritime environments.

PRODUCT INFORMATION

Binding agent	Two component epoxy with polyamide adduct harder
Finish	Satin
Colour	RAL-colours and aluminium
Mass density (20°C) (A+B)	1.4-1.5 kg/L
Solids content (A+B)	Ca 70 vol%
VOC (Volatile Organic Compounds)	± 270 g/L
Recommended film thickness	
Dry Film Thickness (DFT)	100-250 µm
Wet Film Thickness (WFT)	125-315 µm
Theoretical spreading rate (80 µm DFT)	8.7 m²/L
Practical spreading rate (Depending on several factors like shape of object, surface profile, method of application, application circumstances and experience)	Brush/roller: 85-90 % of the theoretical spreading rate Spray: 50-70 % of the theoretical spreading rate
Flashpoint	>21°C
Dry temperature resistance	250 °C

DRYING TIMES

For DFT up to 100 µm and 20°C

Dust dry	2 hours
Transportable	16 hours
Complete hardening	3 days
Recoatable	
Minimum interval	8 hours
Maximum interval	Unlimited, provided that the surface is dry and clean

Film thickness, ventilation, temperature and relative humidity are of great influence on drying times.

APPLICATIONS-INSTRUCTIONS

Mixing ratio: volume: base - hardener 20L comp.A + 5L comp.B
Weight: base – hardener: 100 parts comp A + 13.3 parts comp. B

Mixing instructions: Base and hardener should be mixed and applied at temperatures above 10°C
At lower temperatures extra thinner is needed which gives a slighter resistance against sagging and which will delay hardening.

Pot life after mixing: ca. 6 hours at 20°C

Application conditions: During application and hardening the temperature should be above 5°C to attain maximum resistance against chemical and mechanical influences.

Application at lower temperatures (down to -5°C) is possible, however hardening will take considerable more time and complete resistance will be achieved much later.

The surface should remain free from water and ice and the temperature of the surface should at least be 3°C above dew point.

During application and hardening in closed or small spaces, it is necessary to refresh the air continually to remove the solvent vapours, this because of drying, health and safety.

Usage information	Airless	Luchtspuit	Borstel/Rol
Type of thinner	Thinner EP	Thinner EP	Thinner EP
Recommended thinner	5-10 vol%	10-15 vol%	0-5 vol%
Nozzle orifice	0.48-0.53 mm 0.019-0.021 inch	2.0-2.5 mm	/
Nozzle pressure	170-200 bar	3-4 bar	/
Cleaning of tools	Cellulose thinner	Cellulose thinner	Cellulose thinner

DURABILITY

At least 12 months, provided that it has been stored in closed original packing at a dry and cool spot.

PACKAGING

1 L + 0,2 L 5 L + 1 L 15 L + 3

These data have been drawn up to the best of our knowledge and were correct at the data of issue. However we cannot accept full responsibility, because de choice of products and circumstances during elaboration of the systems fall outside our judgement. This documentation sheet will not automatically be replaced in case of modification.