

Hi-Build Epoxy Coating

Technical Data Sheet

Product Description

Hi Build Epoxy Coating is a two-pack high performance top coat based on Epoxy Resin and stable pigments. Chemical resistance and Saline water resistance of Epoxy Resin makes this coating ideal for iron and steel surfaces as top coat. Its excellent resistance to saline water exposure.

Product features:

- Tough, abrasion, and chemical resistant
- Excellent flexibility
- Brush, roller, or spray application
- Interior/Exterior applications
- Product is lead, chrome, and heavy metal free

Recommended Uses

Hi-Build Epoxy Coating is intended for industrial applications, either new build or maintenance.

Hi-Build Epoxy Coating is ideal for steel or concrete surfaces in industrial and marine environments.

Application Areas:

- Chemical Industry
- Food Industry
- Hospital & Pharmaceuticals
- Extreme Duty Structural coating
- Flooring
- Tub and Tiles

Note: Exterior applications will chalk, but will not detract from other qualities.

Product Characteristics

Typical Physical Properties	
Gloss:	High: 80+ GU at 60°
Viscosity:	100 - 110 Seconds/BSB4/30°C
Mixing Ratio	Base: C/A = 2:1 by volume
Pot Life:	3 Hours approx. (After mixing)
Thinner:	Epoxy Thinner
Thinning Ratio:	8-10 % (Approx. for brush application)
Coverage:	500-550 Sft / 4 liters. (On non-absorbent surface)
Recommended DFT:	45-50 Microns / Coat
Flash Point:	Below 70° F

Surface Preparation

Surfaces to be finished must be clean, dry and free of dirt, oil or any contamination that would adversely affect adhesion, protective properties or appearance of the coating.

Prepare metal surfaces to SSPC-SP2, SSPC-SP3 for normal requirements.

Prepare metal surfaces to SSPC-5 white metal blast for immersion service.

For questions regarding other substrates contact your Crown Representative.

Application Method

Brush/ Roller: Thin up 8-10% of thinner is recommended for brush and roller application. Good quality brushes and mohair/ short nap rollers should be used with full strokes. Avoid re-brushing. Additional coats may be required to achieve minimum specified film thickness.

Spray: Thin up 25-30% of thinner for conventional spray application. When airless spray is being used, excessive high tip spraying pressure should be avoided. The minimum pressure at the pump conducive with good atomization should be used.

Dry Times

	70°F (21°C)
To Touch	1 Hour
To Handle	4 Hours
To Recoat	4 Hours
Through Dry	18 Hours
Immersion Service	7 Days

Optimum drying conditions are 60°F to 90°F (16°C to 32°C) at 50% R.H. Lower temperatures and high humidity will slow dry time. Surface must be dry and at least 5°F(3°C) above the dew point.

Note: Product may also be force cured to enhance dry. Force cure temperatures in the range of 110-180°F (43 - 82 °C) may be utilized to accelerate solvent evaporation and speed oxidation.



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Clean Up

Clean all equipment immediately after use with Epoxy Thinner for spray guns and line, pots, and other equipment. Follow manufacturer's safety recommendations when using any solvent.

Note: Due to limited potlife, never leave catalyzed paint in spray equipment.

Environmental Conditions

For optimum coating performance product, substrate and ambient temperature should be above 50°F (10°C). To prevent condensation during application the surface temperature must be 5°F (3°C) or more above the dew point.

Note: For use outside this range please contact your FCA Representative.

Storage Conditions

Storing partially used container uncatalyzed: Pour a small amount of the recommended thinner over the surface. Do not stir. Replace lid securely. Store away from heat or open flame.

Topcoating Information

Hi-Build Epoxy is self-priming and may be recoated as early as 4 hours.

Safety Precautions

Keep container tightly closed and keep out of reach of children or away from food and drink.

Ensure good Ventilation during application and drying.

When applying paint, it is advisable to wear eye protection.

In case of contact with eye, rinse with plenty of water immediately and seek medical advice.

Remove splashes from skin by using soap or water.

Paint must always be stored in a cool place.

When transporting paint, care must be taken. Always keep container in a secure upright position.

Dispose of any paint waste in accordance with the appropriate Environment Quality Regulations.