



Technical data sheet

PROTECTION MADE EASY

Oxypaint HB Primer

Description and destination of the product

Oxypaint HB Primer is an epoxy primer of the type "High Build". Thanks to the combination with zinc phosphate, a good anticorrosion protection is given.

Oxypaint HB Primer is also very suitable in epoxy systems as protection of construction steel, storage tanks, etc.

Type of binder

Epoxy resin with a polyaminoamide hardener.

Type of pigment

Zinc phosphate, titanium dioxide, colour pigments and inert fillers.

Colour

Grey.

Gloss

Mat.

Technical data

- **Density:** 1.47 (\pm 0.05) g/cm³
- **Solids content:** 59 (\pm 2) % in volume
75 (\pm 2) % in weight
- **Mixing ratio:** 91 parts **base**
9 parts **Hardener EP**
Mixing errors result in deviating properties and differences in gloss. Therefore we advise to mix the complete contents of base paint and hardener.
- **Potlife:** \pm 8 hours at 20°C
- **VOC:** < 340 g/L (not diluted)
< 500 g/L (25% diluted)
Cat. A/j: 500 g/L (norm 2010)
- Indicative drying times (R.H. 75%) for 60 micron layer thickness:

	Dustdry	Tackfree	Dry
10°C	1 hour	8 hours	24 hours
20°C	30 minutes	5 hours	14 hours
30°C	20 minutes	3 hours	10 hours

- **Theoretical yield:** 6.7 m²/kg – 9.9 m²/L for 60 microns
5.0 m²/kg – 7.4 m²/L for 80 microns
4.0 m²/kg – 5.9 m²/L for 100 microns

The practical yield can largely be influenced by the roughness and porosity of the substrate, the applied layer thickness or the losses by airless application.

Surface preparation

Surfaces that are polluted with grease or oil should be washed down with solvents, alkaline solutions or emulsifier.

Salts or other water dilutable contaminations should be removed with water and brush, water under high pressure or jet.

After this cleaning, the steel surface must be blasted up to SA 2.5.

When a second layer of **Oxypaint HB Primer** is applied or when **Oxypaint HB Primer** is applied on an existing shop or welding primer, the surface must first be degreased, cleaned and derusted with appropriate means (see above).

Use

Mixing ratio in weight: 91 parts base and 9 parts hardener EP

It is always recommended to brush corners, sharp edges, bolts or nuts before applying a flat coat.

	% Dilution	Thinner	Pressure (bar)	Nozzle
Brush	0-5 %	Thinner 60	-	-
Roller	0-5 %	Thinner 60	-	-
Pneumatic gun	0-20 %	Thinner 60	3 to 5	1.2-1.5 mm
Airless gun	0-10 %	Thinner 60	150 to 250	0.015-0.021

Clean the tools with **Thinner 60**

Recommended layer thickness: 80 microns

	Minimum	Maximum
10°C	after 24 hours	7 days
20°C	after 6 hours	3 days
30°C	after 5 hours	2 days

Application conditions

Oxypaint HB Primer can be applied at temperatures between 12°C and 35°C and air humidity between 30 and 85 %. The temperature of the surface must be 3°C higher than the temperature of dew point.

Storage stability

Minimum 2 years in the original unopened packing, stored in a dry environment between -20°C and +40°C.

Safety measure

For detailed information about safety measures, personal protection and transport data of this product, we refer to the safety data sheet.

The last update of our technical data sheets is always available at our website: www.libertpaints.be

Disclaimer

The information given in this technical data sheet is only a general product description, based on our experiences and tests and therefore does not represent a specific practical case. Consequently Libert Paints doesn't guarantee the functionality or result and takes no responsibility in this respect.

We advise our clients to test the applicability of the product to the nature and the state of the surfaces and to carry out the necessary representative tests in case of doubt. Please contact our R&D department as the occasion arises.

Attention: our clients should verify whether the present technical data sheet hasn't been replaced by a more recent version.