



01.17.6891.112298.D

OMEGA
Boya ve Kimya Sanayi Tic. Ltd. Şti.

1411-1104 EPOXY HB PRIMER

Resin Type

Epoxy

Description

Epoxy HB Primer is a two-component, epoxy based primer containing zinc phosphate.

Characteristics

Higher film thickness with single coat,
Can be sanded away easily,
High corrosion resistance,
Creates a plane surface for the air-drying topcoats which shall be applied on it.

Fields Of Use

Epoxy HB Primer is formulated for being used on any kinds of metal where high corrosion resistance is required.

Application

Surface Preparation:

Before primer has been applied, **Epoxy Shop Primer** (1411-1106) should be applied on the surface as pre-production primer. Epoxy HB system can also be used directly as primer on the metal surfaces easily following surface preparations to be made.

If the Epoxy HB Primer is used directly on metal surface, the surface preparation to be made so that the system can show the expected success is as important as the original application.

Any kinds of humid, chloride, sulphate salt, corrosion, rolled-in scale on the metal surfaces should be removed by grit spraying at **Sa 2 ½** degree according to Sweden Standard SIS 05 5900 or mechanical method at **St 2** standard. Besides, dust, dirt, oil and grease on the metal surfaces should be cleaned by cleaning materials and/or high-pressure water jet.

Welding burrs and sharp corners of the surfaces should be ground.

After the different cleaning procedures performed, surface should be cleaned by vacuum cleaner, clean and dry air or a clean brush.

After the related processes, there should be a slight metal glow on the surface and following this process, it should be applied on the surface preferably promptly and in 30 minutes at the latest.

Primer Application:

Epoxy HB Primer (1411-1104) is mixed well preferably by drilling motor after its package has been opened. Epoxy Hardener (1411-1504) is added at the recommended rate, then Epoxy Thinner (1451-1401) is added at the recommended rate for ensuring application viscosity of the mixture. The mixture gives the application viscosity. (Application viscosity should be adjusted as 22" - 24" / DC4 / 20°C in spraying applications, 26" - 40" / DC4 / 20°C in the brush and roller applications.) It is recommended that the primer should be applied so that dry film thickness of 90 - 100 µ. can be obtained. If wet-on-wet application shall not be performed, 6 hour waiting is required for acceptance of the coat following application of the second coat.



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On Epoxy HB Primer,

1131-1201	Industrial Semi Gloss Top Coat
1131-1301	Industrial Top Coat
1231-1201	Synthetic Semi Gloss Top Coat
1231-1301	Synthetic Top Coat
1331-1201	Cellulosic Semi Gloss Top Coat
1331-1301	Cellulosic Top Coat
1431-1201	Epoxy Semi Gloss Top Coat
1431-1209	Epoxy Miox Top Coat
1431-1301	Epoxy Top Coat
1432-1201	Solvent-free Epoxy Semi Gloss Top Coat
1432-1301	Solvent-free Epoxy Top Coat
1531-1201	Polyurethane Semi Gloss Top Coat
1531-1301	Polyurethane Top Coat
1631-1201	Acrylic Semi Gloss Top Coat
1631-1301	Acrylic Top Coat
2031-1201	Flash-off Semi Gloss Top Coat
2031-1301	Flash-off Top Coat can be applied.

Notes

While Application:

Atmospheric temperature should be between 5 °C -50 °C
Surface temperature should be between 10 °C -30 °C
Relative humidity should be < 85 %

Important Reminders:

Required ventilation should be ensured in the closed areas for preventing any health problem or fire risk.

If it is preferred that primer and topcoat are applied together and wet-on-wet, minimum 90-minute waiting is required after application of primer providing that product properties of the topcoat are taken into consideration, as well.

When application of multiple coats without wet-on-wet application is required, a light sanding should be made between coats if 72 hours has passed.

Mixtures should be prepared in the amount complying with the work order and the work should be continued till this mixture is finished completely.

Upon completion of the work, all the coating equipment used during application should be cleaned well with Epoxy Thinner (1451-1401).

After application, the surface should not be contacted with water for minimum 36 hours.

7-day waiting is required before use of the coated surface for ensuring complete curing.

Technical Info

Product Code

1411-1104

Color

Light Grey,Dark Grey,Oxide Red

Gloss

Matt

Density

1,30 ± 0,05 g/ml (depending on color)

Epoxy HB Primer

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REV NO: 02

1411-1104 Epoxy HB Primer Sayfa 2/3

FORM NO: 330-RP 0703



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Solid, %

By Mass 77 ± 3 (depending on color)
By Volume 66 ± 4 (depending on color)

Drying Time

Dust Dry 55 – 75 min. / 20°C
Touch Dry 1,5 – 3 h / 20°C
Montage Dry 48 h / 20°C
Complete Dry 7 days

Mixing Ratio

By Mass 5 Portion Epoxy HB Primer (1411-1104)
1 Portion Epoxy HB Hardener (1411-1504)
1 Portion Epoxy Thinner (1451-1401)
The mixture gives the application viscosity.

Pot Life

18 h / 20°C

Application Viscosity

22" - 24" / DC4 / 20°C (spray - airless)
26" - 40" / DC4 / 20°C (brush - roller)

Thinner To Be Used

1451-1401

Application Methods

Brush, Roller, Spraying (spray - airless)

Recommended Dry Film Thickness

90 - 100 µ

Theoretical Application Area

6,5 – 7,5 m² / lt (90 - 100 µ dry film thickness)

Package Life

Minimum 1 year for the unopened package.(at room temperature)

Flash Point

< **27 °C**

General Warnings

Use with mask only in the well-ventilated areas and do not inhale.

The aforementioned product properties have been arranged according to the cutting-edge technology results and laboratory test results and they are based on recommendation. The described conditions and dominant local status and other materials to be used should certainly be taken into consideration during use of the product.

For achieving the best results, the convenient devices and application properties should be taken into account.

The information in this document shall remain effective till the next edition. The right to modify the information without notification in advance is reserved.

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