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OMEGA
Boya ve Kimya Sanayi Tic. Ltd. Şti.

1421-1208 EPOXY SURFACE TOLERANT HB MID COAT

Resin Type

Epoxy

Description

Epoxy Surface Tolerant HB Mid Coat is a two-component epoxy based primer containing zinc phosphate.

Characteristics

Ensuring high film thickness on single coat applications
Can be used as a **semi gloss top coat** after pre-production primer in special cases,
Provides high physical and chemical resistance,
Forms a plane surface for any kinds of air and flash-off drying topcoats to be applied on.

Fields Of Use

Epoxy Surface Tolerant HB can be used as a single coat on epoxy based primers for all metal surfaces ,where chemical and physical resistance is needed.

Application

Before Epoxy Surface Tolerant HB,
1411-1106 Epoxy Shop Primer
Should be applied as pre-pdoruction primer,or one of below
1411-1101 Epoxy Primer
1411-1102 Epoxy Zinc Phosphate Primer
1411-1103 Epoxy Zinc Rich Primer
1411-1104 Epoxy HB Primer
1411-1114 Epoxy Corrosion Inhibition Primer
1412-1101 Solvent-free Epoxy Primer
1421-1109 Epoxy Miox Primer
should be choosed as primer on surface and minimum 2, maximum 72 should be waited before application of the mid coat.

Mid Coat Application:

Epoxy Surface Tolerant HB Mid Coat (1421-1208) is mixed well preferably by drilling motor after its package has been opened. Epoxy Surface Tolerant HB Mid Coat Hardener (1421-1508) 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 20" - 24" / DC4 / 20°C in spraying applications, and as 25" - 38" / DC4 / 20°C in the brush and roller applications.) It is recommended that the Epoxy Surface Tolerant HB Mid Coat should be applied so that dry film thickness of **80 - 90 µ.** can be obtained. If wet-on-wet application shall not be performed, 4 hour waiting is required for acceptance of the coat following application of the second coat.

On Epoxy Surface Tolerant HB,

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

OMEGA BOYA VE KİMYA SANAYİ TİCARET LİMİTED ŞİRKETİ

Akse Mh. 547 Sk. No:6 Çayırova / Kocaeli / TÜRKİYE

Tel: 90 262 6582454 (pbx) Faks: 90 262 6582404 Web: www.omegaboya.com E-mail: omega@omegaboya.com
REV NO: 02 1421-1208 Epoxy S.Tolerant HB Mid Coat Sayfa 1/3 FORM NO: 330-RP 0703



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1431-1301	Epoxy Top Coat
1431-1209	Epoxy Miox 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, as it can also be used easily as semi gloss **topcoat coating** on the preferred surfaces **without application of topcoat**.

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 75-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

Epoxy Surface Tolerant HB Mid Coat

Product Code

1421-1208

Color

By demand

Gloss

Semi Gloss

Density

1,40 ± 0,05 g/ml

Solid, %

By Mass

83 ± 3

By Volume

73 ± 5

Drying Time

Dust Dry

30 – 45 min / 20°C

Touch Dry

1 - 1,5 h / 20°C

Montage Dry

48 h / 20°C

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REV NO: 02

1421-1208 Epoxy S.Tolerant HB Mid Coat Sayfa 2/3

FORM NO: 330-RP 0703



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Complete Dry

7 days

VOC

230 gr/lit

Mixing Ratio

By Mass

5 Portion Epoxy Surface Tolerant HB Mid Coat (1421-1208)
1 Portion Epoxy Surface Tolerant HB Hardener (1421-1508)
1 Portion Epoxy Thinner (1451-1401)
The mixture gives the application viscosity.

Pot Life

8 h / 20°C

Application Viscosity

20" - 24" / DC4 / 20°C (spray - airless)
25" - 38" / DC4 / 20°C (brush - roller)

Thinner To Be Used

1451-1401

Application Methods

Brush, Roll, Spraying (spray - airless)

Recommended Dry Film Thickness

80 - 90 μ

Theoretical Application Area

8,5 - 9,5 m² / lt (80 - 90 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.

The modifications in the document (up-to-date version) shall be broadcast on www.omegaboya.com

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