Technical Data
Epoxy HR

Jotun Protects Property

Product description
Epoxy HR is a two-component, high solid phenolic epoxy coating with high heat resistance.

Recommended use
Corrosion protection for external areas of pipes and other steelwork exposed to high temperatures (up to 200ºC). Also suitable for application to hot substrates (up to 150ºC). Note that Epoxy HR may change colour at elevated temperatures.

Epoxy HR is also suitable for prevention of corrosion under insulation up to 200ºC, please contact Jotun for details of acceptable conditions.

Film thickness and spreading rate

	Minimum	Maximum	Typical
Film thickness, dry (µm)	100	200	125
Film thickness, wet (µm)	160	320	200
Theoretical spreading rate (m²/l)	6,3	3,2	5

Physical properties

Colour	Aluminium, Light Grey
Solids (vol %)*	63 ± 2
Flash point	28ºC ± 2 (Setaflash)
VOC	310 gms/ltr UK-PG6/23(97). Appendix 3
Gloss	Flat
Water resistance	Very good
Solvent resistance	Excellent
Chemical resistance	Excellent
Flexibility	Fair

*Measured according to ISO 3233:1998 (E)

Surface preparation

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504.

Bare steel
Cleanliness: Power tool cleaning to min. St 2, mill scale free (ISO 8501-1:2007) and a roughness between 35 - 50 microns. Improved surface treatment (blast cleaning to Sa 2½) will improve the performance.

Other surfaces
The coating may be used on other substrates. Please contact your local Jotun office for more information.

Condition during application

The temperature of the substrate should be minimum 10°C and at least 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. The coating should not be exposed to oil, chemicals or mechanical stress until fully cured.

Application methods

Spray	Use airless spray
Brush	Recommended for stripe coating and small areas, care must be taken to achieve the specified dry film thickness.

Application data

Mixing ratio (volume)	6,5:1
Mixing	6,5 parts Comp. A (base) to be mixed thoroughly with 1 part Epoxy HR, Comp. B (curing agent)
Induction time	20 minutes.
Pot life (23°C)	4 hours (Reduced at higher temp.)
Thinner/Cleaner	Jotun Thinner No. 23
Guiding data airless spray	
Pressure at nozzle	15 MPa (150 kp/cm², 2100 psi)
Nozzle tip	0.46-0.69 mm (0.018-0.027")
Spray angle	40-80°
Filter	Check to ensure that filters are clean.

Drying time

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

* Good ventilation (Outdoor exposure or free circulation of air)
* Typical film thickness
* One coat on top of inert substrate

Substrate temperature	10°C	15°C	23°C	40°C	100°C
Surface dry	16 h	12 h	4 h	2 h	0,5 h
Through dry	26 h	20 h	10 h	4 h	1 h
Cured	21 d	14 d	7 d	3 d	1 d
Dry to recoat, minimum	26 h	20 h	10 h	4 h	1 h
Dry to recoat, maximum [1]	21 d	14 d	7 d	3 d	1 d

1. The surface should be free from chalking and contamination prior to application. If the maximum dry to recoat time is exceeded, please contact Jotun for advice.

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

Typical paint system

Epoxy HR **2 x 125 µm** **(Dry Film Thickness)**

Other systems may be specified, depending on area of use

Storage

The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed.

Handling

Handle with care. Stir well before use.

Packing size

20 litre unit: 16.3 litres Comp. A (base) in a 20 litre container and 2.5 litres Epoxy HR, Comp. B (curing agent) in a 3 litre container

Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Material Safety Data Sheet.

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THIS DATA SHEET SUPERSEDES THOSE PREVIOUSLY ISSUED