

# Technical Datasheet

## POXENAMEL HB 2/C



Product Code: 08430 Topcoat/Primer

### DESCRIPTION

High-solid polyurethane enamel, made from hydroxylated acrylic resin binder and zinc phosphate corrosion-inhibiting pigment.

### USE: INTERIOR - EXTERIOR

For use as a combined finishing topcoat and primer, for direct application on metal. Ideal for surfaces where good chemical resistance and weather resistance is desired, leaving a smooth, semi-gloss topcoat finish. Provides excellent adhesion on steel and galvanized surfaces. Certified for corrosive environment **Class C-4 Medium and High**, as well as Certification Class **C-5 High**, as per **UNE-EN ISO 12944-6-2018**.

### FEATURES

- Leaves a tough and resistant film.
- Good adhesion on steel and galvanized steel.
- Great opacity and coverage.
- Protects metal against oxidation.
- Good gloss and colour retention.

### APPROVAL CERTIFICATES

- Corrosivity category **C-4 Medium and C-4 High**, as per UNE EN ISO 12944-6: 2018. Tecnalia Laboratories, Certificate No. 083623-003.
- Corrosivity category **C-5 High**, as per UNE EN ISO 12944-6: 2018. Tecnalia Laboratories. Certificate No. 085974-004.
- Fire Reaction: B,s1d0 EN 13501-1

**Finish:** Semi-gloss

**Colour:** Junomatic Industrial Tinting System Colours

**Mixture density:** 1,50 ± 0,05 gr/cc S/FR1001

**Drying time @ 23°C (80µ DFT)**

Touch dry: 1 hour

Dust dry: 6 hours

Tack-free: 8 hours

Operational: 12 hours

**Minimum repaint time:** 15 hours

**Maximum repaint time:** Unlimited

**Thinner:** Spraying: Use **D-17**, Brush/Roller: Use **D-71**

**Recommended dry film thickness:** 140 µ (DFT)

**Practical coverage:** 8,3 m<sup>2</sup>/l (@ 80 micron thickness)

**Recommended coats:** 2

**Mixture volume solids:** 67% ± 2 % Theoretical.

**Component A/B mixing ratio in volume:** 4:1

**Mixture pot-life:** 2 hours (20°C)

**VOC Content:** Max. 500 g/l

**Relative humidity:** Max. 80%

8430 WHITE BASE (P)

8431 DEEP BASE (TR)



Format: 4 L / 15 L

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### SURFACE PREPARATION

**IRON AND STEEL.** Abrasive blasting to Sa 2 ½ grade according to ISO 8501-1. Profile roughness 30µ. Peeling paint coats, mill scale, rust, and foreign matter to be removed.

Apply **POXENAMEL HB 2/C** immediately after blasting to prevent any type of contamination.

**GALVANIZED.** If the galvanization is hot-dip galvanized and this has been exposed to the atmosphere, it normally forms zinc corrosion (whitish rust) and contaminants can accumulate. These must be removed by washing with fresh, clean water containing detergents and by abrasion, followed by intensive cleaning with hot water. Alternatively, the use of hot water, pressurized water, steam cleaning, sweep blasting or cleaning with manual or mechanical tools may be suitable. Given the wide variety of galvanized materials in the market, it is recommended to carry out a test patch to check the strength and adhesion of the paint prior to application to prevent possible incompatibilities.

### APPLICATION TIPS

Stir component A in its container and once paint is properly homogenized and mixed, add component B slowly to it (in the indicated proportions), while mechanical stirring is carried out at low speed. Put the lid on, and shake the container for 2 minutes until it is perfectly homogenized. Let the mixture rest for 10 minutes. Do not use the product after its potlife of 2 hours. (after mixing the 2 components)

**ENVIRONMENTAL CONDITIONS.** During the application and the curing process the temperature must be kept above 5°C. Relative humidity must not exceed 80%. There should be no rising moisture/damp.

Substrate temperature must be at least 3°C above the dew point. Avoid condensation. Do not apply when risk of rain or high winds.

### APPLICATION METHOD

- BRUSH and ROLLER: The application by these methods, especially roller, could have variations in dry film thickness, so it would be necessary to apply several coats until reaching the recommended thickness.

- CONVENTIONAL SPRAY EQUIPMENT:

Tip Size: 1,5 - 2.0 mm.

Working pressure setting: 3-4 bar.

Dilution between 5-15%.

- AIRLESS SPRAYING

Tip size: 0.43-0.53 (0.017-0.021").

Working pressure setting: 175 bar.

Max. dilution: 5%

The exact determination of the dilution percentage will depend on the temperature, work pressure setting, type of nozzle, etc.

Pay special attention not to dry spray; the deposited paint coat must be damp, otherwise adhesion problems will occur.

Do not paint in wet weather/rain or during the warmest time of day/hours of maximum heat levels.

### OBSERVATIONS

The combination of using different application methods/tools, differences in dry film thickness, and environmental conditions can cause variations in gloss level.

### SAFETY & ENVIRONMENT

Solvent based products must be applied with good ventilation and with the necessary protection measures. Avoid sources of ignition.

Minimize product waste by estimating the amount needed, taking into account the m<sup>2</sup>, porosity and the surface texture.

Store excess material/leftover paint in a ventilated and dry place. The container must be clean and of adequate size for the amount of product left over.

Close containers carefully and keep upright to avoid spills. Preserve containers away from frost, high temperatures and direct exposure to the sun.

Do not eat, drink or smoke during the preparation and application of the product. Surface preparation and application operations must be carried out with the corresponding safety measures.

For more information, consult the product's Safety Data Sheet.

In case of contact with eyes wash with clean and abundant water. Keep out of the reach of children. Do not discharge into drains or the environment.

Dispose to an authorized waste collection point. Consult your municipality for the correct recycling of both the container and waste and leftovers of paint according to rules/legislation and principles of environmental respect.

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