

High build epoxy coating

SUPERPOXY 270HB(HD)



SUPERPOXY 270HB(HD) is a high-build polyamide epoxy with high solids content designed for industrial and marine use in severe environmental condition. It provides excellent durability in marine atmosphere and economical long-term protection with only one coat.

Usage

Intermediate or top coat for tank-exterior, structural steel, piping in chemical plants, box girder and refineries, etc.

Application Procedure

Procedure	<ol style="list-style-type: none">1. Surface preparation<ol style="list-style-type: none">1) Steel : All primed surfaces must be free of oil, moisture and any other contaminants.2) Concrete : As a fully cured state and prepare in accordance with blast cleaning or prickling2. Environmental Conditions Over 5°C is ideal for painting and hardening. The surface temperature must be at least 3°C above the dew point to prevent moisture condensation. Drying time can be different under -5°C.3. Application Equipment Conventional or airless spray, power mixer, brush Airless spray: Tip size-0.021~0.025inch Output pressure-143atm Recommended thinning ratio: about 30%(Mist) about 20%(Main, airless spray) (*Airless spray data are indicative and subject to adjustment)
Caution for usage	<ol style="list-style-type: none">1) Mix the material according to designed mixing ratio and use after stirring it until uniformly blended. And, Use the mixed paint within pot life.2) Avoid applying paint on rainy days, high humidity(Over 85%) day, low temperature(Under -5°C) condition.3) When applied over inorganic zinc, a mist coat is required for removing pinhole and bubbling.4) Even if you use same product(color, lot), the painting equipment and method(thinning ratio) can cause different color. So, you should check the color before using it.5) When coating summer season (April~September), 'SUPERPOXY 270HB(HD) SUMMER TYPE <PART B>' is recommended.6) When apply this paint to exposure region, it is possible to occur yellowing and chalking, so you have to apply good weather resistance topcoat.7) When exposed long time, the chalking can be occurred. So, remove chalking and dust before recoating.
Caution for handling	<ol style="list-style-type: none">1) Store it indoor (5~35°C) condition, avoiding heat and open flame. And, keep it standing and being closed.2) Dispose of the waste paint through the waste disposal company designated by the Ministry of Environment.3) Since this product is a chemical product, it may deteriorate during long-term storage. Please refer to our customer center for the products that have passed this period.
Warning	Please refer to the warning in the appendix.
Application system	Preceding primer : SUPERZINC 190BG(D), SUPERZINC 190BG, SUPERPOXY 122, etc. Subsequent topcoat : SUPERTHANE 300BG, SPIFLON(S), etc.

Physical Data

Finish	Flat	Color	Wide range of color
Applied over	Primed steel or concrete	Components	2
Volume Solid	Approximately 75%	Recommended Film Thickness	100~125 μm
Coats	1~2	Mixing Ratio A : B	1:1(vol)
Recommended Coverage	7.5 m ² /L (@ D.F.T. 100μm) * Allow for application losses and surface irregularities.	Pot life(20°C)	6hrs (by 20% thinning)
Dry times(20°C) (SUMMER TYPE)	Dry through : 8hrs	Recoatible(20°C)	To topcoat(min/max) : 8hrs ~ 1months
Diluent	KOATHINNER 123S, SUPERTHINNER 123(S)	Shelf Life	12months (When stored indoors at 5~35°C)

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Packing Unit	18L[9L/9L]		
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The information given in this document is based on laboratory tests and on-site application results, but may vary depending on quality improvement and work conditions.

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