



# HB MIO EPOXY BUILD FINISH EM97

## A high performance two pack epoxy solvent based micaceous iron oxide build coating and finish

### Recommended Areas of Use

As an intermediate build coat or finish on suitably primed steel and non-ferrous substrates. This product produces a tough, hard wearing coating that is recoatable even after long periods of exposure.

### Certificates & Approvals

Manufactured under the auspices of an ISO 9001:2008 quality & ISO 14001:2004 environmental management systems.

2004/42/EC EU limit value for this product (cat.A/j sb): 500g/l (2010). This product contains max. 375 g/l VOC.

### Properties

<b>Gloss</b>	Eggshell (approx. 20%)	<b>Surface dry</b>	2 hours
<b>Theoretical Coverage</b>	7.5 m <sup>2</sup> /L/coat	<b>Minimum over coating time</b>	3 hours minimum
<b>Recommended number of coats</b>	1 to 2 coats, depending upon desired build.	<b>Maximum over coating time</b>	Unlimited
<b>Density</b>	1.67 kg/L	<b>Minimum application conditions</b>	Temperature > 10°C, RH < 65% (but must be 3°C above dew point)
<b>Volume solids</b>	56% (mixed)	<b>Time to light traffic</b>	24 hours minimum, after final coat
<b>Flash point (Abel closed cup)</b>	27°C	<b>Shelf life</b>	12 months minimum in original unopened containers.
<b>VOC</b>	375 g/L	<b>Colour range</b>	Natural & Silver Grey plus limited range of additional metallic colours.
<b>Thinner / Cleaning</b>	Bradite Thinner TE36	<b>Temperature Resistance</b>	200°C (some discolouration may occur)
<b>Pot Life</b>	6 hours (see notes section)	<b>Mix Ratio</b>	Base & Activator tins are supplied pre-measured. For part mixing use: 3:1 (v/v) or 100:18 pbw
<b>Recommended wet film thickness</b>	134 microns/coat	<b>Recommended dry film thickness</b>	75 microns/coat

### Suitable Surfaces

For internal & external steel & non-ferrous substrates which are dry, free of contamination and have been properly prepared and primed. Compatibility with existing coatings should be confirmed by preparing and painting a test patch. [Note, not suitable for applying over asphalt, bitumen, epoxy tar, alkyd, chlorinated rubber or vinyl based paints.]

### Application Information

Application and use should always conform to the codes of practice described in BS 6150 and BS 5493.

**Brush and Roller** – supplied ready for use. Thin, if required, with 0 - 10% Bradite Thinner TE36.

**Conventional Air Spraying** - Thin with 10 - 20% Bradite Thinner TE36 as required, tip size - 3.0mm, tip pressure 60psi (0.4MPa) approximately.

**Airless Spraying** - Thin with 0 - 15% Bradite Thinner TE36 as required, tip size - 19 thou (0.48mm) approximately, tip pressure - 2100 psi (15MPa) approximately.

## Cleaning

Clean all equipment immediately after use with Bradite Thinner TE36 for best results.

## Specifications

### Preparation – industrial protective coating

High pressure steam cleaning to remove all loose, flaking paint and contamination back to a sound surface. Bradite TD39 industrial strength detergent, washing and rinsing should be used with scrubbing to remove grease or oil.

For new or total repair, steel should be blast cleaned to SIS Sa 2<sup>1/2</sup> minimum with a blast profile of 35-50 microns. (For maintenance repair, sweep blast or mechanically abrade existing coating to provide a key. Damaged or rusty areas should be blast cleaned to SIS Sa 2<sup>1/2</sup> or mechanically to SIS St 3 minimum).

1st coat	Bradite Surface Tolerant Epoxy Primer EP92*
2nd coat	Bradite HB MIO Epoxy Build Finish EM97
3rd coat	Bradite Polyurethane Gloss Finish PG77
4th coat	Bradite Polyurethane Gloss Finish PG77

\* Substitute with Bradite Barrier Primer EU96 on galvanised metal, aluminium and other non-ferrous metal surfaces.

For maintenance painting the 1<sup>st</sup> coat will be a touch up to bare areas only.

### Preparation – wet blasted steel

High pressure steam cleaning to remove all loose, flaking paint and contamination back to a sound surface. Bradite TD39 industrial strength detergent, washing and rinsing should be used with scrubbing to remove grease or oil.

Steel should be wet blast cleaned to SIS Sa 2<sup>1/2</sup> minimum with a blast profile of 35-50 microns then rinsed with fresh water, with excess water being blown off with oil free compressed air. (For maintenance repair, wet blast as previous, feather existing coating to a sound edge and abrade to provide a key.)

## Painting System

1st coat	Bradite Surface Tolerant Epoxy Primer EP92
2nd coat	Bradite HB MIO Epoxy Build Finish EM97
3rd coat	Bradite Polyurethane Gloss Finish PG77

For maintenance painting the 1<sup>st</sup> coat will be a touch up to bare areas only.

### Preparation – high temperature applications (200°C)

High pressure steam cleaning to remove all loose, flaking paint and contamination back to a sound surface. Bradite TD39 industrial strength detergent, washing and rinsing should be used with scrubbing to remove grease or oil.

For new or total repair, steel should be blast cleaned to SIS Sa 2<sup>1/2</sup> minimum with a blast profile of 35-50 microns. (For maintenance repair, sweep blast or mechanically abrade existing coating to provide a key. Damaged or rusty areas should be blast cleaned to SIS Sa 2<sup>1/2</sup> or mechanically to SIS St 3 minimum).

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1st coat	Bradite HB MIO Epoxy Build Finish EM97
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## Notes

An induction period of 20 minutes after mixing is required if material temperatures are below 10°C.

## Summary Safety Information

Always refer to the Health and Safety sheet for the product before use, and observe the warning phrases on the label.

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