



BIPOX HB MIDCOAT

PRODUCT CODE: 6145

Description

BIPOX HB MIDCOAT is a high-build 2 component adhesive primer based on epoxy resins.

Features

- good adhesion on electrolytically and thermally zinc-coated steel, aluminium and stainless steel.
- good adhesion on non-ferrous metals
- readily spread
- effective rust prevention
- water resistance
- high chemical resistance
- suitable for spattering
- for use as primer or as 'direct to metal' system and as one-layer system

Uses

In protective coating systems for steel and non-ferrous metals. Directly on steel as primer for Bicholux, Bicholux QD and Bichothane 2K PU Spray Enamels or as intermediate layer between Bipox HB Zinc Phosphate Primer and Bichothane 2K-PU Enamels.

For containers, road tankers, chassis, and other industrial applications with stringent requirements for chemical, water and corrosion resistance.

Specifications

(tinted product at 20°C)

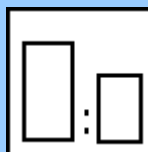
Finish	: satin gloss
Gloss level (60°)	: approx. 50
Colour	: using BICCS colour mixing system
Theoretical coverage	: 5.9 m ² /l at 100 µm dry film thickness
Specific gravity	: 1.38 g/ml
Solids content	: 74% wt. / 60% vol.
Flash point	: 22°C
Application conditions	: min. 5°C / 80% R.H.
VOC content	: 360 g/l
Shelf life in can	: min. 1 year in original, unopened packaging (5 – 25°C)

APPLICATION INSTRUCTIONS



Surface preparation

The surface must be completely clean, dry, and free of grease and rust.
First sand old and intact paint layers.



Mixing ratio

4 : 1 by volume

Hardener

Bipox Hardener for Midcoat

Potlife

6 hours



Viscosity and thinning

BICCS Thinner 0104
Max. 10 – 20% - Air spray
max. 5 – 10% - Airless spray

Air spray

Nozzle 1.8 – 2.0, 3 to 4 bar
20 – 30 sec. DIN cup 4

Airless

Nozzle 0.013" - 0.015"
140 – 160 bar
30 – 50 sec. DIN cup 4



Spraying instructions

1 - 2 cross-coats.

Recommended film thickness

Min. 180 µm wet
Min. 100 µm dry

Tool cleaning

Washing thinner or BICCS thinner 0104



Drying times

Touch-dry approx. 30 minutes
Tack free approx. 60 minutes
For re-spraying after initial drying, but within max. 4 days or after thorough curing.

For sanding approx. 24 hours
Cured approx. 7 days

Data at 20°C and 65% RH



Substrates

Steel, grit-blasted steel, electrolytically and thermally zinc-coated steel (galvanised, Senzimir zinc-plating)
Old intact paint layers, clean, dry, free of grease, rust and contamination and adequately roughened if necessary.

Additional Information

Bipox HB Midcoat is ready-to-use for brush application on small areas.
The hardener for Bipox HB Midcoat is not interchangeable with the hardener for Bipox HB Zinc Phosphate Primer.
Bipox HB Midcoat is suitable for exterior applications, however it must be covered with a top coat.
The Bipox HB Midcoat hardener causes a strong colour deviance when used in combination with colour pastes L (maroon red) and K (organic orange). This means the red series cannot be made up.

Warning/restricted applicability

Considering the great diversity of purpose-specific aluminium alloys available in the market, it is impossible for us to recommend a single coating system that will apply to all kinds of aluminium. Our product data is generally based on pure, unalloyed aluminium, also known as the 1000 series.

Safety

See the appropriate safety sheet.

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The information provided in this product information sheet is based on accurate testing carried out in our laboratory, and is intended solely as a guideline. All recommendations and suggestions related to the use of products produced by BICCS, including but not limited to that provided in technical documentation or in response to a specific question, is based on data that we have compiled to the best of our knowledge. The products and information are intended for users in possession of the required specific knowledge and industrial skills, and the suitability of any product for any purpose whatsoever remains at all times the responsibility of the end user. BICCS bv has no knowledge of the quality or condition of the substrate, nor of the many factors that can influence the use and application of the product. BICCS therefore accepts no liability of any kind pertaining to loss or damage as a consequence of the use of or reference to this data sheet, except where otherwise agreed in writing.

The data in this information sheet is subject to amendment, and is the result of practical experience and continuous product development. This data sheet replaces all earlier publications, and it is therefore the responsibility of the user to make certain that this sheet is the correct version, before proceeding to use the product to which it pertains.



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INDUSTRIAL COATING & COLOURANT SYSTEMS

N.B. De technische gegevens in deze publicatie steunen op onze huidige kennis. Zij gelden als aanduiding en leveren u vrijblijvend een beeld van de toepassingsmogelijkheden van onze producten. De gegevens kunnen door een recentere uitgave gewijzigd worden.

Please note: The technical data in this publication are based on our current knowledge. These should be regarded as indicative, providing an impression of possible applications of our products without obligations. The data may be updated or changed in future editions.