

# HAYMES PAINT INDUSTRIAL COATING SOLUTIONS

## 309 2K Epoxy

Product Codes: I309B

### Product description

Haymes Paint Industrial Coating Solutions 309 2K Epoxy is an epoxy topcoat, suitable for most industrial and commercial applications. It is characterised by excellent adhesion and anti-corrosive properties with high abrasion and solvent resistance.



#### Key Features

- ✓ Superior performance
- ✓ High gloss
- ✓ Quick and easy application

### Where to Use (Substrates)

Mild steel, aluminium, galvanised iron, glass reinforced plastics (GRP) and previously painted substrates in sound condition.

Product Name	Volume Solids %	Weight Solids %	Density g/mL	VOC g/L
309 2K Epoxy	42.7	51.0	1.050	514.6

### Surface Preparation

 <b>Mild Steel</b>	DTM: Sand with 240 Frecut. Primer: Apply Haymes Paint Industrial Metal Etch Primer or Haymes Paint Industrial Universal Primer. Sand with P600 wet or dry.
<b>Aluminium</b>	<u>Primer:</u> Apply Haymes Paint Industrial Metal Etch Primer. Sand with P600 wet or dry.
<b>Galvanised Iron</b>	<u>Primer:</u> Apply Haymes Paint Industrial Metal Etch Primer. Sand with P600 wet or dry.
<b>Glass Reinforced Plastics (GRP)</b>	<u>Primer:</u> Apply Haymes Paint Industrial Metal Etch Primer or Haymes Paint Industrial Universal Primer. Sand with P600 wet or dry.
<b>Previously painted Surfaces</b> (in sound condition)	Sand with P600 wet or dry.

**Special Notes:**

- All surfaces must be thoroughly sanded and cleaned with Haymes Wax & Grease Remover prior to application.
- Surfaces must be clean, bare, dry and free of dust, wax, grease, surface contamination and oxidation prior to painting.
- Use white or light-coloured primers under bright yellows, oranges and reds, if required.
- The above systems are examples only. For further information, please contact Haymes Paint on 1800 033 431.

**Product Preparation**

	<ul style="list-style-type: none"> <li>• Weigh the concentrates into the required base in accordance with the relevant colour formula.</li> <li>• A maximum of only 10% reduced concentrates is allowed and a maximum of 35% for all concentrates, in total.</li> <li>• Stir or shake for a minimum of 10 minutes.</li> <li>• Never leave the mixture stand for more than 30 minutes before mixing.</li> </ul>			
 <b>Mixing Ratio</b> 4:1 (by volume)	Haymes Paint Industrial Coating Solutions 309 2K Epoxy	Haymes Paint Industrial Coating Solutions 309 Epoxy Hardener		
	4 parts	1 part		
 <b>Reducer</b>	Up to 20% (v/v) Haymes Paint Industrial Coating Solutions 2K Thinner, if required.			
 <b>Matting</b> (if required)	<b>Satin Finish:</b> Add 30% of 399 Flattening Base. <b>Matt Finish:</b> Add 45% of 399 Flattening Base. <b>Notes:</b> = Never add more than 50% of 399 Flattening Base. = 399 Flattening Base must be added before adding a hardener or thinner. = The addition of 399 Flattening Base will reduce coverage.			
 <b>Pot Life</b> @ 25C	3 to 4 hours.			
 <b>Spray viscosity</b> @ 25C	BSB 4 Cup	17 to 19s		
	Ford 4 Cup	15 to 17s		
<b>Spray Equipment</b>	<b>Gun type</b>	<b>Fluid tip</b>	<b>Spray pressure</b>	<b>Spray distance</b>
	Gravity Feed	1.2 to 1.4mm	2.0 – 2.4bar 30 - 35psi	15 - 20cm 6 - 8inch
	Suction Feed	1.5 to 2.0mm	2.0 – 2.4bar 30 - 35psi	15 - 20cm 6 - 8inch
	Airless, Air Assisted, Electrostatic	Consult the spray gun manufacturer's instructions.		

Product Preparation (continued)		
 <b>Number Of coats</b>	2 - 3	Apply one light coat followed by one or two even full coats. Avoid heavy wet coats.
 <b>DFT Recommended</b>	80 to 100 µm 3.1 – 4.0 mils	
 <b>Flash off time @ 25C</b>	5 to 10 mins between coats.	
 <b>Drying</b>	Air Dry @ 25°C	Tack free: 3 to 4 hours. Recoat with itself after 7 hours minimum and 36 hours maximum.
This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.		

Before Use	
	Stir all products thoroughly each time before use. Stir the mixture well after the weigh out of components.
	Before application a colour comparison is <b>STRONGLY</b> recommended.
	Surface temperature must always be a minimum of 3C above dew point.

Dry Film Properties (after 7 days drying, when compared to similar technology products)	
<b>Gloss 60/20</b>	95/85.
<b>Water resistance</b>	Excellent.
<b>Petrol resistance</b>	Excellent.
<b>Abrasion resistance</b>	Excellent.
<b>Durability</b>	Good (will chalk and yellow on prolonged exposure).

Equipment Cleaning	
Use Haymes Paint Industrial Coating Solutions 2K Thinner.	

**Storage**

Read the Safety Data Sheet (SDS) for this product for specific directions on storage (section 7 of the SDS) and transport (section 10 of the SDS). To obtain a copy of the SDS, go to the Haymes Paint website, <https://www.haymespaint.com.au/products/technical/product-data-sheets-and-safety-data-sheets/>, or contact Haymes Service Express on 1800 033 431. Containers must be secured and stored upright during transit. Protect from extremes of temperature. Store in a cool, dry, well-ventilated place and out of direct sunlight. Check regularly for leaks. Ensure the container label remains legible for future identification and usage.

**Coverage**

Approximately 4.0 m<sup>2</sup>/L @ recommended DFT.

Shelf Life: 36 months in an unopened container at room temperature away from sunlight.

**Safety & First Aid**

For automotive and industrial use only by professional painters. Not recommended for sale to, or use by the general public.

Read the Safety Data Sheet (SDS) for this product, prior to using this product. The SDS contains important information on how to use this product safely including hazards and precautions, personal protective equipment, storage and first aid in the event of an emergency. To obtain a copy of the SDS, go to the Haymes Paint website, <https://www.haymespaint.com.au/products/technical/product-data-sheets-and-safety-data-sheets/>, or contact Haymes Service Express on 1800 033 431.

If the product is swallowed, phone the Poisons Information Centre on 13 11 26 or contact a Doctor. Keep out of reach of children. Avoid contact with skin and eyes. Wear suitable, protective clothing, eye protection and impervious gloves when mixing and using.

**Protect our environment**

Do NOT pour any leftover product down the drain. Retain in a marked, sealed container for future use or disposal via chemical waste collection programs such as Paintback ®. Visit [www.paintback.com.au](http://www.paintback.com.au) for details of your nearest depot. Dried empty containers can be recycled and should be disposed of via recycling facilities.

**Manufacturer's comment**

This product has been designed as part of an integrated application system. Use with any other manufacturer's product(s) or failing to follow application instructions, could result in detrimental effects on product performance, for which Henry Haymes Pty. Ltd. cannot be held responsible. Important safety information is available on the Safety Data Sheet available from Haymes Paint website [www.haymespaint.com.au](http://www.haymespaint.com.au). Further information about other Haymes products recommended to be used in conjunction with this product are available from the website in the form of Product Data Sheets in relation to those products. We are continually updating materials and methods, so please ensure you have the latest information on the Haymes Paint website.

**Disclaimer**

The information provided in this Product Data Sheet is correct at the time of preparation, but is subject to change. It is your responsibility to check the Haymes Paint website at [www.haymespaint.com.au](http://www.haymespaint.com.au) to ensure that you have the most current Product Data Sheet. Product application and performance is affected by environmental conditions at the time of application and drying. Paint applied in conditions outside of what is recommended may dry more slowly or be less durable, or produce a less uniform appearance.

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