



TECHNICAL DATA SHEET

HB-330 Low Temperature High Build

Description

HB-330 is a specialist two-component, pigmented, high performance epoxy resin formulated with excellent rapid cure properties, at low temperatures, offering good chemical resistance and providing excellent adhesion on wet and green concrete surfaces.

Its ability to cure over a wide temperature range can bring coating broad application latitude.

Features & Benefits

- Nonylphenol free.
- 100% Solid.
- Gloss finish.
- Easy to clean.
- Good abasion resistance.
- Very good chemical and mechanical resistance.
- Excellent combination of rapid cure and long pot life at both ambient and low (<5°C) temperatures.
- Continues to chemically crosslink at very low temperatures (<0°C).
- Excellent film quality even at low temperatures and high humidity.
- Excellent early water resistance.
- Very good chemical resistance.
- Good flexibility.
- Superior corrosion resistance.
- Based from natural, renewable, non-food chain raw material feedstock.

Packaging Kit

- 5.2kg kit - Components A & B
- 10.4kg kit - Components A & B
- 15.6kg kit - Components A & B

Coverage

Coverage varies widely due to the porosity and profile of different substrates.

- 5.2kg covers 20 m²
- 10.4kg covers 40 m²
- 15.6kg covers 60 m²

* Coverage figures given are theoretical. Practical coverage rates may vary due to wastage factors and site condition, profile, and porosity of the substrate.

Substrate Requirements

Requirements as follows:

- The concrete substrate must be prepared mechanically to achieve an open texture surface using a captive shot blast machine or diamond grinding.
- Ensure an even and regular surface.
- Free from cracks and fissures. if any, they must be previously treated (we recommend Sindec Epoxy Crack Filler).
- Clean and dry, free of dust, loose particles, oils, organic residues, laitance, and contaminants.

*Inadequate preparation will lead to loss of adhesion and failure.

Tensile Adhesion Strength

>1.5 N/mm² to concrete

Compressive Strength

>25 N/mm² to concrete

Environmental Conditions

Optimum ambient temperature range is 15 – 25°C. Localized heating (electric powered warm air blower) or cooling equipment may be required outside this range to achieve ideal temperature conditions.

The substrate and uncured floor must be kept at least 3°C above the dew point to reduce the risk of condensation or blooming on the surface, relative humidity at less than 75%. (ideally between 50-65%) from before priming, to at least 48 hours after application.

Installations outside of the above parameters will affect the cure period, surface finish and strengths.

Mixing

Pour the hardener component B into the resin component A and mix both components for a minimum of 3 minutes using a low-speed paddle mixer (300-400 rpm). Use a spatula to scrape the sides and bottom of the bucket. To ensure proper mixing, pour the resin into a clean bucket and mix for 1 further minute.

Product Application

Once mixed, **HB-330** should be applied immediately in a thin continuous film at 250-300g/m². Work the resin into the surface using a squeegee, then roll to avoid pooling. On porous surfaces **HB-330** will be absorbed very quickly, so use enough required amount of resin to ensure complete surface sealing. Apply two coats.

Technical Information

Curing Schedule 20°C	Recoat Light Foot Traffic Light Wheeled Traffic Full Chemical Cure	Within 24 hours Minimum 24 hours Minimum 48 hours 7 Days
Shelf Life	Resin & Hardener:	12 Months
Pot Life	Temp 20°C	15 - 20 Minutes
Storage	This Product must be stored off the ground in original packaging, unopened and un-damaged. The ambient conditions must be dry and between 10°C and 30°C with no direct sunlight. Protect from frost.	



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Chemical Resistance

See Chemical Resistance Chart.

Cleaning

Regular cleaning is essential to enhance and maintain the life expectancy, slip resistance and appearance of the floor. **HB-330** can be easily cleaned using industry standard cleaning chemicals and techniques. Consult your cleaning chemical and equipment supplier for more information. It is recommended that a sample area of your cleaning chemical is tested in an inconspicuous spot before full use.

Appearance

Gloss finishes in a range of standard colours (see the Sindec Chemicals Colour Chart).

Technical Advice

For further information on this or any other Sindec product, please contact our office.

Limitations

Do not proceed with application if atmospheric relative humidity is, or is anticipated to be, >75% or if the surface temperature is <3°C above the dew point. Application should not commence when the substrate temperature or the ambient temperature is or is anticipated to be <10°C during the application or within the curing period.

The design strength of the substrate concrete surfaces must be a minimum of 25 N/mm² compressive strength at 28 days. Compact and cohesive pull of test must show a minimum resistance of 1.4 N/mm².

The manufacture of **HB-330** is a batch process and despite close manufacturing tolerances, colour variation may occur between batches. Products from different batches should not be used on the same surface or surfaces close together. If mixed batches are unavoidable, it is best practice to use the different batches only in areas where the colour cannot be directly compared. Touching up should only be attempted using product from the same batch.

Disposal of Containers

Empty containers must be handled with the same precautions as if they were full. Treat empty containers as hazardous waste and transfer them to an authorized waste manager. If the containers still have some material left, do not mix with other product before considering the risk of potentially dangerous reactions.

Any remaining parts A and B of the same product should be mixed and allowed to cure before disposal.

Health & Safety

Before using this product, please ensure that you have received and read the product Material Safety Data Sheet. Refer to the hazard labelling on the product. Always wear gloves and goggles and avoid contact with skin and eyes.

Additional Information:

The information contained in this document, and all further technical advice given is based on our present knowledge and experience.

However, it implies no liability or legal responsibility on our part. No warranty or guarantee of product performance in the legal sense is intended or implied as the conditions of use and the competence of any labour involved in the application are beyond our control.

Properties and coverage rates shown are for guidance purposes only. The user of the product must determine the product's suitability for the intended purpose. We reserve the right to make any changes according to technological progress or further developments.

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