IriMid HB™

General Description

A two-pack high build polyamide cured epoxy coating suitable for atmospheric and marine conditions. The product is especially suitable as an intermediate coat between organic and inorganic zinc-rich primers and the final matt topcoat. IriMid HB™ can be recoated with all IRIS® topcoats.

Product Technical Information

- Solids by volume 70 ±1 %
- Density 1.55 ±0.05 Kg /Lit
- Flashpoint >16ºC
- Colors/Finish White, Grey / Matt
- Mixing ratio Base to Hardener 82.5 to 17.5 (by volume)
- Suitable Thinner/Cleaner IriThin33

Note: Always add thinner after mixing the components.

- Pot Life

@ 10ºC	@ 23ºC	@ 30ºC	@ 40ºC
6 hours	4 hours	2 hours	1 hour

Drying & Recoating Times

Temperature	To touch	To handle	To recoat		Full cure
			Minimum	Maximum	
@ 10ºC	8 hours	24 hours	24 hours	8 days	10 days
@ 23ºC	3 hours	16 hours	16 hours	5 days	7 days
@ 30ºC	2 hours	10 hours	10 hours	3 days	5 days
@ 40ºC	1 hour	8 hours	8 hours	2 days	4 days

Note: Drying times are dependent on air and surface temperatures as well as film thickness, ventilation, and relative humidity. Maximum recoating time is highly dependent upon actual surface temperatures, not simply air temperatures, higher surface temperatures shorten the maximum recoat window.

The surface should be dry and free from contaminants prior to overcoating. The best inter-coat adhesion is achieved when the subsequent coat is applied before the preceding coat is fully cured. After prolonged exposure times it may be necessary to roughen the surface to ensure inter-coat adhesion. When in doubt, consult your nearest **Darya Tamin** office.

Application

- **Suitable methods**

Air Spray	Airless Spray	Brush/Roller
• Nozzle pressure: 3-5 bar • Nozzle size: 1.5-2.0 mm • The volume of thinner: 0-15٪	• Nozzle pressure: 120-180 bar • Nozzle size: 0.48-0.66 mm • Spray angle: 40-80 degrees • The volume of thinner: 5-10٪	• Brush is recommended for strip coating & touch up and small areas. Roller may be used for small areas. • The volume of thinner: 0-10٪

- **Recommended thickness**

	Dry film thickness(µm)	Wet film thickness(µm)	Theoretical spreading rate (m^2/l)
Acceptable range	75-200	110-285	3.5-9.3
Recommended	150	215	4.7

Surface Preparation

Surfaces should be free of oil, grease, salt or other contaminants. Remove all wax, silicone, powdery or scaling rust and then clean the surface by fresh water washing. Apply over suitable primer system or clean, intact, prepared existing system.

Primed area: Oil and grease should be removed by solvent cleaning according to SSPC-SP1. Remove salts and dirt by fresh water washing. Apply IriMid HB™ immediately after the quality of preparation has been approved.

On inorganic zinc silicates surfaces: Remove zinc salts and apply a mist coat and then apply IriMid HB™ on it. Be careful that the zinc silicate has been fully cured before applying the mist coat and IriMid HB™.

Repair: Corroded areas should be power tool cleaned to ISO-St3 or blast cleaned to ISO-Sa2 or better and feathering edges of the intact coating. Damaged and corroded areas should be repaired first with an appropriate primer system.

Application Condition

The temperature of the substrate should be at least 3°C above the dew point of the air. Temperature and relative humidity should be measured in the vicinity of the substrate. The maximum recommended surface temperature is approx. 40°C and relative humidity during application and curing should not exceed 80٪ . When applying the paint in confined spaces, provide adequate ventilation during application and drying. The temperature of the mixed paint should be at least 10°C.

Storage, Handling & Shelf Life

Generally, keep the paint containers in dry and cool (5-35 ºC) place and away from heat or open flame. Paint containers must be kept tightly closed in the well-ventilated area and handled with care.
This product's shelf life @ 23 °C is 18 months.

Environmental, Health & Safety Note

Read the material safety data sheet (MSDS) of the product before use and pay attention to safety signs attached to the product can. This product is flammable so keep away from heat and open flame.
Avoid skin and eyes by wearing overall, glove, goggles, and a suitable mask. Spillage on the skin should immediately be removed with a suitable cleanser, soap, and water. Eyes should be well flushed with water, and medical attention sought immediately. Don't discard the product on planets, sea, river and drinking water sources.
Keep out of reach of children.

Disclaimer

The information in this document is given to the best of IRIS's knowledge based on professional tests by our experts. However other factors that are affecting the use and application of this product are out of IRIS's responsibility.

For more information contact with Darya Tamin.