HB-320

Chemical Resistant High Build Epoxy

DESCRIPTION

HB-320 is a two pack solvent free high build epoxy coating that provides a seamless, durable and chemical resistant floor finish. When applied in two or more coats, HB-320 produces a glossy, impervious surface with excellent resistance to abrasion, impact and a wide range of chemicals. Its 100% solids epoxy composition builds a robust coating layer that delivers long term durability in industrial and commercial environments.

HB-320 is suitable for use in factories, workshops, garages, warehouses, plant rooms, laboratories, cleanrooms and wet processing areas where hygiene and ease of maintenance are essential.

Features & Benefits

- **High build epoxy coating**
- **Seamless glossy finish**
- **Excellent chemical resistance**
- **Durable and abrasion resistant**
- **Easy to clean and maintain**
- **Slip resistant options available**
- **Solvent free, low odour**

Packaging Kit

HB-320 is supplied in pre-weighed units to ensure correct mixing ratios:
25 kg unit (Part A + Part B)

Coverage

Typical consumption is **0.25–0.30 kg/m² per coat.**
A 15 kg unit will cover approximately 50–60 m² per coat.
Coverage may vary depending on substrate porosity, surface profile and application method.

Environmental Conditions

Application should take place between 10 °C and 30 °C with substrate temperature at least 3 °C above the dew point. Ambient relative humidity should not exceed 75 % during application and for the first 48 hours of curing. Adequate ventilation is required to promote uniform curing.

Substrate Requirements

Concrete substrates must achieve a compressive strength of at least 25 N/mm² and a tensile strength above 1.5 N/mm². Substrates must be dry (maximum 75 % RH, unless a moisture tolerant primer is used), clean, sound and free from laitance, dust, oils, grease, curing agents or contaminants. Mechanical preparation such as shot blasting or grinding is recommended.

Priming Requirements

HB-320 should always be applied over a primer to ensure full adhesion:

- Dry substrates (<75 % RH): apply **EPR-100 Solvent Free Epoxy Primer.**
- Damp substrates (>75 % RH): apply **DPM-230 Moisture Tolerant Epoxy Primer.**

Highly porous surfaces may require two primer coats.

Mixing

All components should be conditioned to 15 °C – 25 °C before use. Part A (Resin) is poured into a clean container and Part B (Hardener) is added. The two parts are mixed using a slow speed drill (300–400 rpm) until a uniform blend is achieved. The mixed product must be applied immediately.

Product Application

HB-320 is applied by squeegee and roller or brush in two or more coats to achieve the required thickness. The second coat should be applied once the first coat has cured but remains within the overcoating window (typically 16–24 hours at 20 °C). Application should produce a continuous film free from pinholes or dry patches. Broadcast aggregates may be applied into the first coat if a slip resistant finish is required.

Appearance

Gloss finish available in a wide range of standard colours according to the Jofa Resins colour chart. Bespoke RAL colours may be supplied on request.

Chemical Resistance

HB-320 resists a wide range of oils, alkalis, salts and dilute acids. For specific resistance enquiries, contact the Technical Department.

Product Confines

HB-320 should only be applied when substrate temperature is at least 3 °C above the dew point and ambient relative humidity is below 75 %. The coating performs reliably in continuous service up to 60 °C. Slight colour variation may occur under UV exposure without affecting performance.

Cleaning

HB-320 floors should be maintained through regular cleaning using scrubber dryers or rotary machines fitted with soft pads, together with a neutral pH cleaning solution diluted in warm water. Daily sweeping or vacuuming is recommended to remove dust and grit that may cause abrasion of the surface. Spills of oils, foodstuffs or chemicals should be removed promptly with a damp mop to prevent surface staining.

For periodic maintenance, a mild neutral detergent may be used followed by rinsing with clean water. Abrasive powders, steam cleaners, highly alkaline or acidic products must be avoided as they can dull or damage the gloss finish.

Health & Safety

Refer to the Safety Data Sheet (SDS) before use. Applicators must wear appropriate PPE including chemical resistant gloves, safety glasses and respiratory protection in poorly ventilated areas.

Disposal of Containers

Empty containers must be treated with the same precautions as full ones and disposed of via an authorised hazardous waste contractor.

Any remaining Part A and B should be mixed together and allowed to cure before disposal.

Additional Information

Jofa Resins endeavour to ensure that all product guidance provided is accurate and correct. Information given by or on behalf of Jofa Resins is based on tests and installations and on our current knowledge and experience. It implies no warranty or guarantee arising from the use of its products as the substrate and site conditions and the actions of any installation team involved in product application is beyond our control. Whether or not in accordance with any advice, recommendation, specification, or information given by Jofa Resins.

Jofa Resins products are guaranteed against defective materials and manufacture and are sold subject to our standard terms and conditions of sale, copies which can be obtained upon request.

Please contact the Jofa Resins Technical Department for further assistance.

TECHNICAL INFORMATION

Shelf Life	24 Months when stored in unopened containers under proper conditions.
Pot Life Temp 20°C	15 to 20 Minutes
Curing Schedule 20°C	**Foot traffic:** 24 h • **Light traffic:** 48 h • **Full cure**: 7 days
FeRFA Floor Guide	Type 3
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.
Temperature Resistance	Up to 60 °C
Compressive Strength EN 13892-2	>45 N/mm²
Flexural Strength EN 13892-2	>15 N/mm²
Impact Resistance EN ISO 6272	10 Nm
Fire Classification EN 13501-1	B_{fl}-s1
Adhesion Strength EN 13892-8	>2.5 N/mm²

The above values, based on laboratory tests and our practical experience with this product, represent typical properties measured under standard laboratory conditions of 20 °C and 50 % relative humidity.

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