HB-350

High Build Epoxy Wall Coating

DESCRIPTION

HB-350 High Build Epoxy Wall Coating is a two component, solvent-free, high build epoxy system designed for the protection and finishing of vertical surfaces such as concrete, masonry, or steel. It produces a dense, continuous film with excellent mechanical strength and chemical resistance, making it ideal for environments demanding durability, hygiene, and ease of cleaning.

The coating is easy to clean and offers excellent resistance to abrasion and chemicals, making it ideal for food production areas, general manufacturing, workshops, and distribution facilities.

Features & Benefits

- **High Build vertical finish**
- **Seamless glossy finish**
- **Excellent chemical resistance**
- **Durable and abrasion resistant**
- **Easy to clean and maintain**
- **Solvent free, low odour**

Packaging Kit

HB-350 is supplied in pre-weighed units to ensure correct mixing ratios:
5 kg unit (Part A + Part B)

Coverage

Typical consumption is **0.15–0.20 kg/m² per coat.**
A 5 kg unit will cover approximately 25–33 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.

Installations outside of these parameters may affect curing time, surface appearance and long term performance. For concrete bases in direct contact with the ground, a damp proof membrane should be incorporated into the slab design in accordance with CP102 Code of Practice for Protection of Buildings Against Water from the Ground.

Substrate Requirements

The substrate must be sound, clean, dry, and capable of supporting the coating. Concrete and masonry shall be fully cured, with compressive strength ≥ 25 N/mm², pull-off adhesion ≥ 1.5 N/mm², and moisture content ≤ 4% by weight. Steel must be blast cleaned to Sa 2½ (ISO 8501-1) with a surface profile of 50–75 µm, free from rust, mill scale, and contaminants. Cracks, voids, or irregularities must be repaired beforehand, preferably with **EPM-6100 Epoxy Repair Mortar**. For vertical application, substrate temperature must be 10–30 °C, relative humidity < 75%, and at least 3 °C above dew point.

Priming Requirements

HB-350 can be applied directly to a suitably prepared substrate; however, priming is recommended for open or highly porous surfaces to ensure proper adhesion and effective sealing.

- 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-350 The product may be applied by roller or brush, depending on site conditions and the required film build. Application thickness should typically be 150–200 µm dry film per coat. On vertical surfaces, care should be taken to avoid sagging or runs; multiple thinner layers may be applied if necessary to achieve the specified build.

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-350 exhibits excellent resistance to a wide range of oils, salts, alkalis, and dilute acids, making it suitable for use in demanding industrial environments.

Product Confines

HB-350 should only be applied if ambient temperatures are above 10 °C, when the 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

For surfaces coated with **HB-350**, regular cleaning is recommended to maintain hygiene and appearance. The coating may be cleaned using mild detergents, warm water, and non abrasive cleaning equipment. Strong acidic or caustic cleaners should be avoided unless specifically approved for use with epoxy finishes. Periodic inspection is advised, and any areas of damage should be repaired promptly to prevent loss of protection.

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	**Touch dry:** 8 - 10 h • **Overcoat period:** 10 -24 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	>40N/mm²
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.

JOFA Resins | Version 1.0 (July 2025)
All rights reserved © 2025