

# METZ 4HB-EN

## EPOXY NOVOLAC CORROSION RESISTANT COATING



### DESCRIPTION:

Metz 4HB Epoxy Novolac is a 100% solids coating, based on special resins and hardeners which impart outstanding chemical resistance, especially against concentrated inorganic acids. It also cures rapidly even at low ambient temperatures, thus minimising downtime. Metz 4HB Epoxy Novolac can be used as a membrane beneath many Metz corrosion resistant systems. The abbreviation Metz 4HB-EN is used in places on this data sheet.

### FEATURES AND BENEFITS:

- **Outstanding Chemical Resistance**  
Resistant to a wide range of concentrated acids and alkalis, solvents oils and fats. Resistant to spillages of concentrated sulphuric, hydrochloric and phosphoric acids at normal temperatures. Refer to Metz Chemical Resistance Chart.
- **High Temperature Resistance**  
Resistant to temperatures up to 120°C.
- **Solventless**  
100% solids formulation.
- **Rapid Cure**  
Fast setting, minimises downtime
- **Low Temperature Cure**  
Cures at temperatures down to 0°C.
- **Excellent Adhesion**  
Bonds to many substrates, including properly prepared concrete, mild steel and 304 and 316 stainless steel.

### RECOMMENDED:

As a membrane or coating to protect concrete against chemical and mechanical attack in:

- Secondary containment linings
- Acid plants
- Fertiliser plants
- Oil refineries
- Steel Mills
- C.I.P. rooms in food and beverage plants
- Food processing plants
- Meat and Poultry plants

### NOT RECOMMENDED:

For exposure to some strong organic acids and solvents. Refer Metz Chemical Resistant Chart.

Note: Colour changes may occur upon ageing, exposure to U.V. light or strong chemicals.

### PHYSICAL PROPERTIES: (Typical Values)

Abrasion:	280mg/1000 cycles CS-17 wheels (Taber Abrasion 1000gm load/wheel)
Density g/cm <sup>3</sup> :	1.4 - 1.5
Adhesion to concrete (ASTM D7234):	>1.5MPa (Concrete failure)
Max. Continuous Service Temp.:	120°C

Note: For continuous temperatures over 100°C contact Metz re special primer required.

### COVERAGE:

Theoretical quantities (allow for wastage)

Primer:	Metz Epoxy Primer: 0.2 - 0.3 kg per sq. metre, depending on absorbency of surface. 0.3-0.4kg per sq. metre when incorporating Metz Fabric Reinforcement. Metz Fabric Reinforcement is recommended when using as a membrane.
Topping:	Metz 4HB Epoxy Novolac: 0.36 kg per sq. metre at 0.25 mm (250 micron) thickness per coat.

### APPLICATION TEMPERATURE:

For optimum results, maintain a temperature of 5 - 40°C on air and substrate and components during mixing, application and curing.

Note: Materials should be kept as cool as possible. Reducing material temperature will increase pot life.



Acid Proofing & Industrial Flooring • Specialty Ceramic Tiles



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### INSTRUCTIONS FOR USE

#### 1. Temperature of Working Area

For optimum results, maintain a temperature of 5 - 40°C on air, substrate and components during application and curing. The surface temperature of the substrate must be at least 3°C above the dew point. At temperatures below 5°C, the application becomes more difficult and curing is retarded.

At temperatures above 40°C the working time decreases. Application in direct sunlight and rising surface temperatures may result in blistering of the coating due to expansion of entrapped air or moisture in the substrate.

Note: Materials should be kept as cool as possible. Reducing material temperature will increase pot life.

#### 2. Surface Preparation

All surfaces must be clean and free from all contaminants which may inhibit bond. For best results, surfaces should be dry. Concrete on grade should utilise a waterproof barrier beneath the slab.

- New Concrete** - New concrete should have attained a compressive strength of 20 MPa minimum. Surface must be free from form oils and curing compounds. The surface should be a fine wood float finish and be 28 days old. Light abrasive blast, high pressure waterblast or grind to remove laitance and provide uniform textured surface. Surface moisture content should be less than 10%.
- Old Concrete** - Concrete must be sound. Remove laitance, loose deposits, old paints, protective coatings and attacked or deteriorated concrete. Chemically clean surface to remove any contaminants. All structural cracks should be repaired, all slopes re-established and all voids filled. Smaller voids can be repaired with Metz 33EN-Plaster.
- Metal** - Abrasive blast to AS1627.4 Class 3 for immersion conditions and to Class 2 ½ for all other conditions with a minimum blast profile of 50 microns. Check surface for soluble salt contamination. If not immediately overcoating apply Metz Metal Primer. Metz Metal Primer must also be applied for immersion conditions.

#### 3. Mixing

a) **Mixing Equipment**  
Mechanical mixing is recommended. A low speed mixer or a heavy duty drill with an appropriate mixing paddle are suitable.

b) **Mixing Proportions**

	By Weight	By Volume
<b>Metz Epoxy Primer</b>		
Liquid	1.85	1.6
Hardener	1	1
<b>Metz 4HB-EN</b>		
Liquid	4.2	3.5
Hardener	1	1

Note: The liquid to hardener ratio must not be altered under any circumstances.

c) **Mixing Procedure** - Remix liquid components prior to use. For Metz Epoxy Primer, mix liquid and hardener together thoroughly for 1 - 2 minutes. For Metz 4HB-EN, mix liquid and hardener together thoroughly for 3 minutes.

At end of the mixing period material should be uniform in colour. Material which has begun to set must be discarded. Do not add any solvent, additive or adulterant to any component, or to the mixed material.

d) **Pot Life**

Metz Epoxy Primer

at 20°C 70 minutes

at 30°C 40 minutes

at 40°C 30 minutes

Metz 4HB-EN

at 20°C 40 minutes

at 30°C 30 minutes

at 40°C 20 minutes

Note: Increase in temperature will decrease pot life, as will leaving mixed material in a large mass. Spread out material in a thin layer as soon as possible after mixing.

Changes in colour and gloss can occur as the product reaches the end of its pot life. Ensure material is applied well before end of pot life (eg: within 20 minutes at 20°C.)

e) **Clean Up** - Mixing equipment, tools etc can be cleaned with Metz Cleaner, xylene, acetone or MEK prior to initial set.

Ensure you have the latest mixing instructions, refer [www.metz.net.au](http://www.metz.net.au) for most current data sheet version.

#### 4. Installation

(i) Metz Epoxy Primer - Apply to prepared surface using squeegee then back-roll with short nap roller. Ensure total area is covered and surface is completely sealed. Apply more primer if necessary to seal surface. Allow primer to dry, then inspect surface for voids. Fill any voids with Metz 33EN-Plaster. When using Metz 4HB-EN as a membrane, a special fabric is rolled onto the wet primer and flattened out to ensure that no voids exist in the coating.

(ii) Metz 4HB-EN - Spread mixed Metz 4HB-EN on primed surface using a squeegee. Finish by rolling with a short nap roller to obtain uniform coverage. Finished thickness should be 250 microns per coat. For vertical surface apply by roller to desired thickness.

When using Metz 4HB-EN as a membrane in critical areas, it is recommended that two full coats (finished thickness of 500 microns) be applied over the primer. The second coat should be applied before the first coat has fully set (see table below)

While the top coat is still wet, it should be evenly broadcast with Metz Broadcast Aggregate too provide a bonding surface for any subsequent topping. Prior to installing subsequent Metz materials ensure all loose aggregate particles, dust etc., are removed.

Recoat times at 20°C

Minimum: 2 hours

Maximum: 6 hours

#### 5. Setting/Curing:

Setting Time

at 20°C 6 hours

at 30°C 4 hours

at 40°C 3 hours

Full Cure

at 20°C 3 days

at 30°C 2 days

at 40°C 2 days

Do not allow water, chemicals or traffic on the material surface for a minimum of 24 hours. For harsh chemical or physical environments ensure full cure occurs.

#### 6. Storage

Store in original sealed containers in cool dry place. Under these conditions, minimum shelf life is 12 months.

#### 7. Safety Precautions

Liquid and Hardener - use Chemical goggles, PVC gloves and barrier cream. Avoid contact with skin and eyes. For full safety precautions refer to Material Safety Data Sheets for all components.

**Always ensure you have the latest data sheet version, refer [www.metz.net.au](http://www.metz.net.au)**

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**METZ SPECIALTY  
MATERIALS PTY LTD**

A.C.N. 140 636 639

15A Stanton Road, Seven Hills NSW 2147  
Facsimile: (02) 9671 4292 Phone: (02) 9671 1311

6 University Place, Clayton North, VIC 3168  
Facsimile: (03) 9561 6944 Phone: (03) 9561 6144

Unit 16, 42 Smith Street, Capalaba QLD 4157  
Facsimile: (07) 3823 5552 Phone: (07) 3823 5555

**Distributor**