# Technical Data MARATHON XHB



## Product description

Marathon XHB is a high solids, low VOC, high build, two-pack epoxy coating reinforced with glass flakes.

#### Recommended use

A high build, high solids coatings for steel subject to aggresive atmospheric or mechanical exposure. Offers extremely good protection against corrosion and has outstanding abrasion resistance.

## Film thickness and spreading rate

	Minimum	Maximum	Typical	
Film thickness, dry (μm)	400	1000	600	
Film thickness, wet (µm)	426	1065	640	
Theoretical spreading rate (m <sup>2</sup> /l)	2,35	0,94	1,56	

#### Physical properties

Colour Limited number

Solids (vol %)\*  $96 \pm 2$ 

Flash point  $40^{\circ}\text{C} \pm 2 \text{ (Setaflash)}$ 

Gloss
Gloss retention
Water resistance
Abrasion resistance
Solvent resistance
Chemical resistance
Flexibility
Glossy
Fair
Excellent
Excellent
Excellent
Fair

Compatibility with

cathodic protection Excellent

\*Measured according to ISO 3233:1998 (E)

## Surface preparation

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504.

#### Bare steel

Cleanliness: Blast cleaning to min. Sa 2  $\frac{1}{2}$  (ISO 8501 1:1988). Roughness: using abrasives suitable to achieve Grade Medium G (50 - 85  $\mu$ m, Ry5) (ISO 8503-2).

#### Coated surfaces

Clean, dry and undamaged compatible primer. Contact your local Jotun office for more information.

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Other surfaces

The coating may be used on other substrates. Please contact your local Jotun office for more information.

## Condition during application

The temperature of the substrate should be minimum 10°C and at least 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. Good ventilation is required in confined areas to ensure proper drying. The coating should not be exposed to oil, chemicals or mechanical stress until cured.

## Application methods

Use airless spray Spray

Brush Recommended for stripe coating and small areas, care must be taken to achieve the

specified dry film thickness.

## Application data

Mixing ratio (volume) 2 parts Comp. A (base) to be mixed thoroughly with 1 part Comp. B

(curing agent)

Pot life (23°C) 45 minutes (reduced at higher temperatures)

Thinner/Cleaner Jotun Thinner No. 17/( max 10%)

Guiding data airless spray

Pressure at nozzle

20 MPa (200 kp/cm<sup>2</sup>, 2800 psi) 0.63 - 1.09 mm (0.025-0.043") Nozzle tip

65 - 80° Spray angle

Filter Filters to be removed prior to spraying.

Note Thinning will prolong the drying & curing times

#### Drying time

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

- \* Good ventilation (Outdoor exposure or free circulation of air)
- Typical film thickness
- One coat on top of inert substrate

Substrate temperature	10°C	23°C	40°C
Surface dry	8 h	4 h	2 h
Through dry	20 h	10 h	4 h
Cured	14 d	7 d	3 d
Dry to recoat, minimum	20 h	10 h	4 h
Dry to recoat, maximum <sup>1</sup>	5 d	3 d	2 d

1. The surface should be free from chalking and contamination prior to application. If the maximum dry to recoat time is exceeded, please contact Jotun for advice.

MARATHON XHB Page 2 of 4 The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

## Typical paint system

On Sa 21/2:

Marathon XHB 1-2 X 600 μm (Dry Film Thickness)

For max mechanical strength, on Sa 21/2:

Marathon XHB (Dry Film Thickness) 1 X 1000 µm

Other systems may be specified, depending on area of use

#### Storage

The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed.

## Handling

Handle with care. Stir well before use.

#### Packing size

15 litre unit: 10 litres Comp. A (base) in a 20 litre container and 5 litres Comp. B (curing agent) in a 5 litre container

Packing may vary from country to country according to local requirements.

#### Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Material Safety Data Sheet.

#### **DISCLAIMER**

The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, we cannot quarantee anything but the quality of the product itself. We reserve the right to change the given data without notice.

Footer - English

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ISSUED 31 AUGUST 2005 BY JOTUN THIS DATA SHEET SUPERSEDES THOSE PREVIOUSLY ISSUED

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