

# Technical Data

## MARATHON XHB



### Product description

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

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### Recommended use

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

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### Film thickness and spreading rate

	Minimum	Maximum	Typical
Film thickness, dry ( $\mu\text{m}$ )	400	1000	600
Film thickness, wet ( $\mu\text{m}$ )	426	1065	640
Theoretical spreading rate ( $\text{m}^2/\text{l}$ )	2,35	0,94	1,56

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### Physical properties

Colour	Limited number
Solids (vol %)*	96 $\pm$ 2
Flash point	40°C $\pm$ 2 (Setaflash)
Gloss	Glossy
Gloss retention	Fair
Water resistance	Excellent
Abrasion resistance	Excellent
Solvent resistance	Excellent
Chemical resistance	Excellent
Flexibility	Fair
Compatibility with cathodic protection	Excellent

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

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### 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 ½ (ISO 8501 1:1988). Roughness: using abrasives suitable to achieve Grade Medium G (50 - 85  $\mu\text{m}$ , Ry5) (ISO 8503-2).

#### Coated surfaces

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

Other surfaces

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

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## 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.

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## Application methods

Spray Use airless spray

Brush Recommended for stripe coating and small areas, care must be taken to achieve the specified dry film thickness.

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## 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)

Nozzle tip 0.63 - 1.09 mm (0.025-0.043")

Spray angle 65 - 80°

Filter Filters to be removed prior to spraying.

Note Thinning will prolong the drying & curing times

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## 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.



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