



21-44

Hardener for Epoxy Primer

BIC-BEN® HARDENER

VERSION

Version 1
Date 20 December 2019

PHYSICAL PROPERTIES

Supply viscosity	20 – 24 sec. by Ford cup No.4 at 30 °C
Specific gravity	0.87 – 0.89 g/cm ³
Shelf life	1 Year Store in average temperature between 40 – 95 °F (5 – 35 °C). Avoid too much temperature fluctuation or direct contact with sunlight. Suitable storage temperature is 70 °F or 21°C

PRODUCT DESCRIPTION

21-44, hardener for Epoxy Primer. It's good reactivity with Epoxy resin to provide good appearance, high gloss, adhesion after completed reaction.

APPLICATION PARAMETERS

Mixing ratio	Part A [58 - line : Hardener : Thinner 4 : 1 : 5-15% By Volume Please see in Part A information.	
Part A	58-Line	
Reducer Thinner	86-145	
Spray viscosity	Ford cup No. 4	18-20 seconds
Pot life	4– 5 hr. at 25 °C	
Spray condition	Gravity feed	1.2 – 1.4 mm
	Air pressure	1.7 -2.2 bar
		28 – 30 psi HVLP max 0.6 – 0.7 bar (8-10 psi) at the air cap
Number of coats	2 coats	Dry film thickness 50-60 micron.

KEY CHARACTERISTICS

- Part B for Epoxy paint system
- Good adhesion
- Anti corrosion paint

PRECAUTION

Warning	For professional or trained applicator use only. Not for sale or use by the general public. before use, read and follow all TDS, label, and SDS precautions. Flammable product. Keep out reach of children. Always wear approved organic vapor goggle and safety mask when using product. Apply paint in good ventilating area.
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This product data sheet is intended to describe Big-Ben's product application. It should not be therefore be constructed as guarantee in any specific property of the product. We assume no liability in connection with its use.