



HB31

- *High solids, satin finish*
- *Offers smoothing qualities on rough surfaces*
- *Providing up to 8 years' service life*

AVAILABLE IN THESE COLORS



BLACK



WHITE



**OCEAN
BLUE**



**DAWN
BLUE**



**GLACIER
BLUE**

Note: Color differences may occur between actual color chips shown.

3:1 HIGH BUILD EPOXY

Ramuc® HB31 3:1 high building epoxy cures to a hard, tough, durable finish, providing stain, chemical and abrasion resistance for protection of concrete, plaster and fiberglass swimming pools, spas and slides.

This product cures to a satin finish with excellent coverage rates, especially on previously painted epoxy surfaces. Because of their chemical cure, epoxies are the paints of choice for indoor and outdoor pools.

HB31 Epoxy rolls or sprays easily up to 8 mils dry per coat rendering “smoothing” qualities on rough surfaces. Two coats offer up to 8 years’ service life and is a superior choice for spas.

TECHNICAL INFORMATION

VEHICLE TYPE: Epoxy Polyamide

FINISH: Satin

COMPONENTS: 2

POT LIFE: 3 hours

MIX RATIO: 3:1 by volume A:B

SOLIDS BY VOLUME: 65% ± 3%

SOLIDS BY WEIGHT: 80% ± 2%

COVERAGE: 150-200 sq.ft/gal. on bare, sandblasted or rough surfaces. 300-350 sq.ft./ gal kit on recoats

APPLICATION METHOD: Brush, no thicker than 3/8” non-shedding roller, airless or conventional spray.

NUMBER OF COATS: 2 (product is self-priming)

DRY FILM THICKNESS PER COAT: min 5 mils; 7.5 wet mils. Max 8 mils; 12.5 wet mils.

APPLICATION TEMP: 50°F Min / 90°F Max; surface and ambient

RECOAT TIME: 16-72 hours. After 72 hours, must sand before applying 2nd coat.

DRY TIME: Outdoor Pool: 507 days to fill pool
Indoor Pool: 10-14 days to fill pool

THINNER: Xylene



For compatibility purposes, the existing paint on previously painted surfaces of a pool or spa should be determined before painting. Aged plaster should be checked for integrity. Check for hollow or weak, crumbling plaster by using a ball-peen hammer or any other comparable method. Perform repairs to the plaster before painting.

JOINT AND CRACK FILLER: Plaster or concrete surfaces should be tested for integrity and soundness. Power wash the surface to remove loose paint and dirt. Should any minor repairs need to be made, such as hydraulic cement patch or crack joint filling, do them at this time. Do not use silicone-based products, as paint adhesion will be adversely affected. For compatibility purposes, the existing paint on previously painted surfaces of a pool or spa should be determined before painting. Aged plaster should be checked for integrity. Check for hollow or weak/crumbling plaster by using a ball-peen hammer or any other comparable method. Perform repairs on the plaster before painting.

SURFACE PREPARATION: Coating performance, in general, is proportional to the degree of surface preparation. Follow recommendations carefully, avoiding shortcuts. Inadequate preparation of surfaces will virtually assure inadequate coating performance. Scrub clean the entire pool surface to remove all dirt, oils and chalk. All surfaces should be acid etched with Ramuc Clean and Prep Solution to remove mineral deposits and to achieve a medium sandpaper grade finish on bare concrete or plaster surfaces. Neutralize/rinse with water. If surface is exceptionally hard, we recommend sanding with 60-80 grit sandpaper to create surface profile, prior to applying the first coat of Ramuc HB31 Epoxy Pool Paint. New concrete and plaster surfaces must be cured a minimum of 28 days prior to painting.

FOR PREVIOUSLY PAINTED EPOXY POOLS: You will need the following cleaning supplies: Tri-sodium phosphate (TSP) and muriatic or sulfamic acid solution; high pressure power washer with minimum 3000 p.s.i., turbo tip attachment, #80 grit sandpaper, a power sander, sanding block and a wire brush.

The existing epoxy must be cleaned with Ramuc Clean and Prep well, all residue removed, sand with 80 grit to create mechanical adhesion, remove all residue and then apply Ramuc HB31 Epoxy Pool Paint.

CONDENSATION TEST: After all cleaning is completed, allow the pool surface to dry. Average dry times vary regionally and are dependent upon the porosity of the surface. It is recommended to wait 5 dry sunny days then perform a condensation test to determine surface dryness.

- Tape 2'x2' pieces of transparent plastic to areas in the deep end wall, floor and several of the other areas of the pool.
- Wait about 4 hours to determine if condensation has formed underneath the plastic.
- If condensation is evident, the surface is not dry enough to paint.
- Remove the plastic and wait 24 hours to perform the test again and continue until no condensation forms. This ensures that the surface is dry enough to apply paint.

APPLICATION SYSTEMS: Use no thicker than a 3/8" nap roller for solvent based paints. DO NOT use rollers with cardboard cores. Apply at the recommended coverage rate. Ideal air temperatures for application are between 50°F, no more than 90°F. Overnight curing temperatures must be at least 50°F or the paint will not cure properly causing an "oily" feel to the top of the paint. Do not paint when rain is imminent.

MIXING THE PAINT: Ramuc HB31 Epoxy Pool Paint is self-priming; no other type of primer is recommended or should be used.

1. Mechanically mix Part A for approximately 5 minutes.
2. Mechanically mix Part B for approximately 5 minutes.
3. Mechanically mix both Part A and Part B together for approximately 15 minutes.

Mixing with a stir stick is not recommended. Ramuc HB31 Epoxy Pool Paint has a pot life (use life) of 8 hours. Once mixed, allow the material to stand at 65°F and above for 20 minutes. Allow to stand at 45 minutes at temperatures 50°F—65°F to ensure chemical reaction before using. If material is used too soon after mixing or if pool is filled too soon after application yellowing or loss of gloss can occur. If more than one gallon kit is used at a time, intermix several gallons together.
