



SAXON PB-06

DESCRIPTION

SAXON PB-06 is a high-performance, two-component novolac phenolic epoxy coating, formulated with a solvent-free system and cured with amine technology. It is designed to provide excellent chemical resistance, strong adhesion, and durable protection in demanding industrial environments, particularly where tanks, vessels, or steel surfaces are exposed to aggressive chemicals, fuels, or high-service conditions.

MAIN PROPERTIES

- 🌀 Single-coat coating system for tank interiors
- 🌀 Designed for application with heavy-duty, single-feed airless spray equipment, such as 60:1 pump
- 🌀 Excellent pit-filling properties, helping improve surface coverage and protection
- 🌀 Light-colored finish provides better visibility during inspection and maintenance
- 🌀 Easy-to-clean surface after service exposure
- 🌀 Excellent resistance to crude oil at temperatures up to 120°C / 250°F
- 🌀 Suitable for storing unleaded gasoline blends containing ethanol from E5 up to E100
- 🌀 Suitable for biodiesel storage in accordance with EN 14214
- 🌀 Provides strong chemical resistance against a broad range of chemicals and solvents
- 🌀 Helps reduce fire hazards and explosion risks during application and service
- 🌀 Complies with the requirements of EI 1541 Section 2.2 for coating systems used in aviation fuel storage tanks and pipelines

COLOUR AND PRODUCT PRESENTATION

Colour range

See Saxon Colour Chart (other colours available on request)

Size

10 litres - 20 litres

MAIN PROPERTIES

PREPARED MIXED PRODUCT	
Application	Roller and brush for stripe coating or spot repair only. Spray gun/machine for product application.
Touch Dry	2 to 4 hours depending on ambient conditions.
Recoatable	12 hours, drying times will be significantly longer in cold conditions.
Coverage	7 m ² per litre for 150 µm This numbers could be lower on highly porous surfaces.
Thinning	No thinner should be added.
Cleaning	Clean equipment immediately after use with white spirit.
Colours	Off-white & Light Grey (other colours available on request).
Shelf Life	Base: 24 months: if correctly stored to manufacturer's guidelines. Activator: 24 months: if correctly stored to manufacturer's guidelines.
Fully cured	5 days.
DFT	100 - 200 µm depending on system required.
Volume of Solids	100%





POT LIFE	
Mixed Product Temperature	Pot life
10°C (50°F)	2 hours
20°C (68°F)	1 hour
30°C (86°F)	45 minutes

CURING TIME FOR DFT 150 µm	
Substrate temperature	Dry to touch
5°C (41°F)	8 hours
10°C (50°F)	6 hours
20°C (68°F)	4 hours
30°C (86°F)	3 hours
40°C (104°F)	2 hours

OVERCOATING INTERVAL FOR DFT up to 150 µm						
Product	Interval	5°C (41°F)	10°C (50°F)	20°C (68°F)	30°C (86°F)	40°C (104°F)
Saxon PB-06	Minimum	24 hours	20 hours	8 hours	4 hours	2.5 hours
	Maximum	30 days	30 days	30 days	20 days	15 days

LIMITATIONS

During application and curing, the substrate temperature must be maintained above 5 °C (41 °F) and at least 3°C (5 °F) above the dew point to prevent condensation. The product shall be mixed by volume at a ratio of 75:25 (base to activator), equivalent to 3:1. For proper application, the paint temperature should preferably exceed 20° C (68° F). Thorough mechanical mixing of the base and activator is essential, and no thinners should be added to the mix.

Filters must be removed from the spray equipment prior to application.

Note: Do not use if the substrate is above 180 degrees Fahrenheit.

PREPARATION

This product requires proper surface preparation in accordance with conventional coating system requirements. Prior to application, the substrate must be sound, clean, dry, and free from oil, laitance, loose material, dust, or any other contaminants that may affect adhesion or performance. For steel surfaces, abrasive blast cleaning shall be carried out to a minimum standard of SSPC-SP10 or ISO Sa 2½, with a recommended surface profile of 50-125 µm / 2.0-5.0 mils. When applied over steel previously coated with a suitable primer, the primed surface must be fully dry, intact, and free from any contamination before





overcoating.

COATING SYSTEM APPLICATION

Stir well before and during use.

ROLLER



For spot repairs, touch-ups, and stripe coating, the product may be applied by roller directly from the container, ensuring the roller sleeve is fully loaded with material before application. Apply the coating in a controlled and systematic manner, focusing only on the affected areas, welds, edges, corners, bolts, seams, or other localized sections requiring additional protection. Work the material evenly into the surface to achieve full coverage and proper film build, blending the repair area into the surrounding coating while the material remains wet. Maintain a manageable wet edge during application to avoid visible lap marks and ensure a uniform finish.

BRUSH



For spot repairs, touch-ups, and stripe coating, the product may be applied by brush directly from the container. Before use, ensure the brush is clean and free from dust, loose bristles, or any contamination that could affect the coating finish. Load the brush by dipping up to approximately half the length of the bristles into the product, then gently tap off any excess material against the side of the container without wiping the brush aggressively. Apply the coating in a controlled and even manner, concentrating on localized areas such as welds, edges, corners, bolts, seams, or damaged sections requiring additional protection. Avoid excessive pressure during application; allow the material to flow from the brush to achieve proper coverage, film build, and adhesion. Blend the repaired or striped area into the surrounding coating while the material remains wet to obtain a uniform finish.

SPRAY



For spray application, use heavy-duty, single-feed airless spray equipment, preferably with a 60:1 pump ratio, suitable high-pressure hoses, and equipment capable of maintaining the required spray pressure throughout the application. The product should be applied without adding thinner. Use an approximate nozzle orifice of 0.53 mm / 0.021 in. At a paint temperature of 20°C / 68°F, the minimum recommended nozzle pressure is 28.0 MPa / 280 bar / 4,061 psi. At a paint temperature of 30°C / 86°F, the minimum recommended nozzle pressure is 22.0 MPa / 220 bar / 3,191 psi.

Before spraying, mask and protect all areas that are not intended to be coated





using suitable masking tape, paper, or protective film. Begin application from the upper sections and work downward, applying the coating with smooth, controlled, and overlapping spray passes while maintaining a consistent wet edge. Keep the spray gun at a uniform distance from the surface and apply the material evenly to achieve the required film build, coverage, and finish. For larger surfaces, apply in a systematic pattern using horizontal and vertical passes, or a crosshatch method where required, to obtain a full and uniform coating without missed areas, dry spray, or excessive build-up. The spray tip should be checked and cleaned regularly during application to prevent blockage and maintain a consistent spray pattern.

Other spray equipment or application methods may be suitable depending on site conditions; however, Saxon Technical Support should be consulted when alternative equipment is proposed.

CLEANING

Return excess material/paint to container. Wash and clean using solvents or thinner immediately after use. All application tools and spray equipment should be cleaned thoroughly immediately after use to prevent material build-up or curing inside the system. Any mixed coating remaining inside the spray unit, hoses, gun, or related equipment must be flushed out before the product reaches the end of its pot life.

HEALTH AND SAFETY RECOMMENDATIONS

Please refer to the Safety, Health and Environmental Information on the container. When preparing the surfaces avoid the inhalation of dust and/or metal particles. Wear a suitable facemask and recommended safety personal protection. Material Safety Data Sheets for this is available freely available at Saxon Paints website.

STORAGE

Store in secure dry conditions. Keep out of reach of children. Containers should be kept closed during storage. Do not empty into drains, water rivers or access routes to septic drums.

For further information contact Saxon Paints

GENERAL INFORMATION

Apply all products in accordance with BS 6150: 2006 Code of practice for painting of buildings and BS 8000:



Part 12: 1989 Code of practice for decorative wallcoverings and painting.

Every care is taken to ensure that all information provided on this Technical Data Sheet is accurate. Results cannot be guaranteed by the manufacturer as it has no control over the conditions under which its products are applied.

For help or more information contact Saxon Paints or visit our website at www.saxonpaints.com Before using this product please ensure you have the latest information. The information is correct at date of issue May 2021.

WARRANTY

SAXON PAINTS warrant its title to the product, that the quality of the product conforms to Saxon Paints' specifications for such product in effect at the time of manufacture and that the product shall be delivered free of the rightful claim of any third person for infringement of any patent covering the product. This product is for professional use only. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the paints correctly and according to Saxon Paints' technical documentation. Applicators and operators shall use appropriate personal protection equipment when using this product. This guideline is given based on the current knowledge of the product. These are the only warranties that Saxon Paints makes and all other express or implied warranties, under statute or arising otherwise in law, from a course of dealing or usage of trade, including without limitation, any other warranty of fitness for a particular purpose or use, are disclaimed by Saxon Paints. Any claim under this warranty must be made by Buyer to Saxon Paints in writing within five (5) days of Buyer's discovery of the claimed defect, but in no event later than the expiration of the applicable shelf life of the product, or one year from the date of the delivery of the product to the Buyer, whichever is earlier. Buyer's failure to notify Saxon Paints of such non-conformance as required herein shall bar Buyer from recovery under this warranty Any suggested deviation to suit the site conditions shall be forwarded to the responsible Saxon Paints' representative for approval before commencing the work.

LIMITATIONS OF LIABILITY

The information in this document is given to the best of Saxon Paints' knowledge. The information in this sheet is intended for guidance only and is based upon laboratory tests that Saxon Paints' believes to be reliable. Saxon Paints' products are considered as semi-finished goods and as such, products are often used under conditions beyond Saxon Paints' control like the quality or condition of the substrate, or the many factors affecting the use and application of the product. The product and related information are designed for users having the requisite knowledge and industrial skills in the industry and it is the end-user's responsibility to determine the suitability of the product for its own particular use and it shall be deemed that Buyer has done so, as its sole discretion and risk. Saxon Paints' does not accept any liability arising from any loss, injury or damage resulting from such use or the contents of this information. Variations in the application environment, changes in procedures of use, or extrapolation of data may cause unsatisfactory results. Minor product variations may be implemented to comply with local requirements. Users should always consult Saxon Paints' for specific guidance on the general suitability of this product for their needs and specific application practices. If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail

