

PRODUCT DESCRIPTION

Epoxy Mastic Primer is a two-pack epoxy polyamide coating, specifically designed as a self-priming, surface tolerant paint system or as an intermediate coat in heavy duty paint system where low VOC and high film build are required. Lead and chromate-free.

INTENDED USE

It is designed to be used on all steel structures.

GENERAL PROPERTIES

Colour	: Orange
Gloss Level	: Low-Gloss
Volume Solid	: 80 ± 2 %
Specific Gravity	: 1.40 – 1.50 kg/l (Mixed)
Flash Point	: Base: 7 °C Hardener: 23 °C Mix: 7 °C
VOC	: 210 g/L (EPA Method 24)
Typical Thickness	: 100 – 200 µm dry film 125 – 250 µm wet film

SURFACE PREPARATION

All surfaces should be clean dry, and free from contamination. The surface should be assessed and treated in accordance with ISO 8504. Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Abrasive Blast Cleaning

For optimum performance, abrasive blast clean to Sa 2½ (ISO 8501-1) or SSPC-SP10 with a surface profile of 50 – 75 microns (2 – 3 mils). If oxidation has occurred between the blasting and application of this product, the surface should be re-blasted to the specified visual standard. Surface defect revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner.

Damaged Area

Damage area should be prepared with abrasive blast cleaning to Sa 2½ (ISO 8501-1) or SSPC-SP10. When abrasive blasting is not possible, mechanical cleaning to St3 (ISO 8501-1) or SSPC-SP3 is acceptable. Epoxy Mastic Primer should be applied over a surface that is dry and free from all contamination.

Other Surfaces

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

**CONDITION DURING
APPLICATION**

Avoid paint application when the temperature is below 10 °C and relative humidity is above 85 %. The temperature of steel surface must be minimum 3 °C above dew point of surrounding air.

APPLICATION GUIDE

Mixing Ratio	:	BASE	:	HARDENER	
		4	:	1	(by volume)
		Base and hardener should be mixed thoroughly before use with a mechanical agitator			
Pot Life	:	<u>25 °C</u>			
		4 hrs			
		(Pot life will vary substantially with temperature)			
Theoretical Coverage	:	8.0 m ² /litre at 100 µm DFT			
		4.0 m ² /litre at 200 µm DFT			
Thinner	:	Hi-Pon Epoxy Thinner			
Cleaner	:	Hi-Pon Epoxy Thinner			

APPLICATION METHOD

Airless spray is recommended for application. Brush is recommended for stripe coating and small areas. Care must be taken to achieve the specified dry film thickness.

APPLICATION DETAILS

Airless Spray	:	Tip Size	:	0.018" – 0.027"	
		Pressure at nozzle	:	140 - 170 bar	
Drying Time	:	Substrate Temperature		<u>25 °C</u>	<u>35 °C</u>
		Surface Dry		3 hr	1 hr
		Through Dry		8 hr	4 hr
		Cured		7 days	7 days
		Dry to Overcoat (min)		8 hr	4 hr
		Dry to Overcoat (max)		7 days	7 days

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.

**RECOMMENDED
COATING SYSTEM**

The following topcoats are recommended for Epoxy Mastic Primer:

Top Coat:

- Hi-Pon 40-04 Epoxy Top Coat
- Hi-Pon 50-01 Polyurethane Top Coat

For the choice of coating system for different application, refer to the product brochure or contact Nippon Paint for professional recommendation.

PACKAGING

Unit	Base		Hardener	
	Volume	Container Size	Volume	Container Size
5 L	4 L	5 L	1 L	1 L
20 L	16 L	20 L	4 L	5 L

STORAGE

Shelf Life Base : 12 months (25 °C) minimum
 Hardener : 12 months (25 °C) minimum

Subject to re-inspection thereafter. Higher temperature during storage may reduce the shelf life and may lead to gelling in the tin.

Store in tightly closed container in a dry, cool and well-ventilated space, keep away from sources of heat and ignition.

SAFETY PRECAUTION

- This product is intended for use of professional applicators. Refer to the safety information display on the container and in the safety data sheet (SDS) before using the product.
- Use this product in well-ventilated area, avoid skin contact, spillage on the skin should immediately be removed with suitable cleanser, soap and water.
- Eye should be well flush with water and seek for medical attention immediately upon contact with this product.
- During the application, naked flame, welding operation and smoking is not allowed. Adequate ventilation should be provided.
- If you have any doubt regarding the suitability of use, refer to Nippon Paint for further advice.

DISCLAIMER

The information in this data sheet is given to the best of Nippon Paint's knowledge and practical experience. Users may consult with Nippon Paint on the general suitability of the product for their needs and specific application practices though it remains each user's responsibility to determine the suitability of the product for the user's particular use. The condition of the substrate and application are not within Nippon Paint's control. Therefore, no implied conditions, warranties or other terms will apply to the Product. Nippon Paint does not and cannot warrant the results which the user may obtain by using the product. In no event will Nippon Paint be liable to the user for any kind of loss (whether direct or indirect) even if Nippon Paint was previously advised of it. In line with Nippon Paint's policy for continuous development, Nippon Paint reserves the right to modify the product and the information in this data sheet without prior notice. It is the user's responsibility to check with Nippon Paint for the latest version of this

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In the event of any inconsistency, the English version shall prevail.