Hi-Pon 80-03 Epoxy Phenolic Primer is a two-pack epoxy phenolic coating for blast cleaned steel surfaces. Its wide range of chemical resistance properties has made it a durable, high performance coating for steelwork and concrete surface with immersion as well as non-immersion services.

It is designed for long-term corrosion protection lining of storage tank for a wide range of chemicals, solvents, crude oil, aggressive palm oil and vegetable oil derivatives.

**Colour**: Red Oxide  
**Gloss Level**: Matt  
**Volume Solids, %**: 65 ± 2%  
**Specific Gravity**: 1.40 kg/l (Mixed)  
**Flash point**: Base: 13.3°C Hardener: 35°C Mix: 13.3°C  
**VOC**: 357 g/L (EPA Method 24)  
**Typical Thickness**: 100 – 200 um dry film  
****: 155 – 310 um wet film

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

**Abrasive Blast Cleaning**  
Abrasive blast cleaning to Sa 2½ (ISO 8501-1:2007). For optimum performance, blast cleaned to 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.

**Shop Primer Surface**  
This product is suitable for application to the unweathered steelwork freshly coated with zinc silicate shop primers. If the zinc shop primer shows extensive or widely scattered breakdown or excessive zinc corrosion, overall sweep blasting will be necessary. Other types of shop primer are not suitable for over coating and will required complete removal by abrasive blast cleaning. Weld seams and damaged areas should be blast cleaned to Sa 2½ (ISO 8501-1:2007).

**Damaged Area**  
Damage area should be prepared with abrasive blast cleaning to Sa 2½ (ISO
HI-PON 80-03 EPOXY PHENOLIC PRIMER

TECHNICAL DATA SHEET

8501-1:2007). When abrasive blasting is not possible, mechanical cleaning to St 3 (ISO 8501-1:2007) is acceptable. After the surface preparation, repair the damaged area using Hi-Pon 80-03.

Hi-Pon 80-03 Epoxy Phenolic Primer should be applied over a surface that is dry and free from dirt, grease, oil and other contaminants and must be applied within the overcoating intervals specified (refer to application section for details).

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 over 85%. The temperature of steel surface must be a minimum 3°C above dew point of surrounding air. Ensure proper ventilation to have air movement to remove solvent.

APPLICATION GUIDE

Mixing Ratio
Base : Hardener = 6 : 1 (by volume)
Base and hardener should be mixed thoroughly before use.

Pot Life
: 25°C
4 hours

Theoretical Coverage
: 6.5 m²/litre at 100 µm DFT
3.2 m²/litre at 200 µm DFT

Thinner
: Hi-Pon Epoxy Thinner

APPLICATION METHOD
Airless spray is recommended for application. Brush and roller are 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" – 0.026"
Pressure at nozzle
140 – 170 kg/cm²

Typical Thickness
: 100 – 200 µm dry film
155 – 310 µm wet film

Drying Time
: Substrate Temperature
25°C
40°C
Surface Dry
30 mins
20 mins
Through Dry
4 hrs
3 hrs
Cured
7 days
3 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 PAINTING SYSTEM

The following coating system is recommended for Hi-Pon 80-03 Epoxy Phenolic Primer:

Topcoat

- Hi-Pon 80-04 Epoxy Phenolic Top Coat

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

PACKAGING

<table>
<thead>
<tr>
<th>Unit</th>
<th>Base Vol</th>
<th>Container Size</th>
<th>Hardener Vol</th>
<th>Container Size</th>
</tr>
</thead>
<tbody>
<tr>
<td>5 L</td>
<td>4.3 L</td>
<td>5 L</td>
<td>0.7 L</td>
<td>1 L</td>
</tr>
<tr>
<td>20 L</td>
<td>17.2 L</td>
<td>20 L</td>
<td>2.8 L</td>
<td>5 L</td>
</tr>
</tbody>
</table>

STORAGE

Shelf life: Part A: 12 months (25°C)
Part B: 12 months (25°C)

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

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.
HI-PON 80-03 EPOXY PHENOLIC PRIMER

TECHNICAL DATA SHEET

- 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 data sheet. This data sheet has been translated into various languages. In the event of any inconsistency, the English version shall prevail.