



# HI-PON 80-08 NOVOLAC VINYL ESTER GF

TECHNICAL DATA SHEET

## PRODUCT DESCRIPTION

**Hi-Pon 80-08 Novolac Vinyl Ester GF** is a two-pack, high build and chemical resistant novolac vinyl ester coating, reinforced with glass flakes. Suitable for properly prepared carbon steel and concrete substrates in atmospheric and immersed environments.

## INTENDED USE

It is designed for use in the internal lining of chemical storage tanks and pipes, and for structural steelwork in environments where superior resistance to chemical attack is required. Suitable for use in most aggressive environments. Excellent resistance in both aliphatic and aromatic organic solvents, and concentrated organic and inorganic acids.

## GENERAL PROPERTIES

<b>Colour</b>	: Off-White & Grey
<b>Gloss Level</b>	: Semi Gloss
<b>Volume Solids, %</b>	: 100 % Reactive (~ 85 % of contents are convertible to solid)
<b>Specific Gravity</b>	: 1.27 kg/l (Mixed)
<b>Flash point</b>	: Base: 32°C Hardener: 57°C Mix: 32°C
<b>VOC</b>	: 245 g/L (EPA Method 24)
<b>Typical Thickness</b>	: 400 – 600 µm dry film : 471 – 706 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

Abrasive blast cleaning to Sa 2½ (ISO 8501-1:2007) or SSPC-SP6. For optimum performance, blast cleaned to SSPC-SP10 with a surface profile of 75 – 100 microns (3 – 4 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.

### 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 80%.



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The temperature of steel surface must be minimum 3°C above dew point of surrounding air. When surface temperatures exceed 35°C, Hi-Pon 80-08 should be overcoated as soon as hard dry to avoid intercoat adhesion problems.

### APPLICATION GUIDE

<b>Mixing Ratio</b>	: Base : hardener = 50.3 : 1 (by volume) Base and hardener should be mixed thorough before use.
<b>Pot Life</b>	: 25°C                      35°C 55 minutes                  25 minutes (Pot life will vary substantially with temperature)
<b>Theoretical Coverage</b>	: 1.70 m <sup>2</sup> /litre at 500 µm DFT
<b>Thinner</b>	: Do not thin
<b>Cleaner</b>	: Hi-Pon Vinyl Ester 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

<b>Airless Spray</b>	: Tip Size                      : 0.036" – 0.048" Pressure at nozzle            : > 220 kg/cm <sup>2</sup>
<b>Typical Thickness</b>	: 500 – 600 µm dry film : 588 – 706 µm wet film
<b>Drying Time</b>	: Substrate Temperature    25 °C            35 °C Surface Dry                    2 hours        1.5 hours Through Dry                   5 hours        3 hours Cured *                        5 days        3 days Dry to recoat (min)*        5 hours        3 hours Dry to recoat (max)*        5 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.



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## RECOMMENDED PAINTING SYSTEM

The following paint system is recommended for Hi-Pon 80-08 Novolac Vinyl Ester GF:

Hi-Pon 80-08 is normally applied directly to steel, however, it can also be applied over the following primers.

### Primer:

- Hi-Pon 80-07 Novolac Vinyl Ester Primer

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	
	Vol	Container Size	Vol	Container Size
20L	19.61 L	20 L	0.39 L	5 L

## STORAGE

**Shelf life** : Part A: 5 months (20°C) minimum  
Part B: 5 months (20°C) minimum

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. Recommended storage temperature range is 10°C - 15°C to prolong shelf life for Base only. Best practice would be to store Part A and Part B in separate locations.

## 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.



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## DISCLAIMER

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