

**PRODUCT DESCRIPTION**

**Hi-Pon 90-08 Epoxy Ultra HB** is a two-pack, ultra-high build, high solids epoxy coating. It can be applied up to 3000 microns (120 mils) dry film thickness. It has excellent corrosion, impact and abrasion resistance. Suitable for properly prepared carbon steel, shop primed steel and concrete in atmospheric and immersed environments.

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**INTENDED USE**

It is designed for use in highly corrosive environments, such as areas in offshore environments, ship loading facilities, jetties, decks, refineries, chemical plants, power plants, bridges, water treatment plants, mining equipments and general structural steels. Compatible with cathodic protection systems.

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**GENERAL PROPERTIES**

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| <b>Colour</b>            | : Off-White & Grey                                   |
| <b>Gloss Level</b>       | : Low-Gloss  |
| <b>Volume Solid</b>      | : 98 ± 3 %   |
| <b>Specific Gravity</b>  | : 1.08 ± 0.05 kg/l (Mixed)                           |
| <b>Flash Point</b>       | : Base: -3 °C Hardener: 23 °C Mix: -3 °C             |
| <b>VOC</b>               | : 35 g/L (EPA Method 24)                             |
| <b>Typical Thickness</b> | : 1000 – 3000 µm dry film<br>1020 – 3062 µm wet film |

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**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.

Shop Primed Surface

This product is suitable for application to the unweathered steelwork freshly coated with approved shop primers. 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) or SSPC-SP10, to achieve surface profile 50 – 75 µm.

Concrete Substrates

New concrete shall be properly cured prior to coating application. All

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surfaces should be clean and free from laitance, curing compounds, release agents, efflorescence, grease, oil, dirt, organic growth, old coatings and loose or disintegrating concrete. Surface preparation should be done in accordance to SSPC-SP13 / NACE No. 6. A suitable primer or sealer is required prior to coating application.

#### 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** : 25 °C  
45 mins

**Theoretical Coverage** : 0.98 m<sup>2</sup>/litre at 1000 µm DFT  
0.33 m<sup>2</sup>/litre at 3000 µm DFT

**Thinner** : Hi-Pon Epoxy Thinner

**Cleaner** : 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 : 0.030" – 0.045"  
Pressure at nozzle : > 280 bar

**Drying Time** : Substrate Temperature 25 °C 40 °C  
Surface Dry 4.5 hrs 2.2 hrs  
Through Dry 24 hrs 12 hrs  
Cured 7 days 4 days  
Dry to Overcoat (min) 24 hrs 12 hrs  
Dry to Overcoat (max) 7 days 4 days

**Remarks:** For high film thickness of > 2000 µm (80 mils) apply in two coats to minimise rough surface texture and indentations.

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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**HEAT RESISTANCE****Dry, Atmospheric**

- Continuous : 80 °C
- Minimum : - 40 °C
- Intermittent : 100 °C

**Wet, Immersed**

- Fresh Water : 50 °C

Intermittent temperature duration – 1 hour maximum

The temperatures listed relate to retention of protective properties. Aesthetic properties may suffer at these temperatures. Heat resistance is influenced by the total coating system. If used as part of a system, ensure all coatings in the system have similar heat resistance.

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**RECOMMENDED  
COATING SYSTEM**

Hi-Pon 90-08 is normally applied directly to steel; however, it can also be applied over the following primers:

**Shop Primer:**

- Zinky-10 Inorganic Zinc Shop Primer

**Primer:**

- Hi-Pon 20-03 Epoxy Red Oxide Primer
- Hi-Pon 20-04 STE IM 80
- Hi-Pon 20-10 Epoxy Zinc Phosphate 63

**Top Coat:**

- Hi-Pon 40-04 Epoxy Top Coat
- Hi-Pon 50-01 AS Polyurethane Top Coat
- Hi-Pon 50-03 Polyurethane Top Coat
- Hi-Pon 50-07 Polysiloxane Top Coat

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

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**PACKAGING**

| <u>Unit</u> | <u>Base</u>   |                       | <u>Hardener</u> |                       |
|-------------|---------------|-----------------------|-----------------|-----------------------|
|             | <u>Volume</u> | <u>Container Size</u> | <u>Volume</u>   | <u>Container Size</u> |
| 20 L        | 16 L          | 20 L                  | 4 L             | 5 L                   |

**STORAGE**

**Shelf Life**      Base : 12 months (25 °C)  
                         Hardener : 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.
- 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

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