



NIIPPON EPOXY MASTIC PRIMER

TECHNICAL DATA SHEET

PRODUCT DESCRIPTION

Nippon 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.

INTENDED USE

It is designed to be used on all steel structure.

GENERAL PROPERTIES

Colour	: Orange & Grey
Gloss Level	: Low-gloss
Volume Solids, %	: 80 ± 2 %
Specific Gravity	: 1.40 - 1.50 kg/l (Mixed)
Flash point	: Base: 27°C Hardener: 27°C Mix: 27°C
VOC	: 210 g/L (mix, by calculation)
Typical Thickness	: 100 - 200µm dry film : 125 - 250µm wet film

SURFACE PREPARATION

All surfaces should be clean 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). 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 8501-1:2007). When abrasive blasting in small area is not possible, mechanical cleaning to St 3 (ISO 8501-1:2007) is acceptable. After the surface preparation, the application of Nippon Epoxy Mastic Primer can be performed.

Nippon Epoxy Mastic Primer should be applied over a surface that is dry and free from all contamination 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.



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TECHNICAL DATA SHEET

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. void paint application when the temperature is below 10°C.

APPLICATION GUIDE

Mixing Ratio	: Base: hardener = 4:1 (by volume) Base and hardener should be mixed thoroughly before use.
Pot Life	: 25°C 4 Hrs
Theoretical Coverage	: 5.3 m ² /litre at 150µm DFT
Thinner	: Hi-Pon Epoxy Thinner

APPLICATION METHOD

Brush and roll is suitable for stripe coating and very small areas. For best result, use airless spray. 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 kg/cm ²	
	Spray Angle	: 60 - 70°	
Typical Thickness	: 100 - 200µm dry film		
	: 125 - 250µm wet film		
Drying Time	: Substrate Temperature	: 25°C	40°C
	Surface Dry	: 3hr	1hrs
	Through Dry	: 8hrs	4hrs
	Cured	: 7days	7days
	Dry to recoat (min)	: 8hrs	4hrs

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 Topcoats are recommended for Nippon Epoxy Mastic Primer:

Topcoat



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TECHNICAL DATA SHEET

- 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	
	Vol	Container Size	Vol	Container Size
5L	4L	5L	1L	1L
20L	16L	20L	4L	5L

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.

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



NIIPPON EPOXY MASTIC PRIMER

TECHNICAL DATA SHEET

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