



# HI-PON 40-02 EPOXY TOP COAT

TECHNICAL DATA SHEET

## PRODUCT DESCRIPTION

**Hi-Pon 40-02 Epoxy Top Coat** is a two-pack amine-adduct cured epoxy finish coat specially developed to achieve long-term corrosion protection for many type of surfaces i.e. aluminium, galvanising, concrete and mild steel. This feature combined with its wide range of resistance properties make Hi-Pon 40-02 a durable, high performance and economical coating for non-immersion as well as immersion services.

## INTENDED USE

It is extensively used as a durable, high performance and economical coating for non-immersion as well as immersion service. For immersion service, it has been extensively used for long term corrosion protection lining of storage tank for palm oil derivatives, vegetable oil, portable water and etc.

## GENERAL PROPERTIES

<b>Colour</b>	: White and Limited colours
<b>Gloss Level</b>	: Low-Gloss
<b>Volume Solids, %</b>	: 55 ± 2 %
<b>Specific Gravity</b>	: 1.25 - 1.38 kg/l (Mixed) depending on colours
<b>Flash point</b>	: Base: 7°C Hardener: 23°C Mix: 7°C
<b>VOC</b>	: 474 g/L (EPA Method 24)
<b>Typical Thickness</b>	: 80 – 150 µm dry film : 150 – 275 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.

### Damaged Area

Damage area should be prepared with abrasive blast cleaning to Sa 2½ (ISO 8501-1:2007). When abrasive blasting is not possible, mechanical cleaning to St 3 (ISO 8501-1:2007) is acceptable. After the surface preparation, patch primer prior to the application of Hi-Pon 40-02 Epoxy Top Coat.

Hi-Pon 40-02 Epoxy Top Coat should always be applied over a recommended anti-corrosive coating scheme for metal surface. The primer surface should be dry and free from all contamination and Hi-Pon 40-02 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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### 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.

### APPLICATION GUIDE

<b>Mixing Ratio</b>	: Base : Hardener = 9 : 1 (by volume) Base and hardener should be mixed thoroughly before use.
<b>Pot Life</b>	: 25°C 5 hours
<b>Theoretical Coverage</b>	: 6.8 m <sup>2</sup> /litre at 80 µm DFT 3.6 m <sup>2</sup> /litre at 80 µm DFT
<b>Thinner</b>	: 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

<b>Airless Spray</b>	: Tip Size	: 0.015" – 0.023"
	: Pressure at nozzle	: 140 – 170 kg/cm <sup>2</sup>
<b>Typical Thickness</b>	: 80 – 150 µm dry film	
	: 150 – 275 µm wet film	
<b>Drying Time</b>	: Substrate Temperature	: 25°C      40°C
	Surface Dry	: 1.5 hrs    0.5 hrs
	Through Dry	: 7 hrs      3 hrs
	Cured	: 7 days     3 days
	Dry to recoat (min)	: 7 hrs      3 hrs
	Dry to recoat (max)	: 30 days    14 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 Primers/Intermediates are recommended for Hi-Pon 40-02 Epoxy Top Coat:

### Primer

- Zinky-12 Inorganic Zinc Rich Primer 77
- Zinky-13 Inorganic Zinc Rich Primer 85
- Zinky-21 Epoxy Zinc Rich Primer 77
- Zinky-22 Epoxy Zinc Rich Primer 80
- Hi-Pon 20-01 Epoxy Primer
- Hi-Pon 20-03 Epoxy Red Oxide Primer
- Hi-Pon 20-04 STE 80
- Hi-Pon 20-04 STE IM 80
- Hi-Pon 20-07 Epoxy Zinc Phosphate 70
- Hi-Pon 20-10 Epoxy Zinc Phosphate 63

### Intermediate

- Hi-Pon 20-04 STE 80
- Hi-Pon 20-04 STE IM 80
- Hi-Pon 30-02 Epoxy MIO 80
- Hi-Pon 30-03 Epoxy Midcoat 80
- Hi-Pon 40-02 Epoxy 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
5 L	4.5 L	5 L	0.5 L	1 L
20 L	18 L	20 L	2 L	5 L

## 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.



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## 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

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