



HI-PON 90-02 EPOXY GLASS FLAKE 80

TECHNICAL DATA SHEET

PRODUCT DESCRIPTION

Hi-Pon 90-02 Epoxy Glass Flake 80 is a two-pack surface tolerant epoxy cycloaliphatic amine glass flake coating, provides a high build barrier coating that gives excellent adhesion and surface wetting properties on manually prepared, rusty steelwork and steel surfaces that cannot be abrasive blast cleaned and hydroblasted.

INTENDED USE

It can be used either as a high build primer or a self-priming high build finish under immersion as well as nonimmersion services, for bridges, tanks and other steel structures used in severe corrosive environments, or pipelines, equipments, machinery and steel structures in chemical factory and power plant.

GENERAL PROPERTIES

Colour	: Grey
Gloss Level	: Matt
Volume Solids, %	: 80 ± 3 %
Specific Gravity	: 1.51 kg/l (Mixed)
Flash point	: Base: 65°C Hardener: 96°C Mix: 76°C
VOC	: 171 g/L (mix, by calculation)
Typical Thickness	: 200 - 300µm dry film : 250 - 375µm wet film

SURFACE PREPARATION

For best result 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.

Bare steel

Bare steel should be prepared with power tool cleaning to min. St2, mill scale free (ISO 8501-1:2007). For optimum performance, to improve surface treatment with abrasive blast cleaning to SA 2½. Surface profile of 50 - 85µm is recommended.

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 90-02.

Other Surfaces

The coating may be used on other substrates. Please contact your local Nippon Paint office for more information.



HI-PON 90-02 EPOXY GLASS FLAKE 80

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.

APPLICATION GUIDE

Mixing Ratio	: Base: hardener = 6:1 (by volume) Base and hardener should be mixed thoroughly before use.
Pot Life	: 25°C 2 - 3 Hrs
Theoretical Coverage	: 4.0 m ² /litre at 200µm DFT 2.7 m ² /litre at 300µm 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	: 0.019" – 0.035"
	: Pressure at nozzle	: 140 – 170 kg/cm ²

Filters should be removed from spray equipment prior to spraying

Typical Thickness	: 200 - 300µm dry film : 250 - 375µm wet film		
Drying Time	: Substrate Temperature	: 25°C	40°C
	Surface Dry	: 1.0hrs	0.5hrs
	Through Dry	: 6hrs	3hrs
	Cured	: 7days	3days
	Dry to recoat (min)	: 16hrs	7hrs
	Dry to recoat (max)	: 7days	3days

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



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TECHNICAL DATA SHEET

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 paint system is recommended for Hi-Pon 90-02:

Intermediate/Topcoat

Hi-Pon 90-02 Epoxy Glass Flake 80

For the choice of coating system for different application, contact Nippon Paint for professional recommendation.

PACKAGING

Unit	Base		Hardener	
	Vol	Container Size	Vol	Container Size
5L	4.3L	5L	0.7L	1.0L
20L	17.2L	20L	2.8L	5.0L

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



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TECHNICAL DATA SHEET

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