HI-PON 20-07 EPOXY ZINC PHOSPHATE 70

TECHNICAL DATA SHEET

PRODUCT DESCRIPTION

Hi-Pon 20-07 Epoxy Zinc Phosphate 70 Two-pack high build, fast drying zinc phosphate epoxy coating.

INTENDED USE

Universal anti-corrosive for all areas according to ISO 12944.

An anti-corrosive primer and / or intermediate coating for corrosion protection of steel and other substrates in atmospheric exposure.

GENERAL PROPERTIES

Colour	: Buff & Red
Gloss Level	: Low sheen
Volume Solids, %	: 72 ± 2 %
Specific Gravity	: 1.46 - 1.56 kg/l (Mixed)
Flash point	: Base: 33°C Hardener: 35°C Mix: 33°C
VOC	: 260 g/L (mix, by calculation)
Typical Thickness	: 100 - 250µm dry film
	: 140 - 360µm 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.

Bare steel

Bare steel should be prepared with abrasive blast cleaning to Sa 2½ (ISO 8501-1:2007), to achieve surface profile 50 – 70 µm.

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 or relative humidity exceeds 85%. The Steel surface temperature must be minimum 3°C above dew point of the surrounding air.

APPLICATION GUIDE

Mixing Ratio	: Base: hardener = 4:1 (by volume) Base and hardener should be mixed thoroughly before use.
Induction time	: 15mins
Pot Life	: 25°C

2 Hrs

Theoretical Coverage : 7.2 m^2/litre at 100 µm DFT
: 2.9 m^2/litre at 250 µm 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 : 0.017" – 0.027"
Pressure at nozzle : 150 - 170 kg/cm^2

Typical Thickness : 100 - 250µm dry film
: 140 - 360µm wet film

Drying Time :

Substrate Temperature	: 25°C	40°C
Surface Dry	: 1hrs	0.5hrs
Through Dry	: 3hrs	2hrs
Cured	: 7days	3days
Dry to recoat (min)	: 3hrs	2hrs
Dry to recoat (max)	: 3mths	3mths

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 Intermediate/Topcoat are recommended for Hi-Pon 20-07:

Intermediate

- Hi-Pon 20-04 STE 80
- Hi-Pon 20-04 STE AL 80
- Hi-Pon 20-04 STE GF 80
- Hi-Pon 20-04 STE MIO 80
- Hi-Pon 30-01 Epoxy Midcoat 70
- Hi-Pon 30-02 Epoxy MIO 80
- Hi-Pon 30-03 Epoxy Midcoat 80
- Hi-Pon 30-04 Epoxy MIO 70

Topcoat

- Hi-Pon 40-02 Epoxy Topcoat
- Hi-Pon 40-04 Epoxy Topcoat
- Hi-Pon 50-01 Polyurethane Topcoat

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	16L	20L	4L	5L
5L	4L	5L	1L	1L

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 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 version of this data sheet. This data sheet has been translated into various languages. In the event of any inconsistency, the English version shall prevail.