

**PRODUCT DESCRIPTION**

**Hi-Pon 80-04 Epoxy Phenolic Top Coat** is a two-pack epoxy phenolic coating for blast cleaned and primed steel surfaces. Its wide range of chemical resistance properties has made it a durable, high performance coating for steelwork and concrete surface with immersion as well as non-immersion services.

**INTENDED USE**

It is designed for long-term corrosion protection lining of storage tank for a wide range of chemicals, solvents, crude oil, aggressive palm oil and vegetable oil derivatives.

- Certified to BS 6920 for contact with potable water
- Tested in accordance with EI Standard 1541, Section 2.2 and 3 for Aviation Fuel Storage Tanks and Piping
- Tested in accordance with Defence Standard 80-97 Issue 5 Annex B

**GENERAL PROPERTIES**

|                          |  |
|--------------------------|--|
| <b>Colour</b>            | : Off-White & Grey                               |
| <b>Gloss Level</b>       | : Matt   |
| <b>Volume Solid</b>      | : 65 ± 2 %                                       |
| <b>Specific Gravity</b>  | : 1.47 ± 0.05 kg/l (Mixed)                       |
| <b>Flash Point</b>       | : Base: 13.3 °C Hardener: 35 °C Mix: 13.3 °C     |
| <b>VOC</b>               | : 290 g/L (EPA Method 24)                        |
| <b>Typical Thickness</b> | : 100 – 200 µm dry film<br>154 – 308 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.

**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.

**Damaged Area**

Damage area should be prepared with abrasive blast cleaning to Sa 2½ (ISO 8501-1) or SSPC-SP10. When abrasive blasting is not possible, mechanical cleaning to St3 (ISO 8501-1) or SSPC-SP3 is acceptable. After the surface preparation, patch suitable primer prior to the application of Hi-Pon 80-04. Hi-Pon 80-04 can be used as self-priming system.

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. Ensure proper ventilation to have air movement to remove solvent.

**APPLICATION GUIDE**

**Mixing Ratio** : **BASE** : **HARDENER**  
6 : 1 (by volume)

Base and hardener should be mixed thoroughly before use with a mechanical agitator

**Pot Life** : 25 °C  
4 hours

**Theoretical Coverage** : 6.5 m<sup>2</sup>/litre at 100 µm DFT  
3.3 m<sup>2</sup>/litre at 200 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 : 0.018" – 0.026"  
Pressure at nozzle : 150 – 200 bar

|                    |                         |                 |                 |
|--------------------|-------------------------|-----------------|-----------------|
| <b>Drying Time</b> | : Substrate Temperature | <u>25 °C</u>    | <u>40 °C</u>    |
|                    |                         | Surface Dry     | 30 mins 20 mins |
|                    | Through Dry             | 4 hrs 3 hrs     |                 |
|                    | Cured                   | 7 days 3 days   |                 |
|                    | Dry to Overcoat (min)   | 4 hrs 3 hrs     |                 |
|                    | Dry to Overcoat (max)   | 21 days 14 days |                 |

**Remarks:** Stripe coat is required on all weld lines. Pin-hole detection is required to ensure a pin hole-free system.

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.

#### HEAT RESISTANCE

##### Dry, Atmospheric

- Continuous : 100 °C
- Minimum : - 40 °C
- Intermittent : 120 °C

##### Wet, Immersed

- Fresh Water : 49 °C
- Crude Oil : 70 °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.

#### RECOMMENDED COATING SYSTEM

Hi-Pon 80-04 can be used as self-priming system; however, it can also be applied over the following primers:

##### Primer:

- Hi-Pon 80-03 Epoxy Phenolic Primer

| No. | Coating System (Steel Substrate)               | DFT        |
|-----|--|------------|
| 1   | 1 coat of Hi-Pon 80-03 Epoxy Phenolic Primer   | 1 X 150 µm |
|     | 1 coat of Hi-Pon 80-04 Epoxy Phenolic Top Coat | 1 X 150 µm |
| 2   | 2 coat of Hi-Pon 80-04 Epoxy Phenolic Top Coat | 2 X 150 µm |

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

#### PACKAGING

| <u>Unit</u> | <u>Base</u> |                | <u>Hardener</u> |                |
|-------------|-------------|----------------|-----------------|----------------|
|             | Volume      | Container Size | Volume          | Container Size |
| 5 L         | 4.3 L       | 5 L            | 0.7 L           | 1 L            |
| 20 L        | 17.2 L      | 20 L           | 2.8 L           | 5 L            |

#### STORAGE

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

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.

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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**

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.