
PRODUCT DATA SHEET

1226 EPOTAR HB BLACK**Product Description:**

NIPPON 1226 EPOTAR HB BLACK is a two pack, polyamide cured, high-build coal tar epoxy coating. It can be applied up to 350 microns or even thicker in one coat. This is intended for immersion and non-immersion services which require excellent protection against fresh and salt water, abrasion and splashes of corrosive chemicals.

Area suitable for this application include marine structure, pipe piling, ship bottom, pipeline ballast tank, sewage treatment plant etc.

Physical Characteristics of Paint:

Colour	: Black
Finish	: Semi-Gloss
Specific Gravity	: 1.35 ± 0.05 (for Mixture of Base & Hardener)
Solid Content	: 62 ± 2 by volume (for Mixture of Base & Hardener)

Other characteristics:

Comply with National technical regulation QCVN 08:2020/BCT on the limits of Lead content in paints.

**Recommendation for Use:****Surface Preparation**Mild Steel Surfaces

For optimum performance, abrasive blasting to Sa 2.5 is desirable. If abrasive blasting is not possible, wire-brush to St 3 is essential.

Galvanised Steel Surface

New galvanised surface requires to be degreased in accordance to SSPC-SP1. For old galvanised surface, it must be abraded to remove corrosion deposits. Shop-prime with a suitable etching primer e.g. NIPPON VINILEX 120 ACTIVE PRIMER. All surfaces must be dry and free from oil and grease prior to painting.

Masonry and Cement Concrete Surface

For concrete, light abrasive blasting is best to remove all previous coating and chalk. If blasting is not possible, new and uncoated concrete surface must be etched with approximately 5% phosphoric acid solution. It should be then be rinsed thoroughly with clean water, and allow to dry off completely before application of NIPPON 1226 EPOTAR HB BLACK. Moisture Content must be below 6% checked by Sovereign Moisture Meter. Unstable matter such as powder, old paint film, dirt and loose plaster should be removed by high pressure water jet washing or mechanical means such as power brush or scraper whichever is suitable. High pressure water jet may be used for external wall. Contaminants, dust and foreign matter should be removed by cleaning with damp cloth. Oil or grease should be

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removed by solvent cleaning or mild detergent. Allow surface to dry again.

Recommended No. of Coats : 1 - 3 coats

Recommended Film Thickness per coat : 100 microns for dry film
161 microns for wet film

Theoretical Coverage at : 6.2 m² / liter (for dry film thickness of 100 microns)

Recommended Film Thickness

$$\text{Theoretical Coverage (m}^2 \text{ / liter)} = \frac{\text{Volume Solid (\%)} \times 10}{\text{Dry Film Thickness (\mu)}}$$

Practical Coverage (20% Loss Factor) : 5.0 m² / liter (for dry film thickness of 100 microns)

Note : This theoretical coverage rate has been calculated from the volume solid of the material and is related to the amount of coating applied onto a perfectly smooth surface without wastage. For a practical coverage rate, due allowance should be made for atmospheric conditions, surface roughness, geometry of the article being coated, the skill of applicator, method of application etc. when estimating quantities required for a particular job.

Application Data:

Application Methods : Brush, roller, compressed air spray and airless spray. Preferably use airless spray if a thicker coat is required in one application.

Guiding Data for Spray	:	<u>Air</u>	<u>Airless</u>
		Delivery Pressure (kg/cm ²)	3 - 4 140 - 170
		Tip size at 60° angle	1.3 mm 0.015" - 0.017"

Thinning	:	Roller & Brush	10% maximum
		Air Spray	25% maximum
		Airless Spray	5% maximum

Mixing Ratio : 85 parts by volume of NIPPON 1226 EPOTAR HB BLACK (BASE) to 15 part by volume of NIPPON 1226 EPOTAR HB BLACK HARDENER.
Stir the content of the BASE component, continue stirring and gradually add the total content of the HARDENER component, continue stirring until a homogeneous mix is obtained.

Pot Life at 25°C to 30°C : 6 - 8 hours after mixing, depending on prevailing temperature

Thinner : NIPPON SA 65 THINNER

Cleaning Solvent : NIPPON SA 65 THINNER

Note: All equipment should be cleaned IMMEDIATELY with Thinner after use. For thinning, substitute thinners other than those approved or supplied by Nippon Paint may adversely affect the product performance and void product warranty whether expressed or implied.

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Drying Time at 25°C to 30°C:

Dry to touch	: 1 - 2 hours depends on wet film thickness.
Dry to handle	: 16 hours
Dry to overcoat	: Minimum 16 hours
Curing time at 25°C to 30°C	: 7 - 8 days for a coating of 350 microns. Thicker coat will require longer curing time. In all cases, higher temperature will shorten and lower temperature will lengthen the curing time.

Note: Drying time will become remarkable under low temperature. Overcoating the previous coat of NIPPON 1226 EPOTAR HB BLACK should be done within 6 - 7 days but preferably as soon as possible after it has been allowed 16 hours drying or else, it is desirable to roughen it by dry sanding with sandpaper before it is overcoated. This is to ensure proper intercoat adhesion. Exposure of the paint film to water, chemical and abrasion should be avoided as far as possible before full cure of the coating. When chalking occurs, chalks should be removed by water washing. Allow the surface to dry thoroughly prior to overcoating.

Standard Packing	: 5 Liters (4.25 Liters BASE & 0.75 Liter HARDENER) 20 Liters (17 Liters BASE & 3 Liters HARDENER)
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Environmental Conditions during Application:

1. Do not apply when the relative humidity exceeds 85%. The temperature of the substrate to be painted must be 3°C higher than the dew point.
2. Do not apply at temperature below 7°C. If not, drying and overcoating time will be considerably extended.
3. During application of the paint, naked flame, welding operations and smoking should not be allowed and good ventilation is necessary.

Safety, Health and Environmental Information:

1. Flammable Liquid. Do not expose to heat, sparks or open flame.
2. Skin Contact: May cause moderate skin irritation. Avoid prolong contact with skin. Use solvent resistant glove. To remove splashes of paint from skin, use soap and water.
3. Inhalation: Respiratory irritation. Only used in well ventilated areas. Do not breathe vapor or spray paint. Respirator with organic vapor cartridges recommended.
4. Eye Contact: Cause severe eye irritation and blurred vision. Safety glasses / goggles with side shields recommended. In case of contact with eyes, rinse immediately with plenty of water and seek medical advice.
5. Ingestion: Harmful if swallowed. Keep away from drinks, food and out of reach of children. If swallowed, seek medical advice immediately and show the container or label.
6. In the event of an accident, contain and collect spillage using sand or earth or absorbent. Do not empty into drain or water courses.
7. Wastes and empty containers should be treated and disposed of in accordance with national and local regulations. Empty containers and packaging should be taken for recycling, recovery or disposal through a suitably qualified or licensed contractor.

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NOTE: The information given applies to the product and its performance under specific test conditions. Due to the varied circumstances beyond our control under which the product may be applied, for specific application, please contact Nippon Paint Sales & Marketing Dept. We reserve the right to modify our product data sheet without further notice.

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