

**PRODUCT  
DESCRIPTION**

Hi-Pon 20-01 Epoxy Primer is a two-pack, high solids epoxy coating that offers good cathodic protection, and excellent resistance to water and seawater.

**INTENDED USE**

Universal anti-corrosive primer for use in aggressive environment. It is also suitable to be over-coated with various kinds of finishing coats.

**GENERAL  
PROPERTIES**

<b>Colour</b>	: Red Oxide
<b>Gloss Level</b>	: Semi-gloss
<b>Volume Solids, %</b>	: 73 ± 2 %
<b>Specific Gravity</b>	: 1.32 - 1.42 kg/l (Mixed)
<b>Flash point</b>	: Base: 13.3°C    Hardener: 12°C    Mix: 12°C
<b>VOC</b>	: 230 g/L (EPA Method 24)
<b>Typical Thickness</b>	: 75 – 250 µm dry film : 103 – 342 µm wet film



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

**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**

Abrasive blast cleaning to Sa 2½ (ISO 8501-1:2007) or SSPC-SP6. For optimum performance, blast cleaned to 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.

**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 = 3:1 (by volume)  
Base and hardener should be mixed thoroughly before use.

<b>Induction time</b>	: 15 mins
<b>Pot Life</b>	: 25°C 6 Hrs
<b>Theoretical Coverage</b>	: 9.7 m <sup>2</sup> /litre at 75 µm DFT : 2.9 m <sup>2</sup> /litre at 250 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	: 0.017" – 0.023"
	: Pressure at nozzle	: 150 - 200 kg/cm <sup>2</sup>
<b>Typical Thickness</b>	: 75 – 250 µm dry film	
	: 103 – 342 µm wet film	
<b>Drying Time</b>	: Substrate Temperature	: 25°C      40°C
	Surface Dry	: 2 hrs      1 hrs
	Through Dry	: 4 hrs      2 hrs
	Cured	: 7 days      3 days
	Dry to recoat (min)	: 4 hrs      2 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.

#### RECOMMENDED PAINTING SYSTEM

The following Intermediates/Topcoats are recommended for Hi-Pon 20-01 Epoxy Primer:

#### Intermediate

- Hi-Pon 20-01 Epoxy Primer
- 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 IM 80
- Hi-Pon 20-04 STE MIO 80
- 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
<b>20L</b>	15L	20L	5L	5L
<b>5L</b>	3.75L	5L	1.25L	5L

**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**

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