
PRODUCT DATA SHEET

NIPPON EPOXY MIO**Product Description:**

NIPPON EPOXY MIO is a two-pack high build polyamide cured epoxy coating containing Micaceous Iron Oxide pigment. It is specially formulated to give high order of protection for steel structure against corrosion. If it is to be applied over steel surface, it is preferable to be used in combination with the primers as recommended.

Physical Characteristics of Paint:

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|-------------------------|--|
| Colour | : Dark Grey |
| Finish | : Low Gloss |
| Specific Gravity | : 1.60 ± 0.05 (for Mixture of Base & Hardener) |
| Solid Content | : 51 ± 2 by volume (for Mixture of Base & Hardener) |
| Abrasion | : Good resistance to abrasion and mechanical damage |
| Adhesion | : Excellent on correctly prepared surfaces and primed surfaces |
| Temperature | : Dry service temperature range up to 100°C |

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**

Abrasive blasted in accordance with Swedish Standard Sa 2.5, preferably Sa 3.0 (SIS 05 59 00 / ISO 8501-1). Shop-prime immediately with a suitable shop-primer e.g., NIPPON ZINC PHOSPHATE BLAST PRIMER or NIPPON ZINC RICH PRIMER HS after abrasive blasting follows up with a compatible barrier coat or intermediate coat.

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.

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| Recommended No. of Coats | : 1 - 2 coats |
| Recommended Film Thickness per coat | : 75 microns for dry film 148 microns for wet film |
| Theoretical Coverage at Recommended Film Thickness | : $6.8 \text{ m}^2 / \text{liter}$ (for dry film thickness of 75 microns) |

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

Practical Coverage (20% Loss Factor) : 5.4 m² / liter (for dry film thickness of 75 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 and airless spray

Guiding Data for Spray : Airless

Delivery Pressure (kg/cm²) 140 - 170

Tip size at 60° angle 0.015" - 0.017"

Thinning : Roller & Brush 10% maximum

Airless Spray 5% maximum

Mixing Ratio : 4.25 parts by volume of NIPPON EPOXY MIO (BASE) to 0.75 part by volume of NIPPON EPOXY MIO 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 - 7 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.

Drying Time at 25°C to 30°C:

Dry to touch : 1 - 2 hours

Dry to handle : 16 hours

Dry to overcoat : Minimum 16 hours

Curing time at 25°C to 30°C : 6 - 7 days

Note: Drying time will become remarkable under low temperature. Overcoating the previous coat of NIPPON EPOXY MIO 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

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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)

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.

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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