

FEATURES

Hi-Pon 20-04 STE 80 is a two-pack, surface-tolerant, high solids epoxy mastic coating. It is an anti-corrosive primer and / or intermediate coating for corrosion protection of steel and other substrates in atmospheric environments.

- Universal corrosion protection
- Enhance adhesion between substrate and top coating
- It is also be over-coated with various kinds of finishing coats

PRODUCT INFORMATION

Paint type	Epoxy mastic		
Product type	Interior		
Film appearance	Low Gloss		
Color	Off-White / Grey		
Grade	Heavy Duty Coatings		
Recommended substrate	Steel, Galvanized iron, Aluminium, Stainless, Metal sheet and Concrete		
Pack size	Packaging size	Part A:	Part B:
	1 Gallon set	1 Gallon	1/4 Gallon
	5 Gallon set	5 Gallon	1 Gallon

TECHNICAL INFORMATION

Theoretical coverage	4-11	m ² per litre per coat
	15-43	m ² per gallon per coat
Practical coverage	3-9	m ² per litre per coat
	12-35	m ² per gallon per coat
These value are calculated based on the above theoretical coverage and a loss factor of 20% The actual loss factor for a particular job may vary depending on the application condition, method and technique; surface condition; as well as the structure and dimension of the object to be coated.		
No. of coat	1-2	coats
Specific gravity	1.53 ± 0.05	(Mixed)
Solid by volume	80±2	%
VOC (ISO 11890-2)	178	g/L
Wet film thickness	88-250	microns
Dry film thickness	70-200	microns
Touch dry (25-30°C)	Approx.. 3	hrs.
Recoat dry (25-30°C)	Min. 7	hrs. (Max 7 days)
Full cure (25-30°C)	7	days

REFERENCE STANDARD

CARB SCM 2007	✓	Passed
LEED V4 & V4.1 VOC	✓	Passed

LEED V4 & V4.1 Emissions

✓ Passed

APPLICATION

Applicator	Brush, Roller , Spray and Airless spray
Guiding data for airless spray	
Tip size	0.015-0.025 inch
Delivery pressure	150-200 Bar
Diluted by	Hi-pon Epoxy Thinner
Dilution (%)	Normally no thinning is required or thinning not more than 5% If application is by airless spray. Where thinning is necessary for workability, use about 5-10% thinner by volume for application by brush and roller, 40-50% for application by compressed air spray.
Mixing ratio (Part A : Part B)	6:1 by volume
Pot life	2 hrs at 25 °C

SURFACE PREPARATION

Metal	<p>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</p> <p><u>Abrasive Blast Cleaning</u></p> <p>Abrasive blast cleaning to Sa 2½ (ISO 8501-1) or SSPC-SP10. For optimum performance, blast cleaned to SSPC-SP10 with a surface profile of 50 – 75 microns (2 – 3 mils). Surface defect revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner.</p> <p><u>Hand or Power Tool Preparation</u></p> <p>Hand or power tool clean to a minimum St2 (ISO 8501-1) or SSPC-SP2. Note, all scale must be removed and areas which cannot be prepared adequately by chipping or needle gun should be spot blasted to a minimum standard of Sa 2 (ISO 8501-1) or SSPC-SP6.</p>
Concrete	<p>Remove all loose, defective paint or powdery residues, laitance, loose chalk, dust, fungus, algae and foreign matter. Treat any areas affected by fungus growth with Fungicidal Wash Solution. Repair cracks, uneven surfaces with suitable exterior grade fillers. Smoothen the filler areas with sand paper. Surfaces to be painted must be cleaned thoroughly and dry, it must be free from dirt, grease and other foreign matters. Allow all surfaces to dry completely prior to painting. Avoid painting when the moisture content and alkalinity of the walls are still high. (Recommended painting specification requires the moisture content of the walls to be below 14% measured by protimeter and alkalinity of the walls to be below pH8.)</p>

PAINT SYSTEM

Primer for metal surface	HI-Pon 20-04 STE 80 1-2 coats
Primer for Alloys surface	HI-Pon 20-04 STE 80 1-2 coats
Primer for concrete surface	HI-Pon 20-04 STE 80 1-2 coats
Top coat	HI-Pon 40-04 Epoxy Top Coat 2 coats for interior. HI-Pon 50-01 Polyurethane Top Coat 2 coats for exterior.

HANDLING AND STORAGE

Storage condition	<p>The product must be stored in a dry, well-ventilated space and keep the container tightly closed. When transporting paint, the product should separately from others. Not recommended to place the product outdoor or exposed to the sun directly and must separately be stored between enamel paint and thinner, which is a flammable substance.</p>
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Precipitation

Place the product for a long time may lead the pigment to precipitate at the bottom of the container and can deteriorate over time when not stir product to a homogeneous by using suitable tools, such as an electric drill, air drill, or a stirrer. Therefore, should stir the product to the homogeneous phase before use. If not, the product will cause paint problems e.g. low hiding power or non-equal color shade.

Shelf life at 25-30 °C

12 months

ENVIRONMENTAL
CONDITION

The relative humidity during application should not exceed 85% or when the surface to be painted is more than 3°C above the dew point. Generally, the temperature of surface to be painted should be more than 5 °C and not exceed 50°C.

SAFETY PRECAUTIONS

Precautionary notices are displayed on the container. Use product under well-ventilated area. Avoiding skin contact or inhale product. In case of contact with the eye, rinse with plenty of water immediately and seek medical advice. Remove splashes from the skin by using soap or water. For others information in terms of health and safety hazards for use of this product, please observe the Safety Data Sheet.

DISCLAIMER

The above information is given to the best of our knowledge based on laboratory tests and practical experience. However, since we cannot anticipate or control the many conditions under which our products may be used, we can only guarantee the quality of the product itself.

We reserve the right to alter the given without prior notice.

NOTE

The data are average values for reference only. However, the actual value depends on environmental conditions.