HI-PON 20-04 STE IM 80

FEATURES

Hi-Pon 20-04 STE IM 80 is a two-pack, surface-tolerant, high solids epoxy mastic coating. It is an anti-corrosive primer and / or top coat coating for corrosion protection of steel and other substrates in atmospheric and immersed environments. Suitable for refineries, power plants, bridges, water pipes and tanks.

- Suitable for water pipes and tanks.
- It is certified to BS 6920-1 for contact with potable water and AWWA C210-07
- It is certified to TIS 1048-2551: Epoxy Coatings for Steel Potable Water Pipelines.
- Excellent adhesion
- It is also be over-coated with various kinds of finishing coats

PRODUCT INFORMATION

Paint type	Epoxy mastic		
Product type	Interior		
Film appearance	Semi-Gloss		
Color	White / Grey		
Grade	Heavy Duty Coatings		
Recommended substrate	Steel, Galvanized iron, Aluminium and Concrete		
Pack size	Packaging size	Part A:	Part B:
	1 Gallon set	6/7 Gallon	1/7 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	1.78 ± 0.05	(Mixed)
Solid by volume	80±2	%

VOC (ISO 11890-1)	240	g/L
Wet film thickness	87-250	microns
Dry film thickness	70-200	microns
Touch dry (25-30°C)	Approx. 4	hrs.
Recoat dry (25-30°C)	Min. 10	hrs. (Max 7 days)
Full cure (25-30°C)	7	Days

REFERENCE STANDARD

BS 6920-1: Suitability of Non-metallic Materials And Products For Use in Contact With Water Intended For Human Consumption With Regard To Their Effect On The Quality Of The Water.	✓	Passed
AWWA C210-07: Liquid Epoxy Coating Systems For The Interior & Exterior Of Steel Water Pipelines	✓	Passed
TIS 1048-2551: Epoxy Coatings for Steel Potable Water Pipelines	✓	Passed

APPILCATION

Applicator	Brush, Roller , Spray and Airless spray	
Guiding data for airless spray		
Tip size	0.015-0.023	inch
Delivery pressure	150-170	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

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

Metal	Abrasive Blast Cleaning 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. Hand or Power Tool Preparation 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.
Concrete	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.)

PAINT SYSTEM

Primer for metal surface	HI-Pon 20-04 STE IM 80 1-2 coats
Primer for Alloys surface	HI-Pon 20-04 STE IM 80 1-2 coats
Primer for concrete surface	HI-Pon 20-04 STE IM 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. Note: In case of vivid and intense color shade, a lighter shade is recommended to apply in the first coat for a good hiding result.

HANDLING AND STORAGE

Storage condition	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.
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.
DISCLAMER	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.