

FEATURES

- Hi-Pon Coaltar is a two-pack epoxy for protecting steel and other substrates in immersed and buried environments. It also offers good chemical and sea water resistance.
- Suitable for substrate which is immersed in water, sea water and chemical solution.
 - High film thickness

PRODUCT INFORMATION

Paint type	Epoxy Coal Tar		
Product type	Interior or Exterior		
	**When exposed to sunlight or UV rays, the epoxy paint films will be chalk.		
Color	Black / Brown		
Grade	Heavy Duty Coatings		
Recommended substrate	Substrate in immersed and buried condition		
Pack size	Packaging size	Part A:	Part B:
	1 Gallon set	4/5 Gallon	1/5 Gallon
	5 Gallon set	4 Gallon	1 Gallon

TECHNICAL INFORMATION

Theoretical coverage	7.8	m ² per litre per coat (at DFT 80 micron)
	4.2	m ² per gallon per coat (at DFT 150 micron)
Practical coverage	6.3	m ² per litre per coat (at DFT 30 micron)
	3.3	m ² per gallon per coat (at DFT 50 micron)
	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	1.35-1.37	(Mixed)
Solid by volume	63±2	% (Mixed)
Solid by weight	80±5	% (Mixed)
VOC (EPA Method 24)	260-270	g/L
Wet film thickness	127-238	microns
Dry film thickness	80-150	microns
Touch dry (25-30°C)	Approx. 1-1.5	hrs.
Recoat dry (25-30°C)	Min. 16	hrs. (Max 7 days)
Full cure (25-30°C)	6-7	days

REFERENCE STANDARD

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APPLICATON

Applicator	Brush, Roller, Spray and Airless spray in case prefer high thickness of film in 1 coat.	
Guiding data for airless spray		
Tip size	0.015-0.017	inch
Delivery pressure	140-170	Bar
Diluted by	Hi-pon Coaltar Thinner or Hi-Thinner # 03 or Hi-Pon Epoxy Thinner	
Dilution (%)	Normally no thinning is required or thinning not more than 5-15% If application is by airless spray. Where thinning is necessary for workability, use about 10-15% thinner by volume for application by brush and roller, 30-40% for application by compressed air spray.	
Mixing ratio (Part A : Part B)	4:1 by volume	
Pot life	6-8 hrs at 25-30 °C	

SURFACE PREPARATION

Metal

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

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.

PAINT SYSTEM

Primer for metal surface	Hi-Pon 20-04 STE 80 or HI-PON COALTAR 1-2 coats
Primer for Alloys surface	Hi-Pon 20-04 STE 80 1-2 coats
Primer for metal and alloy surface (Immersed and buried condition)	Hi-Pon 20-04 STE IM 80 or Hi-Pon 20-04 STE AL 80 1-2 coats
Top coat	HI-PON COALTAR 1-2 coats

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

24 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.