



PRODUCT DATA SHEET

NIPPON ZINC RICH PRIMER HS

Product Description:

NIPPON ZINC RICH PRIMER HS is a two-pack Epoxy shop primer for use on abrasive blasted steel prior to application of final paint system. It is recommended where high level of corrosive resistance is required.

Physical Characteristics of Paint:

Colour	: Grey
Finish	: Matt
Specific Gravity	: 1.96 ± 0.05 (for Mixture of Base & Hardener)
Solid Content	: 37 ± 2 by volume (for Mixture of Base & Hardener)
Abrasion	: Good resistance to abrasion and mechanical damage
Adhesion	: Excellent on correctly prepared surfaces
Weathering	: Not recommended for direct exposure to sunlight. It is always used as a base coat in conjunction with a Nippon Polyurethane finish coat.
Temperature	: Dry service temperature range up to 100°C

Recommendation for Use:

Surface Preparation

Mild Steel Surfaces

The surface to be painted should be abrasive blasted to minimum SA-2.5 Swedish Standard. For optimum performance, abrasive blasting in accordance to SA-3.0 is desirable. It is important that the standard should be maintained until the paint is applied on. If rust bloom begins to form before the steel surface is coated, it will be necessary to reblast the steel. The surface must be dry and free from any abrasive residues, dirt, oil and grease and other contaminants prior to painting.

Recommended No. of Coats	: 1 - 2 coats
Recommended Film Thickness per coat	: 50 microns for dry film 134 microns for wet film
Theoretical Coverage at Recommended Film Thickness	: 7.5 m ² / liter (for dry film thickness of 50 microns)

NIPPON PAINT (VIETNAM) CO., LTD

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	Theoretical Coverage = $\frac{\text{Volume Solid (\%)} \times 10}{\text{Dry Film Thickness (\mu)}}$ (m ² / liter)
Practical Coverage (20% Loss Factor)	: 6.0 m ² / liter (for dry film thickness of 50 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.	

<u>Application Data:</u>	
Application Methods	: Brush, roller, compressed and airless spray
Guiding Data for Spray	: <u>Airless</u> Delivery Pressure (kg/cm ²) 140 - 170 Tip size at 60° angle 0.015" - 0.017"
Thinning	: Roller & Brush 10% maximum Airless Spray 5% maximum
Mixing Ratio	: 7.75 parts by volume of NIPPON ZINC RICH PRIMER HS (BASE) to 2.25 parts by volume of NIPPON ZINC RICH PRIMER HS 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. Dilution should be done after the addition of hardener.
Pot Life at 25°C to 30°C	: 4 - 6 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.	

<u>Drying Time at 25°C to 30°C:</u>	
Dry to touch	: Approximately 10 minutes
Dry to handle	: Minimum 5 hours
Dry to overcoat	: Minimum 16 hours
Curing time at 25°C to 30°C	: 5 - 7 days

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Note: Drying time will become remarkable under low temperature. Overcoating the previous coat of NIPPON ZINC RICH PRIMER HS 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 occurs, chalks should be removed by water washing. Allow the surface to dry thoroughly prior to overcoating.

Standard Packing : 5 Liters (3.88 Liters BASE & 1.12 Liter HARDENER)
20 Liters (15.5 Liters BASE & 4.5 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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