Technical Data sheet

Indopoxy 645 MIO

Product Description

Indopoxy 645MIO is a two component, high solid, high build Intermediate coating, pigmented with Micaceous Iron Oxide. It has excellent barrier protection, fast curing and long overcoating properties.

Recommended Use

Indopoxy 645MIO is a high build intermediate to provide excellent barrier protection as part of a high performance system in aggressive environments including offshore structures, bridges, chemical and petrochemical plants and power plants, mining euipments & sites etc It has plate-le micaceous iron oxide pigment, which increases the barrier effect and improves long term overcoating properties of the system making this material suitable for application in the fabrication shop, prior to shipping, with final overcoating at site.

Physical Properties

Composition : Epoxy Resin cured with polyamide

Volume Solids	: 55 ± 2%	**Temperature Resistance :**	
Mixing Ratio: Base: catalyst	: 4:1 (ByV/V)	Continuous	: 120^0 C
Pot Life:	: Min. 4 Hours @ 30 Deg.	Intermittent	: 140^0 C
Application	: Airless spray/Convetinal spray		
Recommended DFT	: 70-100 µ's per coat	**Abrasion Resistance**	: Excellent
Recommended WFT	: 127-181 µ's per coat	**Colour**	: Brown Grey
Theoretical Spreading Rate	: 5.5 - 7.85 m^2/ ltr	**Packing** .	: 20Ltrs, 25 Ltrs combi
Drying Time :		**Thinner**	: Thinner 1501
Surface Dry	: Max. 30 hours @ 30^0C	**Chemic resistanace:**	
Tack Free	: Max. 3 hours @30^0C	**Acid & Alkali**	: Very Good with primer & Topcoat
Hard dry	: 12-16 Hours@30^0C	**Oil resistance**	: Very Good with primer & Topcoat
Overcoating Interval :		**Resistance**	: Very Good with primer & Topcoat
MIN.	: 12 - 16 Hours		
MAX.	: 60 days		

The given drying data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness,ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc

Storage Life : Upto 12 months when kept under sealed and controlled condition.

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 cleaning. Damaged Area Damage area should be prepared with abrasive blast cleaning to Sa 2½ (ISO 8501-1:2007). When abrasive blasting is not possible, mechanical cleaningto St 3 (ISO 8501-1:2007) is acceptable. Indopoxy 645 MIO should always be applied over a recommended anti-corrosive primer for metal surface. The primer surface should be dry and free from oil and other contaminations. It must be applied within the overcoating intervals as specified.

Appliaction Details

Stir components A and B separately and then mix the base and Hardener as per recomende mixing ratio. Stir well to homogeneous after mixing base and hardener and allow it to mature for 10-15 minutes stir again before use and during application. For **conventional Spray** Add thinner 1501 30-40% to get a proper application pattern. **Brush:** Apply preferably without thinning. However, add up to 5% Thinner 1501 if required during the application. Brushing is recommended for stripe coats and touch-ups of critical areas.

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For Airless Spray : Tip Size : 0.017" – 0.031"

Pressure at Nozzle : 180 – 200 kg/cm2

Thinner : Add thinner 05-15%

Recommended system:

Primer Coat:

1. Nippopoxy 760 ZR Primer
2. Nippopoxy 710 ZR Primer
3. Valuethane EP ZR Primer
4. Nippopoxy 755 ZR Primer

Finish Coat:

1. Nippothane 1066HS
3. Nippothane 1070
4. Nippothane 4080HB

Precautions

1. Do not apply in rain, fog or mist and when the surface temperature is 50^0C and above.
2. Material should be used under speculate pot life.
3. The spray machine hose and paint storage equipment should clean with thinner 1501 or 1702 to avoid blockage and damage.
4. Below 10^0 C and above 85% Relative humidity appliaction should be avoided. It creates paint defect.
5. application should be avoided when substrate temperature is less than 3^0C than the dew point temperature

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