INDöKöTE
INDUSTRIAL COATINGS BY NIPPON PAINT

NIPPON PAINT

Technical Data sheet

Indopoxy 321

Product Description

Indopoxy 321 is a Two component polyamide cured fast drying anti corrosive general industrial primer containing Zinc chromate as corrosion inhibiting pigments.

Recommended Use

It is recommended as undercoat on M.S. surface in diverse areas of use in Industries and maintenance projects. Indopoxy 321 is recommended for General & Heavy Fabrication industries, MS structures, & Where high corrosion performance coating systems are required.

Physical Properties

Composition : Epoxy Resin cured with polyamide.

Volume Solids	: 45 ± 2%	**Temperature Resistance :**	
Mixing Ratio: Base: catalyst	: 4:1 (ByV/V)	Continuous	: 100^0 C
Pot Life:	: 3 Hours	Intermittent	: 120^0 C
Application	: Airless spray/Convetinal spray		
Recommended DFT	: 40-60 µ's per coat	**Flexibility**	: Good
Recommended WFT	: 88.8 - 133.3 µ's per coat	**Abrasion Resistance**	: Very good
Theoretical Spreading Rate	: 7.5 - 11.25 m^2/ ltr	**Colour**	: Self STD.Grey
Drying Time :		**Finish**	: Matt
Surface Dry	: Max. 30 min @ 30^0C	**Packing** .	: 25 Ltrs
Tack Free	: Max. 3 Hour@30^0C	**Thinner**	: Thinner IK-1501
Hard dry	: 10 - 12 Hours@30^0C	**Chemic resistanace:**	
Overcoating Interval :		**Acid & Alkali**	: Very good with Topcoat
MIN.	: 10 Hours	**Oil resistance**	: Very good with Topcoat
MAX.	: 30 days	**Solvent Resistance**	: Very good with Topcoat

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 per ISO 8504. Oil or grease should be removed per SSPC-SP1 solvent cleaning. Damaged Area The Damaged area should be prepared with abrasive blast cleaning to Sa 2.5 (ISO 8501-1:2007). When abrasive blasting is impossible, mechanical cleaning St 3 (ISO 8501-1:2007) is acceptable.

Appliaction Details

Stir components A and B separately and then mix the base and Hardener as per the recommended mixing ratio. Mix the paint properly after mixing and allow it to mature for 10-15 minutes and stir again before use and during application. For conventional Spray Add thinner 1501 10-20% to get a proper application pattern. Brush: Apply preferably without thinning. However, if required during the application, add up to 5% Thinner 1501. Brushing is recommended for stripe coat and touch-up of critical areas.

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For Airless Spray : Tip Size : 0.017” – 0.027”
Pressure at Nozzle : 180 – 200 kg/cm2
Thinner Intake: 0-5%

Recommended system:

Top Coat:

1. Nippothane 4080
2. Nippothane 1033
3. Nippothane 1070 / 1067 / 1067HS
4. Valuthane PU

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 equipement should clean with thinner 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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