INDöKöTE
INDUSTRIAL COATINGS BY NIPPON PAINT

NIPPON PAINT

Technical Data sheet

Nippopoxy 680HS MIO

Product Description

Nippopoxy 680 HSMIO is a two-pack, high solids, High build epoxy intermediate coating pigmented with micaceous iron oxide. It provides a high build impervious barrier coating that gives excellent adhesion, surface wetting properties and anti-corrosive properties

Recommended Use

As a middle coat for bridges, tanks external and other steel structures used in severe corrosive environments, or pipelines, equipments, machinery and steel structures in chemical factory and power plant.

Physical Properties

Composition : Epoxy Resin cured with polyamide and pigmented with micaceous iron oxide

Volume Solids	: 80 ± 2%	**Temperature Resistance :**	
Mixing Ratio: Base: catalyst	: 3:1 (ByV/V)	Continuous	: 90^0 C
Pot Life:	: Min. 3-5 Hours	Intermittent	: 120^0 C
Application	: Airless spray/Convetinal spray		
Recommended DFT	: 100-200 µ's per coat		
Recommended WFT	: 125-250 µ's per coat	**Abrasion Resistance**	: Excellent
Theoretical Spreading Rate	: 4 - 8 m^2/ ltr	**Colour**	: Red Brown
Drying Time :		**Finish**	: Matt to Eggshell
Surface Dry	: Max. 1.5 hours @ 30^0C	**Packing** .	: 20 Ltrs
Tack Free	: Max. 4 hours @30^0C	**Thinner**	: Thinner 1501
Hard dry	: 8 -10 Hours@30^0C	**Chemic resistanace:**	
Overcoating Interval :		**Acid & Alkali**	Very good with primer and top Coat
MIN.	: 8 - 10 Hours	**Oil resistance**	Very good with primer and top Coat
MAX.	: 60 days	**Solvent Resistance**	Very good with primer and top Coat

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.Nippopoxy 680 HS 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 10-35% 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 5-20%

Recommended system:

Primer Coat

1. Nippopoxy 760 ZR Primer
2. Nippopoxy 760F ZR Primer
3. Nippopoxy 710 ZP Primer
3. Zinky-13 Inorganic Zinc Rich Primer 85

Finish Coat:

1. Nippothane 1066HS
2. Nippothane 1070
3. Nippothane 2075G

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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