

# Marine Paint Manual

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## NIPPON E-MARINE FINISH M

A two-pack pure epoxy finish for offshore structures, above water hulls, decks and superstructures. An interval-free system is realized when combined with NIPPON E-MARINE PRIMER.

Suitable Use	Finish for boottop, topsides, decks, holds, superstructures, offshore structures, etc.					
Type	Pure epoxy (Two-pack)					
Color	White, Black, 445 Red Oxide, and a wide range of other colors					
Gloss	Semi-gloss					
Volume Solids	62 ± 2% (ISO3233:1998)					
Typical Dry Film Thickness	40 ~ 125 µm					
Approx. Wet Film Thickness	65 ~ 202 µm					
Theoretical Coverage	10.33 m <sup>2</sup> / L (60 µm)					
Drying Time	Surface Dry	3 hours (5°C)	1 <sup>1</sup> / <sub>2</sub> hours (20°C)	1 hour (30°C)		
	Dry Hard	32 hours (5°C)	16 hours (20°C)	12 hours (30°C)		
	Full Cure	14 days (5°C)	7 days (20°C)	5 days (30°C)		
Interval before Overcoating ( by self )	Min.	32 hours (5°C)	16 hours (20°C)	12 hours (30°C)		
	Max.	— (5°C)	— (20°C)	— (30°C)		
Thinner	NIPPON MARINE THINNER 600 ( 0 ~ 10%, by weight )					
Application Method	Airless Spray	Tip range	0.48 ~ 0.53 mm			
		Fan angle	55 ~ 69°			
		Output pressure	100 ~ 150 kg/cm <sup>2</sup>			
	Brush	For touching up small areas only				
Mixing Ratio by Volume	BASE 80 / HARDENER 20					
Pot Life after Mixing	16 hours (5°C) 8 hours (20°C) 5 hours (30°C)					
Package	18L (BASE 14.4L, HARDENER 3.6L) Package may vary from country to country.					
Japan Local Brand	NIPPE EPOXY FINISH M					
Flash Point	BASE 6 °C, HARDENER 6 °C					
Surface Preparation	All surfaces to be coated should be clean, dry and free from contamination.					
	High pressure fresh water wash and remove all oil / grease, soluble contaminants and other foreign matters.					

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## Safety

Take precautions to avoid skin and eye contact (i.e. gloves, goggles, face masks, barrier creams etc.)  
Proper ventilation and protective measures must be provided during applications and drying period to keep solvent vapor concentrations within safe limits.  
Prior to use, obtain, consult and follow the MSDS for this product concerning health and safety information.

### <Note>

- 1) The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.
- 2) At temperatures below 5°C, the coating will take longer to dry and harden.
- 3) Intercoat adhesion is good at any interval. However, salt will deteriorate the adhesion and should be removed before application of subsequent coats.
- 4) Ventilate well in the areas with insufficient air flow.
- 5) If dusting may occur during application at high temperatures, use NIPPON MARINE THINNER 650.
- 6) Use NON-SLIP SAND to produce a non-slip surface for decks and walkways.
- 7) When gloss & colour retention is to be required, NIPPON U-MARINE FINISH is recommended.
- 8) Store the paints in paint store.