

Marine Paint Manual

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Issue Date: September 2016 (ES)

NIPPON E-MARINE PRIMER GF

A super high build, glass flake pure epoxy coating, which provides excellent resistance to water, chemicals and abrasion and good cathodic protection. Usually 500 ~ 650 μm with a single coat can be applied with airless spray.

Suitable Use	Super high-build anticorrosive for rudders, stern frames, sea chest, boottop, keel plate, etc. where significant damage is expected from abrasion and corrosion.					
Type	Pure epoxy (Super high build / Glass flake / Two-pack)					
Color	Gray					
Gloss	Flat					
Volume Solids	94 ± 2% (ISO3233:1998)					
Typical Dry Film Thickness	500 ~ 650 μm					
Approx. Wet Film Thickness	532 ~ 691 μm					
Theoretical Coverage	1.57 m ² / L (600 μm)					
Drying Time	Surface Dry	8 hours (5°C)	4 hours (20°C)	3 hours (30°C)		
	Dry Hard	72 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.	48 hours (5°C)	16 hours (20°C)	12 hours (30°C)		
	Max.	7 days (5°C)	3 days (20°C)	3 days (30°C)		
Thinner	NIPPON MARINE THINNER 600 (0 ~ 10%, by weight)					
Application Method	Airless Spray	Tip range	0.89 ~ 0.99 mm			
		Fan angle	55° ~ 62°			
		(For T/U)	30°			
		Output pressure	above 225 kg / cm ²			
Mixing Ratio by Volume	BASE 75 / HARDENER 25					
Pot Life after Mixing	4 hours (5°C) 2 hours (20°C) 1 hour (30°C)					
Typical Package	18L (BASE 14L, HARDENER 4L)					
	Package may vary from country to country.					
Japan Local Brand	NIPPON E-MARINE PRIMER GF					
Flash Point	BASE 24 °C, HARDENER 28 °C					
Surface Preparation	Blast cleaned to ISO-Sa 2 ¹ / ₂ is recommended.					

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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 SDS 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) Use high ratio types of airless spray equipment (ex. Asahi Sunac Mammoth above 45 : 1). The viscosity increases at low temperatures, particularly during winter and the paint cannot be applied with the airless spray of normal types. The high ratio types prevent from sagging caused by excessive dilution with thinner.
- 3) To prevent spray gun from clogging, remove all filters in the spray guns and surge chambers. Ball tip is recommended.
- 4) At temperatures below 10°C, it will take longer to dry and harden.
- 5) Store the paints in paint store.