

PRODUCT DATA SHEET

HD EPOXY MIO 320



Description:	HD Epoxy MIO-320 is a two-component self priming epoxy primer containing patented Graphene Conducting polymer composites as corrosion inhibiting pigment. It is a strong and rust-preventing, abrasion resistance coating.
Futures :	-Heavy duty, abrasion resistant coating. -Overcoat able by a wide range of epoxy- and polyurethane coatings. -Low VOC. -Applicable by standard heavy duty airless spray equipment in a wide range of film thicknesses.
Recommended use:	As a primer or intermediate coat in OEM systems. Recommended for C4 and C5 H corrosion environment. Recommended for flow coat application.
Service temperatures:	Maximum, dry exposure only: 140°C/284°F

Physical constants:

Colours/shade Nos.:	Grey* (Available in MOI/Glass Flake Version)
Finish:	Flat
Volume solids, %:	85 ± 2
Theoretical spreading rate:	6.8m²/litre, 125 micron/5 mils
Flash point:	26°C [78.8°F]
Specific gravity:	1.5 kg/litre
Surface-dry:	30 minutes at 30°C
Touch-dry:	1 hours at 30°C
VOC content:	210 g/litre

Application details:

Mixing ratio:	HD Epoxy MIO Base : HD Epoxy Curing agent 4 : 1 by volume
Application method:	Airless spray /Air spray/Brush
Thinner (max.vol.):	HD Thin Epoxy (25%) / HD Thin Epoxy (50%)/ HDThin Epoxy (5%) see REMARKS overleaf 5 hours at 30°C
Pot life:	.019"- .023"
Nozzle orifice:	225 bar [3262 psi]
Nozzle pressure:	(Airless spray data are indicative and subject to adjustment) 150 micron/6 mils 175 micron/7 mils
Indicated film thickness, dry:	According to Specification
Indicated film thickness, wet:	According to Specification
Overcoat interval, min:	
Overcoat interval, max:	

Safety:	Handle with care. Use Proper PPEs like safety shoes, gloves , goggles etc.
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Surface preparation:

New steel: Abrasive blasting to Sa 2½ (ISO 8501-1:1988). For temporary protection, if required, use a suitable shop primer. All damage of shop primer and contamination from storage and fabrication should be thoroughly cleaned prior to final painting

Other metals and light alloys: Thorough degreasing and (light) abrasive sweeping to remove Contamination and to secure adhesion - surface profile depending on later exposure.

Repair and maintenance: Remove oil and grease etc. thoroughly with suitable detergent. Remove Salts and other contaminants by high pressure fresh water cleaning. Clean damaged areas thoroughly

by power tool cleaning to St 3 (spot-repairs) or by abrasive blasting to min. Sa 2, preferably to Sa 2½ (ISO 8501-1:1988). Improved surface preparation will improve the performance. As an alternative to dry cleaning, water jetting to min. WJ-3, preferably WJ-2 (NACE No. 5/SSPC-SP 12), may be used. A flash-rust degree of maximum FR-2 is acceptable before application. Improved surface preparation will improve the performance of the product. Feather edges to sound and intact areas. Dust off residues. Touch up to full film thickness.

On pit-corroded surfaces, excessive amounts of salt residues may call for high pressure water jetting, wet abrasive blasting, alternatively dry abrasive blasting, high pressure fresh water hosting, drying, and finally dry abrasive blasting again.

Application conditions:

Use only where application and curing can proceed at temperatures above: 10°C/50°F. Before exposure to outside temperatures below 10°C/50°F within the first day after application the coating must have been forced dried at minimum 15 minutes. The temperature of paint itself should be 15°C/59°F or above. Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying.

Preceding coat:

According to specification.

Subsequent coat:

According to specification.

Remarks:

Film thicknesses/thinning: (optional)

May be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate and may influence drying time and recoating interval. Normal range dry is: **150-175** micron/6-7 mils (Consult the separate APPLICATION INSTRUCTIONS).

Overcoating note: (optional)

Before recoating after exposure in contaminated environment, clean the surface thoroughly with high pressure fresh water hosing and allow drying.

If the maximum recoating interval is exceeded, roughening of the surface is necessary to ensure intercoat adhesion.

When being forced dried at 40-50°C/104-122°F recoating with the topcoat can take place after 60 minutes.

This Product Data Sheet supersedes those previously issued.

Data, specifications, directions and recommendations given in this data sheet represent only test results or experience obtained under controlled or specially defined circumstances. Their accuracy, completeness or appropriateness under the actual conditions of any intended use of the Products herein must be determined exclusively by the Buyer and/or User.

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