

NIPPE CERAMO FOR T/U M

(Worldwide Brand : NIPPON CERAMO T/U)

【 Product Description 】

An anticorrosive primer containing zinc powder and epoxy resin as its main components. It is recommended as a touch up paint for steel plate coated with NIPPE CERAMO, such as block joints or other areas to be coated after secondary surface preparation. It has excellent adhesion to solvent-based paints, high-solids type of paints with high film strength, solvent-free paints and water-borne based paints.

【 Suitable Use 】

Zinc rich anticorrosive primer for touch-up during assembly. The coating is fully compliant with IMO Performance Standard for Protective Coatings.

【 Product Data 】

Type	Zinc dust / Epoxy				
Color	Green, Gray, Blue				
Gloss	Flat				
Volume Solids	47 ± 2 % (ISO3233:1998)				
Typical Film Thickness	Dry : 13 - 20 μm				
	Wet : 28 - 43 μm				
	Min. DFT 10 μm				
	Max. DFT 50 μm				
Theoretical Coverage	0.057 kg / m ² 0.032 L / m ² (at DFT 15 μm)				
Mixing Ratio by Weight	BASE 85 / HARDENER 15				
Specific Gravity	BASE : 2.05 ~ 2.25 HARDENER : 0.84 ~ 0.91				
	Mixed paint : 1.68 ~ 1.80				
Flash Point	BASE 8 °C, HARDENER 4 °C				
Application Method	Airless Spray				
	Brush / Roller	For touching up small areas			
Drying Time	Surface Dry	3 minutes (5°C)	2 minutes (20°C)	1 minute (30°C)	1 minute (40°C)
	Dry Hard	7 minutes (5°C)	5 minutes (20°C)	3 minutes (30°C)	2 minutes (40°C)
Interval before Overcoating	Min.	24 hours (5°C)	16 hours (20°C)	12 hours (30°C)	8 hours (40°C)
	Max.	— (5°C)	— (20°C)	— (30°C)	— (40°C)
*Not applicable on 0°C and below.					
*If interval time before immersion is two weeks or more after painting ballast tanks, the minimum interval before overcoating should be 1 hour.					
Pot Life After Mixing	32 hours (5°C)	24 hours (20°C)	16 hours (30°C)	6 hours (40°C)	

Marine Paint Manual

Issue date : July 2015
TDS Identification No. : 01-02

【 Surface Preparation 】

Surface Cleaning

All surfaces to be coated should be clean, dry and free from contamination. High pressure fresh water wash or fresh water wash, as appropriate, and remove all oil / grease, soluble contaminants and other foreign matters.

Water soluble salts limit equivalent to NaCl : $\leq 50 \text{ mg / m}^2$ of sodium chloride.

Dust quantity rating "1" for dust size class "3", "4" or "5". Lower dust size classes to be removed if visible on the surface to be coated without magnification. (ISO8502-3:1993)

Shop Primers

Approved shop primers, compatible with NOA 60 HS, must be applied in accordance with PSPC MSC. 215(82) and MSC.288(87) to a minimum standard of Sa 2 $1/2$ (ISO8501-1:2007) and over blasting profile of 30 - 75 μm (ISO8503-1/2:1988)

Intact shop primer may be retained and shall be cleaned by sweep abrasive blasting or high pressure fresh water washing.

Welding part, corroded and damaged area to the shop primer must be cleaned by abrasive blasting to Sa 2 $1/2$ (ISO8501-1:2007)

Non approved shop primers must be cleaned by abrasive blasting to Sa 2 (ISO8501-1:2007) and at least 70% of the intact shop primer should be removed.

Welding part, corroded and damaged area to the shop primer must be cleaned by abrasive blasting to Sa 2 $1/2$ (ISO8501-1:2007)

The surface profile on any area where abrasive blasting has been carried out must be in the range of 30 - 75 μm (ISO8503-1/2:1988)

After Erection

Erection joint welds and adjacent areas must be abrasive blasted to Sa 2 $1/2$ (ISO8501-1:2007) or power tool cleaned to St 3 (ISO8501-1:2007).

For PSPC-WBT use

Small damages, up to 2% of total area, may be prepared with power tool to St 3 (ISO8501-1:2007).

Damages over 25sqm or over 2% of the total tank surface area must be abrasive blasted to Sa 2 $1/2$ (ISO8501-1:2007).

For PSPC-COT use

For inner bottom

Damages, up to 20% of the area to be coated, shall be prepared with power tool to St 3 (ISO8501-1:2007).

Contiguous damages over 25sqm or over 20% of the area to be coated, shall be abrasive blasted to Sa 2 $1/2$ (ISO8501-1:2007).

For underdeck

Damages, up to 3% of the area to be coated, shall be prepared with power tool to St 3 (ISO8501-1:2007).

Contiguous damages over 25sqm or over 3% of the area to be coated shall be abrasive blasted to Sa 2 $1/2$ (ISO8501-1:2007).

Marine Paint Manual

Issue date : July 2014
TDS Identification No. : 01-02

【 Application 】

Mixing

Material is supplied in two components as a unit. Mix a complete unit in the proportions supplied. Once the units has been mixed it must be used within the specified pot life.

- (1) Agitate BASE with a power agitator.
- (2) Combine HARDENER with BASE and stir up.

As this paint is apt to precipitate after mixing, stir continuously while painting.

Thinner

Use NIPPE EPOXY THINNER (NIPPON MARINE THINNER 600) with thinning ratio of 0 ~ 15% by weight.

Airless Spray

Airless conditions (These can be adjusted depending on coating facilities.)

Tip range : 0.48 ~ 0.79 mm
(ex. GRACO 519 - 531, 617 - 631, 717 - 731)
Output pressure : 50 ~ 150 Kg / cm²

Brush / Roller

Application by brush / roller is recommended only for small areas to be repaired.

Ventilation

It is recommended to keep ventilating till dry hard (Refer to product data). Ventilation shall be required during the coating application and curing to remove residue of solvents and promote suitable environment for curing.

Cleaner

Use NIPPE EPOXY THINNER (NIPPON MARINE THINNER 600).

Clean up

Do not allow paint to remain in spray equipment. When an application of spraying is completed or discontinued over the pot life period, drain immediately the remaining material in equipment. Clean all equipments with NIPPE EPOXY THINNER (NIPPON MARINE THINNER 600).

【 Ambient Condition for Application 】

Ambient condition

Ambient temperature must be between 1 °C and 40 °C at the time of application. Relative humidity must not exceed 85%.

Steel temperature { Min : at least +3 °C above dew point.
Max : 70 °C

【 Unit Size 】

(Standard)

NIPPE CERAMO FOR T/U MBASE	21.3 kg	4.25 kg
HARDENER	3.75 kg	0.75 kg
	25 kg (set)	5 kg (set)

* Blue color is not available for 5kg set.

(Thinner)

NIPPE EPOXY THINNER 16 L
(Worldwide Brand : NIPPON MARINE THINNER 600)

【 Shelf Life 】

BASE : 6 months under 25°C
HARDENER : 12 months under 25°C

Marine Paint Manual

Issue date : July 2015
TDS Identification No. : 01-02

【 ID code 】

Green BASE : DLC545
Gray BASE : DLC050
Blue BASE : DLC711
HARDENER : DLC204

【 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 of 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.
- 2) Store the paints in paint store.