

### 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 m²/L (60 μm)   |                                  |                  |                 |  |  |
| Drying Time                           | Surface Dry  | 3 hours (5°C)                    | 1½ 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 volume)   |                                  |                  |                 |  |  |
| Application Method                    | Airless Spray  | Tip range                        | 0.48 ~ 0.53 mm   |                 |  |  |
|                                       |  | Fan angle                        | 55° ~ 69°        |                 |  |  |
|                                       |  | Output pressure                  | 100 ~ 150 kg/cm² |                 |  |  |
|                                       | 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)   |                                  |                  |                 |  |  |
| Packaging                             | Two Packs  |                                  |                  |                 |  |  |
| Japan Local Brand                     | NIPPE EPOXY FINISH M   |                                  |                  |                 |  |  |
| Flash Point                           | BASE 6°C, HARDENER 23°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.  |                                  |                  |                 |  |  |
| 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.  |                                  |                  |                 |  |  |

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## ***Marine Paint Manual***

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### <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) For availability of product consult Nippon Paint Marine representatives.
- 9) Unit size and filled volumes can vary due to local regulations.
- 10) Store the paints in paint store.
- 11) Some regions will be supplied with NIPPON MARINE THINNER 615 instead of NIPPON MARINE THINNER 600.
- 12) Use products that comply with local regulations to clean the paint equipment.