



HI-FLORO 6738 FLUOROCARBON TOP COAT

TECHNICAL DATA SHEET

PRODUCT DESCRIPTION

Hi-Floro 6738 Fluorocarbon Top Coat is a two-pack, fast dry fluorocarbon finish coat. It provides excellent film stability, good resistance of contamination, weathering and chemicals.

INTENDED USE

It is designed for use as a long-term protection of high performance finish especially for structures with higher requirements of contamination resistance and weathering resistance, such as bridges, petrochemicals, power generations, steel structures and other steel works.

GENERAL PROPERTIES

Colour	: Colour range based on assortment list
Gloss Level	: Semi-Gloss
Volume Solids, %	: 46 ± 2%
Specific Gravity	: 0.98 - 1.28 kg/l (Mixed) depending on colours
Flash point	: Base: 13.3°C Hardener: 24°C Mix: 13.3°C
VOC	: 480 g/L (EPA Method 24)
Typical Thickness	: 40 – 60 µm dry film : 87 – 130 µm wet film

SURFACE PREPARATION

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504. Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Damaged Area

Damage area should be prepared with abrasive blast cleaning to Sa 2½ (ISO 8501-1:2007). When abrasive blasting is not possible, mechanical cleaning to St 3 (ISO 8501-1:2007) is acceptable. After the surface preparation, patch primer prior to the application of Hi-Floro 6738.

Hi-Floro 6738 Fluorocarbon Top Coat should always be applied over a recommended anti-corrosive coating scheme for metal surface. The primer surface should be dry and free from oil and other contaminations. It must be applied within the overcoating intervals specified (refer to application section for details).

Other Surfaces

The coating may be used on other substrates. Please contact your local Nippon Paint office for more information.

CONDITION DURING APPLICATION

Avoid paint application when the temperature is below 10°C or relative humidity exceeds 85%. The temperature of steel surface must be minimum 3°C above dew point of the surrounding air.



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APPLICATION GUIDE

Mixing Ratio	: Base : Hardener = 14 : 1 (by volume) Base and hardener should be mixed thoroughly before use.
Pot Life	: 25°C 6 hours
Theoretical Coverage	: 11.5 m ² /litre at 40 µm DFT 7.6 m ² /litre at 60 µm DFT
Thinner	: Hi-Floro 6738 Thinner

APPLICATION METHOD

Conventional air and airless spray are recommended for application. Brush and roller are recommended for stripe coating and small areas. Care must be taken to achieve the specified dry film thickness.

APPLICATION DETAILS

Airless Spray	: Tip Size : 0.006" – 0.008" Pressure at nozzle : 100 – 150 kg/cm ²
Typical Thickness	: 40 – 60 µm dry film : 87 – 130 µm wet film
Drying Time	: Substrate Temperature : 10°C 25°C 40°C Surface Dry : 1 hr 0.5hr 0.3 hr Through Dry : 10 hrs 4 hrs 2 hrs Cured : 10 days 7 days 3 days Dry to recoat (min) : 1 0hrs 4 hrs 2 hrs Dry to recoat (max) : 2 weeks 2weeks 2weeks

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

RECOMMENDED PAINTING SYSTEM

The following coating systems are recommended for Hi-Floro 6738 Fluorocarbon Top Coat:

Primer

- Zinky-12 Inorganic Zinc Rich Primer 77
- Zinky-13 Inorganic Zinc Rich Primer 85
- Zinky-21 Epoxy Zinc Rich Primer 77
- Zinky-22 Epoxy Zinc Rich Primer 80
- Zinky-23 Epoxy Zinc Rich Primer 85



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- Hi-Pon 20-01 Epoxy Primer
- Hi-Pon 20-03 Epoxy Red Oxide Primer
- Hi-Pon 20-04 STE 80
- Hi-Pon 20-04 STE IM 80
- Hi-Pon 20-07 Epoxy Zinc Phosphate 70
- Hi-Pon 20-10 Epoxy Zinc Phosphate 63

Intermediate

- Hi-Pon 20-04 STE 80
- Hi-Pon 20-04 STE IM 80
- Hi-Pon 30-02 Epoxy MIO 80
- Hi-Pon 30-03 Epoxy Midcoat 80

For the choice of coating system for different application, refer to the product brochure or contact Nippon Paint for professional recommendation.

PACKAGING

Unit	Base		Hardener	
	Vol	Container Size	Vol	Container Size
15 L	14 L	20 L	1 L	1 L

STORAGE

Shelf life : Part A: 12 months (25°C)
Part B: 12 months (25°C)

Subject to re-inspection thereafter. Higher temperature during storage may reduce the shelf life and may lead to gelling in the tin. Frequent temperature cycles may also shorten the shelf life.

Store in tightly closed container in a dry, cool and well ventilated space, keep away from sources of heat and ignition.

SAFETY PRECAUTION

- This product is intended for use of professional applicators. Refer to the safety information display on the container and in the safety data sheet (SDS) before using the product.
- Use this product in well-ventilated area, avoid skin contact, spillage on the skin should immediately be removed with suitable cleanser, soap and water.
- Eye should be well flush with water and seek for medical attention immediately upon contact with this product.
- During the application, naked flame, welding operation and smoking is not allowed. Adequate ventilation should be provided.



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- If you have any doubt regarding the suitability of use, refer to Nippon Paint for further advice.

DISCLAIMER

The information in this data sheet is given to the best of Nippon Paint's knowledge and practical experience. Users may consult with Nippon Paint on the general suitability of the product for their needs and specific application practices though it remains each user's responsibility to determine the suitability of the product for the user's particular use. The condition of the substrate and application are not within Nippon Paint's control. Therefore no implied conditions, warranties or other terms will apply to the Product. Nippon Paint does not and cannot warrant the results which the user may obtain by using the product. In no event will Nippon Paint be liable to the user for any kind of loss (whether direct or indirect) even if Nippon Paint was previously advised of it. In line with Nippon Paint's policy for continuous development, Nippon Paint reserves the right to modify the product and the information in this data sheet without prior notice. It is the user's responsibility to check with Nippon Paint for the latest version of this data sheet. This data sheet has been translated into various languages. In the event of any inconsistency, the English version shall prevail.