



HI-PON 300HT PRIMER

TECHNICAL DATA SHEET

PRODUCT DESCRIPTION

Hi-Pon 300HT Primer is a single component, silicone acrylic based coating which can withstand dry heat temperature up to 300°C.

INTENDED USE

As a primer for long term corrosion protection of steel exposed to high temperature (below 300°C). It is suitable for use on steel as a primer prior to application of final paint system. Recommended for use in combination with Hi-Pon 300HT Top Coat.

GENERAL PROPERTIES

Colour	: Grey
Gloss Level	: Matt
Volume Solids, %	: 40±2%
Specific Gravity	: 1.68 kg/l
Flash point	: 7°C
VOC	: 554 g/l (EPA Method 24)
Typical Thickness	: 20 – 30 µm dry film : 50 – 75 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.

Abrasive Blast Cleaning

For steel, the surface to be painted shall be power tool to minimum St2 (ISO 8501-1:2007), free from mill scale. For optimum performance, abrasive blast cleaning to Sa 2½ (ISO 8501-1:2007) is recommended prior to application of paint. If oxidation has occurred between the blasting and application of this product, the surface should be re-blasted to the specified visual standard. Surface defect revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner. For galvanised and light alloys, thorough degreasing is necessary.

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.

Hi-Pon 300HT Primer should be applied over a surface that is dry and free from dirt, grease, oil and other contaminants and must be applied within the overcoating intervals specified (refer to application section for details).



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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 and relative humidity is over 85%. The temperature of steel surface must be a minimum 3°C above dew point of surrounding air.

APPLICATION GUIDE

Mixing : Should be stirred thoroughly before use.

Pot Life : None

Theoretical Coverage : 13.3 m²/litre at 30 µm DFT

APPLICATION METHOD

Conventional 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 : 0.015" – 0.017"
Pressure at nozzle : 140 – 170 kg/cm²

Typical Thickness : 20 – 30 µm dry film
: 50 – 75 µm wet film

Drying Time : Substrate Temperature : 25°C 40°C
Surface Dry : 0.5 hrs 0.2 hrs
Through Dry : 2 hrs 1 hrs
Dry to recoat (min) : 2 hrs 1 hrs
Dry to recoat (max) : 30 days 14 days

Freshly applied Hi-Pon 300HT Primer may have slightly reduced mechanical properties. This effect can however be overcome by heating the paint system to 200°C for 1 hour.

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 paint system is recommended:

Hi-Pon 300HT Primer, 1 coat x 25 µm dry film thickness



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Hi-Pon 300HT Top Coat, 2 coats x 30 µm dry film thickness

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

PACKAGING

Unit	Vol	Container Size
4.8 L	4.8 L	5 L

STORAGE

Shelf life : 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.

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.
- 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



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