



# HI-PON 600HT PRIMER

## TECHNICAL DATA SHEET

### PRODUCT DESCRIPTION

**Hi-Pon 600HT Primer** is a single component, silicone based coating which can withstand dry heat temperature up to 540°C.

### INTENDED USE

As a primer for long term corrosion protection of steel exposed to high temperature (below 540°C). It is suitable for use on steel as a primer prior to application of final paint system. It is recommended for use in combination with Hi-Pon 600HT Top Coat.

### GENERAL PROPERTIES

<b>Colour</b>	: Light Grey
<b>Gloss Level</b>	: Matt
<b>Volume Solids, %</b>	: 40±2%
<b>Specific Gravity</b>	: 1.06 kg/l
<b>Flash point</b>	: 27°C
<b>VOC</b>	: 601 g/l (by calculation)
<b>Typical Thickness</b>	: 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 600HT 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).

#### Other Surfaces



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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

<b>Mixing</b>	: Should be stirred thoroughly before use.
<b>Pot Life</b>	: None
<b>Theoretical Coverage</b>	: 13.3 m <sup>2</sup> / litre at 30µm DFT
<b>Thinner</b>	: OP-1 Thinner
<b>Thinning</b>	: Ready for use after thorough stirring. Where thinning is necessary for improving workability, use ~5% thinner by volume for brush and roller application and ~10-15% for spray application.

### APPLICATION METHOD

Brush & roller application is suitable for stripe coating and very small areas. For best result, use conventional or airless spray. Care must be taken to achieve the specified dry film thickness.

### APPLICATION DETAILS

<b>Airless Spray</b>	: Tip Size	: 0.015" – 0.017"	
	: Pressure at nozzle	: 140 – 170 kg/cm <sup>2</sup>	
<b>Typical Thickness</b>	: 20 ~ 30 µm dry film		
	: 50 ~ 75 µm wet film		
<b>Drying Time</b>	: Substrate Temperature	: 25°C	40°C
	: Surface Dry	: 0.5hrs	0.2hrs
	: Through Dry	: 2hrs	1hrs
	: Cured	: 7days	3days
	: Dry to recoat (min)	: 2hrs	1 hrs
	: Dry to recoat (max)	: 30days	14days

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.



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### RECOMMENDED PAINTING SYSTEM

The following paint system is recommended:

Hi-Pon 600HT Primer, 1 coat x 25µm dry film thickness  
Hi-Pon 600HT Top Coat, 2 coats x 30µm 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
5L	5L	5L

### STORAGE

**Shelf life** : 6 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



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