

**DUFLONAR BAKING FLUOROCARBON**  
High Performance Polyvinylidene Fluoride (PVDF) Coating**CONTENT**

1. <b>Technical Data: Duflonar Baking Fluorocarbon</b>	Page 2
2. <b>Recommended Application Data</b>	Page 3
3. <b>Duflonar Performance Data</b>	Page 4 – 5
4. <b>Approved Applicators</b>	Page 6 – 8
5. <b>Approved Applicator Status</b>	Page 9
6. <b>In-House Quality Control Checklist</b>	Page 10
7. <b>Projects Using Duflonar</b>	Page 11 – 14
8. <b>Technical Data: Duflonar Flash Primer</b>	Page 15 - 16
9. <b>Technical Data: Duflonar Solid Colour</b>	Page 17 - 18
10. <b>Technical Data: Duflonar Metallic / Exotic Colour</b>	Page 19 - 20
11. <b>Technical Data: Duflonar Top Clear Coat</b>	Page 21 - 22

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TECHNICAL DATA SHEET FOR  
**DUFLONAR BAKING FLUOROCARBON**  
High Performance Polyvinylidene Fluoride (PVDF) Coating

### INTRODUCTION:

Duflonar high performance polyvinylidene fluoride (PVF<sub>2</sub>) coating is intended for use on architectural aluminium surfaces when the ultimate protection against weathering is required.

70% of the binder consist of polyvinylidene fluoride, as manufactured under the trade names of Hylar 5000 or Kynar 500 base resins. All Duflonar coatings meet or exceed all the requirements of **AAMA 2605-22 – Voluntary Specification, Performance Requirements and Test Procedures for Superior Performance Organic Coatings on Aluminum Extrusions and Panels (with Coil Coating Appendix)**

Duflonar retains its properties for decades and provides protection and long-term economy with inherent advantages over other forms of coatings.

### FINISH / COLOUR:

Low and Medium gloss. Standard, metallic and special colours are available upon request.

### FEATURES:

- \* Resistant to degradation by ultraviolet light.
- \* Resistant to colour change.
- \* Resistant to chalking.
- \* Resistant to erosion.
- \* Resistant to dirt pick-up.
- \* Resistant to fungal growth.
- \* Resistant to chemical and solvents.
- \* Flexible for post-coating forming.
- \* Low in maintenance cost for the lifetime of buildings.

## DUFLONAR BAKING FLUOROCARBON

### High Performance Polyvinylidene Fluoride (PVDF) Coating

#### RECOMMENDED APPLICATION DATA

##### A. SOLID COLOUR

DUFLONAR 2-COAT SYSTEM	Spray Thinner	Spray Viscosity, NK-2 cup	Dry Film Thickness, Microns	Flash Off, Minutes	Baking Condition
Duflonar Flash Primer	Duflonar Flash Primer Thinner	16 – 20 sec	5 – 10	10 – 15	-
Duflonar Finishing Coat	Duflonar Finishing Coat Thinner	20 – 25 sec	Min 25	10 – 15	240°C x 15 mins

##### B. METALLIC / EXOTIC COLOUR

DUFLONAR 3-COAT SYSTEM	Spray Thinner	Spray Viscosity, NK-2 cup	Dry Film Thickness, Microns	Flash Off, Minutes	Baking Condition
Duflonar Flash Primer	Duflonar Flash Primer Thinner	16 – 20 sec	5 – 10	10 – 15	-
Duflonar Finishing Coat	Duflonar Finishing Coat Thinner	20 – 25 sec	Min 25	10 – 15	-
Duflonar Clear Coat	Duflonar Top Clear Coat Thinner	18 – 20 sec	10 – 15	10 – 15	240°C x 15 mins

##### PLEASE NOTE:

1. Baking condition: metal temperature to achieve a minimum of 235°C for 5 mins.
2. Metal preparation and pretreatment must comply to Section 6 of **AAMA 2605-22** – *Voluntary Specification, Performance Requirements and Test Procedures for Superior Performance Organic Coatings on Aluminum Extrusions and Panels (with Coil Coating Appendix)*

## DUFLONAR BAKING FLUOROCARBON

### High Performance Polyvinylidene Fluoride (PVDF) Coating

#### PERFORMANCE DATA

No.	Test Item	Performance	Test Method
1.	Colour Uniformity	Shall be consistent with the colour range or numerical value established between the approval source and the applicator	Visual and instrumental check
2.	Dry film thickness	Primer: 5 – 10 microns Finishing coat: Min 25 microns Clear coat: 10 – 15 microns	-
3.	Specular Gloss, 60°	20 – 40%	ASTM D523
4.	Dry Film Hardness	Min F	ASTM D3363
5.	Adhesion, dry, wet and boiling water	Min level 4B classification	Level 4B classification per ASTM D3359
6.	Impact Resistance	No removal of paint film	ASTM G14
7.	Abrasion Resistance*	Withstand a volume of 80 L of sand or the Abrasion Coefficient value (L/mil) of the coating shall be calculated.	ASTM D968 Method A
8.	Muriatic Acid Resistance	No blistering, and no visual change in appearance when examined by the unaided eye.	Procedure 8.7.1.2 of AAMA 2605-22. 15-Minute Spot Test
9.	Mortar Resistance*	Mortar shall dislodge easily from painted surface. No loss of film adhesion or visual change in appearance when examined by the unaided eye.	Procedure 8.7.2.2 of AAMA 2605-22. 24-Hour PAT Test
10.	Nitric Acid Resistance	Not more than 5ΔE units (Hunter) of colour change per AAMA 2605-22 Section 5.7, when comparing measurements on the acid-exposed painted surface and the unexposed surface.	Procedure 8.7.3.2 of AAMA 2605-22
11.	Detergent Resistance*	No loss of adhesion, no blistering and no significant visual change when examined by the unaided eye.	Procedure 8.7.4.2 of AAMA 2605-22
12.	Window Cleaner Resistance*	No blistering or noticeable change in appearance when examined by the unaided eye and no removal of film under the tape within or outside of the cross-hatched area	Procedure 8.7.5.2 of AAMA 2605-22
13.	Humidity Resistance	No formation of blisters to an extent greater than "Few" blisters Size No. 8 as shown in ASTM D714, Figure No. 4.	Procedure 8.8.1.2 of AAMA 2605-22. 4000 Hrs
14.	Salt Spray Resistance	Minimum rating of 7 on scribe or cut edges, and a minimum blister rating of 8, according to Table 1 & 2, ASTM D1654	Procedure 8.8.2.2 of AAMA 2605-22. 2000 Hrs
15.	Weathering*	Colour Retention: Not more than 5ΔE units (Hunter) of colour change after the minimum 10-years exposure test per Section 8.9.2.1. Chalk Resistance: Greater than or equal to that represented by a no. 8 ratings for colours, no. 6 for whites, based on ASTM D4214 Test Method A after test site exposure for 10 years. Gloss Retention: Shall be a minimum of 50% after the 10-year exposure test per Section 8.9.2.1. Resistance to Erosion: Less than 10% film loss after the exposure test per Section 8.9.2.1.	Florida exposure South of latitude 27 degrees North at a 45-degree angle facing South for a minimum of ten (10) years and operated in accordance with ASTM G7/G7M.

**Important Note:**

- All tests except those denoted by asterisk (\*) were carried out in the laboratory according to **AAMA 2605-22** – *Voluntary Specification, Performance Requirements and Test Procedures for Superior Performance Organic Coatings on Aluminum Extrusions and Panels (with Coil Coating Appendix)*
- Colour and finish appearance (such as gloss and etc) may vary upon factory application due to differences in spray equipment, line conditions or day-to-day process variations. It is strongly recommended that final colour approval limits be made with actual production line samples or mock-ups, not laboratory prepared colour panels. Since flake orientation contributes to colour uniformity, pearlescent, mica and metallic flake colours do present the need for more stringent control in application and consideration during project design and installation.
- We reserve the rights to modify our product specifications without prior notice.

## DUFLONAR BAKING FLUOROCARBON

### High Performance Polyvinylidene Fluoride (PVDF) Coating

### APPROVED APPLICATORS

#### SINGAPORE:

<b>Name/Address</b>	<b>Contact Person</b>	<b>Tel. No.</b>	<b>Fax. No.</b>
<b>AVA GLOBAL PTE LTD</b> 4 Tuas Drive 2 Singapore 638638	Mr. Vincent Ang Chairman	6862 5770	6862 5776
<b>BESCOAT MANUFACTURING PTE LTD</b> No. 32 Tuas Ave 9, Jurong Town Singapore 639184	Ms Maggie Tan Sales & Marketing Manager	6862 5782	6863 2715
<b>FLUOROTECH PTE LTD</b> 23, Neythal Road Singapore 628599	Ms Jane Poh Sales Manager	6266 6661	6266 6636
<b>QUALICOAT PTE LTD</b> 5, Gul Drive, Singapore 629457	Mr. John Pang Director Mr Bahdu Director	6365 2228	6365 2808
<b>STARCOAT PTE LTD</b> 3 Tuas Avenue 13 Singapore 638975	Mr. Ng Chong Lin Director	6262 6533	6262 2309

*Note: Listed according to alphabetical order*

#### OVERSEAS:

#### CHINA:

<b>Name/Address</b>	<b>Contact Person</b>	<b>Tel. No.</b>	<b>Fax. No.</b>
C.M.D ALUMINIUM INDUSTRY (SHENZHEN) CO., LTD C-1, He Yi Industry Zone, Shafu Road. Shajing Town, BaoAn District, Shenzhen, China Zip code: 518104	Mr. Thomas Lin Director & General Manager	755- 8149 9010	755- 8149 9004

<b>Name/Address</b>	<b>Contact Person</b>	<b>Tel. No.</b>	<b>Fax. No.</b>
GUANGDONG JIANMEI ALUMINIUM PROFILE FACTORY CO LTD (JMA) Fengchi Industrial Area, Dali Town, Nanhai District, Foshan City, Guangdong, China Zip code: 528231	Mr Ken Lo Export Dept	757- 8557 8592	757- 8559 9322
JINXING BUILDING MATERIALS CO LTD (GOLDSTAR GROUP) South Road, Yongfeng No. 2 Industrial Lunjiao Shunde District, Foshan City Guangdong. PR. China Zip code: 528308	Mr Peace Xie Deputy General Manager	757- 2733 0295	757- 2733 0294

### **MALAYSIA:**

<b>Name/Address</b>	<b>Contact Person</b>	<b>Tel. No.</b>	<b>Fax. No.</b>
SEIKOTECH ARCHITECTURAL COMPONENTS SDN BHD PT 17941 Tuanku Jaafar Industrial Park, Sungai Gadut, 71450 Seremban, Negeri Sembilan D.K., Malaysia	Mr. Lee Eyu Teck Operation Manager	60-6-6782288	60-6- 6778886

### **THAILAND:**

<b>Name/Address</b>	<b>Contact Person</b>	<b>Tel. No.</b>	<b>Fax. No.</b>
MUANG THONG ALUMINIUM INDUSTRY CO., LTD 66 M.11 Soi Vilalai, Bangna-Trad., (Km.20), Bangchalong, Bangplee, Samutprakarn 10540 Thailand	Mr Kosit Sookkongwaree Factory Manager	662 337 2348 (5 lines)	662 337 2347
SCHIMMER METAL STANDARD CO., LTD. 1/4 Moo 7 T.Bantheaw A. Sena Ayutthaya 13110 Thailand	Mr. Piphat Kovitkanit Director / GM	66 0 3537 5080	66 0 3537 5085

**VIETNAM:**

<b>Name/Address</b>	<b>Contact Person</b>	<b>Tel. No.</b>	<b>Fax. No.</b>
CONG TY TNHH VIET NAM HWA YANG METAL INDUSTRIAL So 49, Duong so 6, Khu Cong Nghiep Viet Nam - Singapore, TX. Thuan An Tinh Binh Duong	Mr Wu Wei Che Asst General Manager	84-650- 3767995	84-650- 3766653
MIAN LAN MECHANICAL CO., LTD Duc Lap Ha Commune, Duc Hoa Dist., Long An Province, Vietnam	Ms Anny Kuo General Manager	84-72-759280- 89(10 lines)	84-72- 759077

*Note: Listed according to alphabetical order*



## DUFLONAR BAKING FLUOROCARBON High Performance Polyvinylidene Fluoride (PVDF) Coating

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### APPROVED APPLICATOR STATUS

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Applicators of **DUFLONAR** coatings are companies who meet the following minimum requirement:

1. A multi-stage aluminium cleaning are companies and chemical pretreatment system conforming to American Architectural Manufacturers Association (AAMA) AAMA 2605-22 – *Voluntary Specification, Performance Requirements and Test Procedures for Superior Performance Organic Coatings on Aluminum Extrusions and Panels (with Coil Coating Appendix)*
2. Spray equipment adequate to apply a uniform coating.
3. Oven capability to fully cure the coatings for optimum hardness, mar-resistance and weather-resistance.
4. Conduct quality control check of coated panels according to our recommended In-House Quality Control Checklist <sup>1</sup>.
5. On-site audit must be done before the issue of “Approved Applicator Status” certification to ensure all parameters conform to requirement. Floor plan of the coating line is also required for reference.
6. As approved applicator, the company will send production panels<sup>2</sup> for verification that the finish products continue to meet our requirements and pass AAMA 2605-22 – *Voluntary Specification, Performance Requirements and Test Procedures for Superior Performance Organic Coatings on Aluminum Extrusions and Panels (with Coil Coating Appendix)*
  - (a) In-house quality control / testing of production panels.
  - (b) Description of production parameters e.g.: spray viscosity, thinner used and etc.
7. Warranty certificate will only submit upon completion of AAMA test.

<sup>1</sup> Please see In-House Quality Control Checklist

<sup>2</sup> The dimension / numbers of panels required: 14 x 7cm / 8pcs and 30 x 30 / 2 pcs

## DUFLONAR BAKING FLUOROCARBON

### High Performance Polyvinylidene Fluoride (PVDF) Coating

### IN-HOUSE QUALITY CONTROL CHECKLIST

Quality control checklist on completed coated panels:

No.	Test item	Performance	Test Method
1.	Cure Test / MEK Rubs	Min. 100 Rubs or 50 Cycles: No change of colour and loss of gloss	--
2.	Dry film thickness	Min 30 microns (2-coat system) Min. 40 microns (3-coat system)	--
3.	Colour vs Standard	Shall be consistent with colour range or numerical value as established between approval source and the applicator	--
4.	Specular Gloss, 60°	25 – 35%	ASTM D523
5.	Film Hardness	Min F	ASTM D3363
6.	Adhesion, wet & dry	Min Level 4B classification	ASTM D3359
7.	Impact Resistance	No removal of paint film	ASTM G14
8.	Acid Resistance (10% Muriatic Acid)	No blistering, and no visual change in appearance, after 15 mins	Procedure 8.7.1.2 of AAMA 2605-22.

**Note:**

This is the minimum quality check items, please refer to AAMA 2605-22 for the complete list of test items.

## DUFLONAR BAKING FLUOROCARBON

### High Performance Polyvinylidene Fluoride (PVDF) Coating

### PROJECTS USING DUFLONAR

#### SINGAPORE:

NO.	LOCATION	COLOUR CODE	COLOUR NAME
1	40 PENJURU LANE	4678E	
2	42 CAIRHILL CONDO	2968M	
3	ACER @ IBP	2964M	SC 5000
4	AMBER PARK	21653M	
5	AMBER PARK	31272M	
6	AUSTRALIA INTERNATIONAL SCHOOL	20480M	
7	@ BREDEL ROAD		
8	BOON LAY MRT	2968M	
9	BOSCH FACTORY	20827M	
10	BULIM SQUARE JTC	21336M	
11	CAIRHILL CONDO	20377M	
12	CAPRI HOTEL @ CHANGI CITY	20893E	
13	CAPRI HOTEL @ CHANGI CITY	3904M	
14	CAPRI HOTEL @ CHANGI CITY	6200M	DARK BRONZE METALLIC
15	CAPRI HOTEL @ CHANGI CITY	6571M	
16	CARTON HOTEL	3944E	
17	CEMENTONE'S HOLIDAY INN	61128E	
18	CHANCERY LANE CONDOMINIUM	5175E	SPANISH RED
19	CHANGI AIRPORT MRT	2968M	CODE Q
20	CHANGI AIRPORT TERMINAL 1	20856M	
21	CHANGI AIRPORT TERMINAL 3	20769M	
22	CHANGI AIRPORT TERMINAL 4	21117M	
23	CHAO YANG FACTORY	5279E	MEDIUM PINK
24	CHINA SQUARE	2964M	SC 5000
25	CHURCH STREET	20480M	
26	CLEANTECH_2 @ JALAN BAHAR	6200M	DARK BRONZE METALLIC
27	CLEANTECH_2 @ JALAN BAHAR	10789E	
28	CLEANTECH_2 @ JALAN BAHAR	31269E	
29	CLEANTECH_2 @ JALAN BAHAR	5932E	
30	CLEANTECH_2 @ JALAN BAHAR	6894E	
31	CLEANTECH_2 @ JALAN BAHAR	6987E	
32	COURTS FURNITURE MALL	10301E	
33	COURTS FURNITURE MALL	20087M	
34	COURTS @ TAMPINES	10301E	
35	EUROKASR	7669M	
36	DHOBY GHAUT MRT INTERCHANGE	10238E	
37	FHTK COLDSTORE	1712E	IVORY
38	FHTK COLDSTORE	7379E	REGAL BLUE
	FRAMEWORK FACTORY	5171E	APRICOT BLUE
39	FRAMEWORK FACTORY	8204E	CHAROKE BLUE
40	FURAMA HOTEL	20377M	
41	GOLDBELL TOWER	3461M	
42	HARBOURFRONT	2968M	CODE Q
43	HARDROCK HOTEL – SENTOSA	5795E	
44	HARDROCK HOTEL – SENTOSA	8903E	

NO.	LOCATION	COLOUR CODE	COLOUR NAME
45	HDB BEDOK	1893E	LIGHT GREY
46	HDB BEDOK	9241E	OCEAN BLUE
47	HDB BUKIT BATOK N6C3	6183M	OLIVE SHEEN
48	HDB BUKIT BATOK N6C3	6200M	DARK BRONZE METALLIC
49	HDB PUNGOL EAST	1927E	
50	HDB WOODLANDS	9418E	COSMIC BLUE
51	HEEREM	2921M	CHAMPAGNE METALLIC
52	HIGH TECH FACTORY	5239E	BANNER RED
53	HONDA @ LENGKEE	2964M	SC 5000
54	HONDA SHOWROOM	2964M	SC 5000
55	ICON @ IBP	21004M	
56	IKEA	1590E	LIGHT GREY
57	INLAND REVENUE HOUSE	2562E	SILVER STREAK
58	INTERNATIONAL BUSINESS PARK	20480M	
59	IOH/NDC SPACEFRAME	8348E	MID GREEN
60	ISTANA PARK	2909E	LIGHT GREY
61	JPH BRUNEI	1941E	IVROY
62	JTC WOODLANDS	6200M	DARK BRONZE METALLIC
63	JTC WOODLANDS	21549E	
64	JTC WOODLANDS	6183M	
65	JTC WOODLANDS	6955E	
66	JTC WOODLANDS	6963E	
67	JUNCTION 8	6687M	
68	KAKI BUKIT TECH PARK	8324E	SMART GREEN
69	KATONG MALL	1882M	SILVER METALLIC
70	KHOO TECH PUAT GENERAL HOSPITAL	2964M	SC 5000
72	KONG MENG SUN	7556M	
73	KPE VENTILATION HOUSE	2968M	
74	KRANJI MRT	8165E	AGED COPPER
75	LKN BUILDING	20480M	
76	MAPLE TREE BUSINESS CITY	20480M (2)	
77	MARGATED FACTORY	8179E	HARTFORD GREEN
78	MAYBANK	2968M	
79	MAYBANK	20087M	
80	MERLION	10840E	
81	MERLION	21748E	
82	MERLION	21750E	
83	MERLION	21749E	
84	MICRON	21749E	
85	MICRON	10841E	
86	MRT – JOO KOON	7133E	
87	MRT – JOO KOON	2968M	
88	MRT – PIONEER ROAD NORTH	2968M	
89	MRT – PIONEER ROAD NORTH	9240E	
90	MRT CIRCLE LINE CIVIC CENTRE	2968M	
91	MT ALVERNIA	2968M	
92	MT ELIZIBETH @ NOVENA	2968M	
93	NATIONAL SKIN CENTRE	90246M	
94	NATIONAL UNIVERSITY HOSPITAL	1712E	IVORY
95	NG TENG FONG GENERAL HOSPITAL	21117M	
96	NG TENG FONG GENERAL HOSPITAL	21118M	
97	NORTHPOINT CITY	6571M	
98	NOVENA HOSPITAL	3840M	
99	NOVENA SQUARE	2964M	SC 5000
100	NTU ADMIN ANNEX	2954E	SEAL GREY

NO.	LOCATION	COLOUR CODE	COLOUR NAME
101	NTU ADMIN ANNEX	3365E	MEDIUM GREY
102	NUS DUKE	3882M	SILVER GREY
103	NUSANTARA	2591M	GLACIER GREY
104	OVERSEA UNION HOUSE	20927M	
105	PARAGON SHOPPING CENTRE	2964M	SC 5000
106	PARKVIEW SQUARE	6200M	DARK BRONZE METALLIC
107	PARKVIEW SQUARE	6481M	
108	PEIRCE VILLA	6170M	COLONIAL GREY
109	PONTIAC MARINA	2918E	LIGHT GREY
110	PSA BUILDING	21004M	
111	PUNGGOL MRT INTERCHANGE	2968M	
112	PUNGGOL MRT INTERCHANGE	20087M	
113	PULLMAN HOTEL	6823M	
114	PULLMAN HOTEL	46490E	
115	QUEEN STREET	1712E	IVORY
116	QUEEN STREET	5267E	RED
117	QUEEN STREET	9174E	TUSCANY BLUE
118	RAFFLES JUNIOR COLLEGE	8300E	
119	REPUBLIC POLYTECHNIC	20844M	
120	RIVERSIDE CONDOMINIUM	9385E	BLUE
121	ROYAL SQUARE @ NOVENA	10712M	
122	ROYAL SQUARE @ NOVENA	1962E	
123	ROYAL SQUARE @ NOVENA	21354E	
124	ROYAL SQUARE @ NOVENA	5869M	
125	ROYAL SQUARE @ NOVENA	7556M	
126	SAKATA	3352E	PEWTER CUP
127	SATS-MC2	3294E	CHARCOAL GREY
128	SELEGIE COMPLEX	20908M	
129	SIEMENS	21626M	
130	SILTRONICS	20810E	
131	SILTRONICS	90220E	
132	SILTRONICS	21658E	
133	SILTRONICS	8885E	
134	SNRSI @ NUS	10834E	
135	SNRSI @ NUS	61098E	
136	SNRSI @ NUS	31319E	
137	SOUTH BEACH	10644E	
138	SOUTH BEACH	3971E	
139	SOUTH BEACH	6736M	
140	SPH BUILDING	20402M	
141	SPORTHUB	2922E	
142	SPORTHUB	3254E	
143	SPORTHUB	3317E	
144	SPORTHUB	6200M	DARK BRONZE METALLIC
145	ST JAMES POWER STATION LINKWAY	2595M	
146	ST REGIS CONDO	20863M	
147	STAMFORD COURT	1712E	IVORY
148	STARHUB	21241M	
149	TAMPINES HUB	31090E	
150	TELETECH PARK	2964M	SC 5000
151	THE CLIFT	20927M	
152	THE EXCHANGE	2968M	CODE Q
153	THE SAIL	3854E	ARMOUR GREY
154	THE SAIL	20893E	SAIL GREY
155	TOMLINSON CONDO	3675E	
156	TURQUOISE CONDO – SENTOSA	10574E	

NO.	LOCATION	COLOUR CODE	COLOUR NAME
157	UBI TECH PARK	20402M	
158	UE SQUARE	2968M	
159	UE SQUARE	2964M	SILVER METALLIC
160	UOB PLAZA	3840M	
161	W & T LOGISTICS	2936E	SEAFOAM GREY
162	WOODLAND CHECKPOINT	9254M	
163	WOODLAND CHECKPOINT	3254E	
164	WOODLAND NORTH COAST JTC	2589E	
165	YEW TEE STATION	8165E	AGED COPPER

**OVERSEAS:**

NO.	LOCATION	COLOUR CODE	COLOUR NAME
1	BEIJING, CEROIL PLAZE	1712E	IVORY
2	HONG KONG, ATUO PLAZA	1831E	OFF WHITE
3	HONG KONG, HHML	1718E	JURONG BEIGE
4	HONG KONG, HOI CHENG BUILDING	8302E	INTERSTATE GREEN
5	HONG KONG, MACDONNELL ROAD	8159E	INTERSTATE GREEN
6	HONG KONG, NAM ON STREET	8370E	INTERSTATE GREEN
7	HONG KONG, SHAM TSENG	8129E	TAYLOR GREEN
8	JAPAN, EHOSHIMA	6275E	GREY
9	JAPAN, ODAKYU SAGAMI	1892E	OFF WHITE
10	JAPAN, SAIPAN CNS GULF RESORT	2979M	LIGHT METALLIC
11	JAPAN, YAYASAN CARPARK	3338E	SILVER GREY
12	SHANGHAI, NANCHANG TOBACCO	2776E	SANDSTONE
13	SHANGHAI, NANCHANG TOBACCO	6269M	COPPER METALLIC
14	SHANGHAI, NCKU	9385E	BLUE
15	SHANGHAI, SUPREME HOUSE	1927E	MIST WHITE
16	YANGON AIRPORT	3771E	
17	VIETNAM AIRPORT	20860M	

**TECHNICAL DATA SHEET FOR  
DUFLONAR FLASH PRIMER****INTRODUCTION:**

A polyvinylidene fluoride yellow primer that is necessary to ensure good adhesion and anti-corrosive property on aluminium substrate for the Duflonar Baking Fluorocarbon system.

**PAINT SPECIFICATION:**

Non-volatile	:	Min 40% by weight
Packing	:	20 litres
Specific Gravity	:	1.30 ± 2% kg/litre
Supplied Viscosity	:	65 ± 2 ku

**APPLICATION:**

Pretreatment	:	The aluminium shall be cleaned & pretreated by a multi-stage system to meet ASTM D1730, Type B, method 5 or 7. Processing must comply with ASTM B449, Section 6, Class I.
Paint Preparation	:	The paint should be thoroughly stirred to a homogenous consistency before use. It is suitable for ordinary air spray, airless spray and electrostatic spray-painting application.
Thinner	:	Duflonar Flash Primer Thinner
Spray Viscosity	:	16 – 20 sec NK-2 cup (10-20% dilution)
Flash Off	:	5 – 10 minutes
Film Thickness	:	Recommended dry film thickness of 5 – 10 microns

**TECHNICAL DATA SHEET FOR  
DUFLONAR FLASH PRIMER**

Theoretical coverage \* : 30 m<sup>2</sup>/litre

Practical coverage \* : 25 m<sup>2</sup>/litre (20% loss factor)

\* Calculation based on film thickness of 10 microns per coat.

**IMPORTANT NOTE:**

*It contains volatile and flammable solvents, ensure adequate ventilation during use and avoid using near fire. Values given as average for reference.*



**TECHNICAL DATA SHEET FOR  
DUFLONAR SOLID COLOUR****INTRODUCTION:**

A polyvinylidene fluoride finishing coat for the Duflonar Baking Fluorocarbon system. It contains 70% Hylar 5000 / Kynar 500 in the binder. Duflonar Flash Primer must be used as the base coat.

**PAINT SPECIFICATION:**

Non-volatile	:	Min 45% by weight
Packing	:	20 litres
Specific Gravity	:	1.20 ± 2% kg/litre
Supplied Viscosity	:	65 ± 2 ku

**APPLICATION:**

Pretreatment	:	The aluminium shall be cleaned & pretreated by a multi-stage system to meet ASTM D1730, Type B, method 5 or 7. Processing must comply with ASTM B449, Section 6, Class I.
Paint Preparation	:	The paint should be thoroughly stirred to a homogenous consistency before use. It is suitable for ordinary air spray, airless spray and electrostatic spray-painting application.
Thinner	:	Duflonar Finishing Coat Thinner
Spray Viscosity	:	20 – 25 sec NK-2 cup (10-20% dilution)
Flash Off	:	5 – 10 minutes

**TECHNICAL DATA SHEET FOR  
DUFLONAR SOLID COLOUR**

Film Thickness : Recommended dry film thickness of minimum 25 microns. Dry film thickness of full system must be minimum 30 microns.

Theoretical coverage\* : 7.5m<sup>2</sup>/litre

Practical coverage\* : 6.0 m<sup>2</sup>/litre (20% loss factor)

\* Calculation based on film thickness of 25 microns per coat.

**IMPORTANT NOTE:**

*It contains volatile and flammable solvents, ensure adequate ventilation during use and avoid using near fire. Values given as average for reference.*

**TECHNICAL DATA SHEET FOR  
DUFLONAR METALLIC / EXOTIC COLOUR****INTRODUCTION:**

A polyvinylidene fluoride finishing coat for the Duflonar Baking Fluorocarbon system. It contains 70% Hyar 5000 / Kynar 500 in the binder. To be used with Duflonar Flash Primer as the base coat and Duflonar Top Clear Coat as the overcoat.

**PAINT SPECIFICATION:**

Non-volatile	:	Min 40% by weight
Packing	:	20 litres
Specific Gravity	:	1.1 ± 2% kg/litre
Supplied Viscosity	:	65 ± 2 ku

**APPLICATION:**

Pretreatment	:	The aluminium shall be cleaned & pretreated by a multi-stage system to meet ASTM D1730, Type B, method 5 or 7. Processing must comply with ASTM B449, Section 6, Class I.
Paint Preparation	:	The paint should be thoroughly stirred to a homogenous consistency before use. It is suitable for ordinary air spray, airless spray and electrostatic spray-painting application.
Thinner	:	Duflonar Finishing Coat Thinner
Spray Viscosity	:	20 – 25 sec NK-2 cup (10-20% dilution)
Flash Off	:	5 – 10 minutes

TECHNICAL DATA SHEET FOR  
**DUFLONAR METALLIC / EXOTIC COLOUR**

Film Thickness	:	Recommended dry film thickness of minimum 25 microns. Dry film thickness of full system must be minimum 40 microns.
Theoretical coverage*	:	7.5 m <sup>2</sup> /litre
Practical coverage*	:	6.0 m <sup>2</sup> /litre (20% loss factor)

\*Calculation based on dry film thickness of 25 microns per coat.

**IMPORTANT NOTE:**

*It contains volatile and flammable solvents, ensure adequate ventilation during use and avoid using near fire. Values given as average for reference.*

**TECHNICAL DATA SHEET FOR  
DUFロンAR TOP CLEAR COAT****INTRODUCTION:**

A polyvinylidene fluoride clear overcoat for the Duflonar Baking Fluorocarbon system. It contains 70% Hylar 5000 / Kynar 500 in the binder. As a overcoat for metallic or exotic finishing coat.

**PAINT SPECIFICATION:**

Non-volatile	:	Min 40%
Packing	:	20 litres
Specific Gravity	:	1.00 ± 0.05
Supplied Viscosity	:	65 ± 2 ku

**APPLICATION:**

Pretreatment	:	The aluminium shall be cleaned & pretreated by a multi-stage system to meet ASTM D1730, Type B, method 5 or 7. Processing must comply with ASTM B449, Section 6, Class I.
Paint Preparation	:	The paint should be thoroughly stirred to a homogenous consistency before use. It is suitable for ordinary air spray, airless spray and electrostatic spray-painting application.
Thinner	:	Duflonar Top Clear Thinner
Spray Viscosity	:	18 – 20 sec NK-2 cup (10-20% dilution)
Flash Off	:	5 – 10 minutes

**TECHNICAL DATA SHEET FOR  
DUFロンAR TOP CLEAR COAT**

Film Thickness : Recommended dry film thickness of minimum 10 microns. Dry film thickness of full system must be minimum 40 microns.

Theoretical coverage\* : 30 m<sup>2</sup>/litre

Practical coverage\* : 25 m<sup>2</sup>/litre (20% loss factor)

\* Calculation based on film thickness of 10 microns per coat.

**IMPORTANT NOTE:**

*It contains volatile and flammable solvents, ensure adequate ventilation during use and avoid using near fire. Values given as average for reference.*