

**PRODUCT DESCRIPTION**

**Hi-Floro 6740 Fluorocarbon 4F Top Coat** is a two-pack air-cured fluorocarbon finish coat. It provides excellent gloss and color retention, excellent resistance to water, weather, contaminated gas and chemicals.

**INTENDED USE**

It is suitable for use in both new construction and as an industrial maintenance finish, and can be applied in a wide range of environments, including refineries, power plants, bridges, transportation vehicles, and buildings.

**GENERAL PROPERTIES**

<b>Colour</b>	: White & Grey Special colours available upon request
<b>Gloss Level</b>	: Gloss
<b>Volume Solid</b>	: 54 ± 2 %
<b>Specific Gravity</b>	: 1.35 ± 0.05 kg/l (Mixed)
<b>Flash Point</b>	: Base: 23 °C Hardener: 24 °C Mix: 23 °C
<b>VOC</b>	: 398 g/L (EPA Method 24)
<b>Typical Thickness</b>	: 30 – 70 µm dry film 55 – 135 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) or SSPC-SP10. When abrasive blasting is not possible, mechanical cleaning to St3 (ISO 8501-1) or SSPC-SP3 is acceptable. After the surface preparation, patch suitable primer prior to the application of Hi-Floro 6740.

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 above 85 %. The temperature of steel surface must be minimum 3 °C above dew point of surrounding air.

**APPLICATION GUIDE**

**Mixing Ratio** : **BASE** : **HARDENER**  
3.75 : 1 (by volume)

Base and hardener should be mixed thoroughly before use with a mechanical agitator

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<b>Pot Life</b>	:	<u>25 °C</u> 6 hours
<b>Theoretical Coverage</b>	:	18.0 m <sup>2</sup> /litre at 30 µm DFT 7.7 m <sup>2</sup> /litre at 70 µm DFT
<b>Thinner</b>	:	Hi-Pon PU Thinner
<b>Cleaner</b>	:	Hi-Pon PU Thinner

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**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.

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**APPLICATION DETAILS**

<b>Airless Spray</b>	:	Tip Size	:	0.011" – 0.017"
		Pressure at nozzle	:	100 – 150 bar
<b>Drying Time</b>	:	Substrate Temperature	<u>25 °C</u>	<u>40 °C</u>
		Surface Dry	1.5 hr	0.5 hrs
		Through Dry	7 hrs	3.5 hrs
		Cured	7 days	3 days
		Dry to Overcoat (min)	7 hrs	3.5 hrs
	Dry to Overcoat (max)		Extended	

**Remarks:** Where an "extended" overcoating time is stated, consult Nippon Paint Protective Coatings for recommended surface preparation to achieve optimal intercoat adhesion.

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  
COATING SYSTEM**

The following coating systems are recommended for Hi-Floro 6740 Fluorocarbon 4F Top Coat:

**Primer:**

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

**Intermediate:**

- 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**

<u>Unit</u>	<u>Base</u>		<u>Hardener</u>	
	<u>Volume</u>	<u>Container Size</u>	<u>Volume</u>	<u>Container Size</u>
19 L	15 L	20 L	4 L	5 L

**STORAGE**

**Shelf Life**      Base : 12 months (25 °C) minimum  
                         Hardener : 12 months (25 °C) minimum

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.
- 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,

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