Technical Data

FLONTECT TOPCOAT

**GENERIC TYPE**
Fluoro Resin Enamel

**DESCRIPTION**
A weather resisting fluoro resin paint based on fluoro resin and non-yellowing isocyanate hardener

**RECOMMENDED USE**
Steel structure at marine or industrial severe corrosive environment

**FEATURES**
- Excellent gloss and color retention
- Quick drying
- Excellent resistance to water and sea water
- Excellent adhesion to polyurethane and epoxy primer
- Provides hardness, abrasion resistance

**PHYSICAL PROPERTIES**

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Colour</td>
<td>White and colours</td>
</tr>
<tr>
<td>Finish</td>
<td>Full gloss</td>
</tr>
<tr>
<td>Volume Solids</td>
<td>39 %</td>
</tr>
<tr>
<td>Typical Thickness</td>
<td>Dry: 25 microns / coat</td>
</tr>
<tr>
<td>Theoretical Coverage</td>
<td>15.7 ml/L at 25 microns DFT</td>
</tr>
<tr>
<td>Flash Point</td>
<td>3°C (Base)</td>
</tr>
<tr>
<td>Specific Gravity</td>
<td>1.29 g/cm³ (White)</td>
</tr>
<tr>
<td>VOC</td>
<td>542 g/L</td>
</tr>
<tr>
<td>Temperature Resistance</td>
<td>Non-continuous: 200°C, Continuous: 100°C</td>
</tr>
</tbody>
</table>

*Practical coverage vary depending on loss factors.

**SURFACE PREPARATION**
- All surfaces to be coated should be completely clean, dry and free from contamination.
  
- Surface preparation method shall be in accordance with ISO 8504: 2000.
  
- Remove salt and other water-soluble contaminants by fresh water.
  
- Remove oil and grease with suitable detergent or solvent (SSPC-SP-1).
  
- Remove rust, mill scale and other loose material completely by abrasive blasting (ISO 8501-1:2007 Sa 2 1/2 or SSPC SP-10) or power tool cleaning (ISO8501-1 St 3 or SSPC SP3).

**APPLICATION**

- Ambient temperature shall be above 5°C and relative humidity shall be below 85%. Surface temperature shall be a minimum of 3°C above dew point.
  
- Adequate ventilation shall be provided in confined spaces to ensure proper drying.

**Mixing**
Stir each component with power agitator well before mixing. Then power mix two components.

**Mixing ratio**
Base/Hardener = 7/1 by weight

**Induction Time**
Not required

**Application Method**
- Airless spray
  
  Thinner: Tect top coat Thinner (10-20% by weight)
  
  Nozzle pressure: Not less than 10Mpa
  
  Nozzle Tip: No.163-513~717
  
  Brush/Roller
  
  Thinner: Tect top coat Thinner (0-10% by weight)
  
  Power mix thinner if required.

*Too much thinning results sagging and slower cure.*
Clean Up

Clean all the equipment with thinner immediately after use.

Pot Life

<table>
<thead>
<tr>
<th>Temperature</th>
<th>5 °C</th>
<th>20 °C</th>
<th>30 °C</th>
</tr>
</thead>
<tbody>
<tr>
<td>5°C</td>
<td>8 hour(s)</td>
<td>5 hour(s)</td>
<td>2 hour(s)</td>
</tr>
</tbody>
</table>

*Use all mixed paint within pot life.

Drying Time

<table>
<thead>
<tr>
<th>Temperature</th>
<th>5 °C</th>
<th>20 °C</th>
<th>30 °C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Surface dry</td>
<td>1 hour(s)</td>
<td>15 minute(s)</td>
<td>10 minute(s)</td>
</tr>
<tr>
<td>Touch dry</td>
<td>4 hour(s)</td>
<td>2 hour(s)</td>
<td>1 hour(s)</td>
</tr>
</tbody>
</table>

*Drying time may vary depending on film thickness, ventilation, humidity, undercoat paint condition etc.

Overcoating Interval

<table>
<thead>
<tr>
<th>Temperature</th>
<th>5 °C</th>
<th>20 °C</th>
<th>30 °C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Minimum</td>
<td>24 hour(s)</td>
<td>24 hour(s)</td>
<td>10 hour(s)</td>
</tr>
<tr>
<td>Maximum</td>
<td>7 day(s)</td>
<td>7 day(s)</td>
<td>7 day(s)</td>
</tr>
</tbody>
</table>

*The overcoating intervals are based on overcoating with same or same type of paint.

Typical undercoat: FLONTECT UNDERCOAT

Typical topcoat: -

SAFETY PRECAUTIONS

Detail information is given on Safety Data Sheet (SDS). Avoid inhalation of spray mist or vapour. Avoid skin and eye contact. Paint contacted with skin should be immediately removed with water and/or suitable cleanser. Eyes should be flushed with water and seek immediate medical attention. Since this product contains flammable solvents, keep away from sparks and open flames. Application and handling of this product should be in compliance with relevant national regulations.

STORAGE

Store in dry, cool condition and away from sources of heat and ignition. Containers must be kept tightly closed. Store conditions shall be in accordance with national regulations.

SHELF LIFE

12 months from date of production

GENERAL REMARKS

- This product is not recommended for continuous water immersion.
- Hardener is moisture sensitive and store in dry condition.
- Use Tect Top coat thinner for dilution and washing. Thinners containing alcohol cannot be used.
- Note that pot life can be shortened especially when ambient temperature is high.
- Bubbling may occur when film thickness is too high by one coat.

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