HI-ACRYL 1902 ACRYLIC TOP COAT

TECHNICAL DATA SHEET

PRODUCT DESCRIPTION

Hi-Acryl 1902 Acrylic Top Coat is a one-pack, fast-drying acrylic copolymer finish coat. It has good weatherability and hardness to provide durable performance in harsh and rugged conditions.

INTENDED USE

It is designed for use as a top coat over a suitable primer on the exterior of steel and concrete structures.

GENERAL PROPERTIES

Colour	: Limited Range of Colour
Gloss Level	: Semi-Gloss
Volume Solids, %	: 40 ± 2 %
Specific Gravity	: 1.10 – 1.35 kg/l (Mixed) depending on colours
Flash point	: 23°C
VOC	: 535 g/L (EPA Method 24)
Typical Thickness	: 40 – 60 µm dry film
	: 100 – 150 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 8501-1:2007). When abrasive blasting is not possible, mechanical cleaning to St 3 (ISO 8501-1:2007) is acceptable. After the surface preparation, patch primer prior to the application of Hi-Acryl 1902.

Hi-Acryl 1902 Acrylic Top Coat should always be applied over a recommended anti-corrosive coating scheme for metal surface. The primer surface should be dry and free from all contamination and Hi-Acryl 1902 must be applied within the overcoating intervals specified (refer to application section for details).

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.

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APPLICATION GUIDE

Mixing : Mixed thoroughly before use with a power agitator.

Theoretical Coverage : 10.0 m^2/litre at 40 µm DFT
6.7 m^2/litre at 60 µm DFT

Thinner : Hi-Pon Acrylic Thinner

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.

APPLICATION DETAILS

Airless Spray : Tip Size : 0.011" – 0.018"
Pressure at nozzle : 140 - 170 kg/cm^2

Typical Thickness : 40 – 60 µm dry film
: 100 – 150 µm wet film

Drying Time

: Substrate Temperature	25 °C	40 °C
Surface Dry	25 mins	12 mins
Through Dry	4 hrs	2 hrs
Dry to recoat (min)	4 hrs	2 hrs
Dry to recoat (max)*	Extended	

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, the 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.

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

RECOMMENDED PAINTING SYSTEM

The following coating systems are recommended for Hi-Acryl 1902 Acrylic Top Coat:

Primer:

- Hi-Vinyl 1201 Zinc Phosphate Primer
- Hi-Pon 20-03 Epoxy Red Oxide Primer
- Hi-Pon 20-04 STE 80
- Hi-Pon 20-04 STE IM 80

- Hi-Pon 20-07 Epoxy Zinc Phosphate 70
- Hi-Pon 20-10 Epoxy Zinc Phosphate 63
- Hi-Pon 90-01 Epoxy Glass Flake HB 95

Intermediate:

- Hi-Pon 30-02 Epoxy MIO 80
- Hi-Pon 30-03 Epoxy Midcoat 80

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

PACKAGING

Unit	Vol	Container Size
20 L	20 L	20 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. 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 by 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

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