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.

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

**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

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.

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.
HI-ACRYL 1902 ACRYLIC TOP COAT

APPLICATION GUIDE

Mixing: Mixed thoroughly before use with a power agitator.

Theoretical Coverage:
- 10.0 m²/litre at 40 μm DFT
- 6.7 m²/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/cm²

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-ACRYL 1902 ACRYLIC TOP COAT

TECHNICAL DATA SHEET

- 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.

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<th>PACKAGING</th>
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<td><strong>Unit</strong></td>
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<th>STORAGE</th>
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<td><strong>Shelf life</strong>: 12 months (25°C)</td>
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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.

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<th>SAFETY PRECAUTION</th>
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<td>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.</td>
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<td>Use this product in well-ventilated area, avoid skin contact, spillage on the skin should immediately be removed with suitable cleanser, soap and water.</td>
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<td>Eye should be well flush with water and seek for medical attention immediately upon contact with this product.</td>
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<td>During the application, naked flame, welding operation and smoking is not allowed. Adequate ventilation should be provided.</td>
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<td>If you have any doubt regarding the suitability of use, refer to Nippon Paint for further advice.</td>
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<td>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</td>
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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 kind of loss (whether direct or indirect) even if Nippon Paint was previously advised of it. In line with Nippon Paint's policy for continuous development, Nippon Paint reserves the right to modify the product and the information in this data sheet without prior notice. It is the user's responsibility to check with Nippon Paint for the latest version of this data sheet. This data sheet has been translated into various languages. In the event of any inconsistency, the English version shall prevail.