



# DUFLON 4F II FRESH

## TECHNICAL DATA SHEET

### PRODUCT DESCRIPTION

**Duflon 4F II Fresh** is a high class fluorine, two-pack air-cured fluorocarbon providing 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 which can be used in a wide range of environments including refineries, power plants, bridges, transportation vehicles and buildings.

### GENERAL PROPERTIES

<b>Colour</b>	: White & RAL 7035
<b>Gloss Level</b>	: Gloss
<b>Volume Solids, %</b>	: 54 ± 2 %
<b>Specific Gravity</b>	: 1.32 - 1.39 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 – 50 µm dry film : 55 – 93 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 Duflon 4F II Fresh.

Duflon 4F II Fresh 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 Duflon 4F II Fresh 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

<b>Mixing Ratio</b>	: Base : Hardener = 5 : 1 (by weight) Base and hardener should be mixed thoroughly before use.
<b>Pot Life</b>	: 25°C 6 Hrs
<b>Theoretical Coverage</b>	: 8.0 m <sup>2</sup> /kg at 50 µm DFT
<b>Thinner</b>	: Hi-Pon PU Thinner *Max 3% dilution using Hi Pon PU Thinner

### APPLICATION METHOD

Airless spray is 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.

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

<b>Airless Spray</b>	: Tip Size	: 0.011" – 0.017"
	Pressure at nozzle	: 100 - 150 kg/cm <sup>2</sup>
<b>Typical Thickness</b>	: 30 – 50 µm dry film : 55 – 93 µm wet film	
<b>Drying Time</b>	: Substrate Temperature	25 °C      40 °C
	Surface Dry	1.5 hrs      0.5 hrs
	Through Dry	7 hrs      3.5 hrs
	Cured	7 days      3 days
	Dry to recoat (min)	7 hrs      3.5 hrs
	Dry to recoat (max)	None

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 PAINTING SYSTEM

The following coating systems are recommended for Duflon 4F II Fresh:

Duflon 4F II Fresh is normally applied directly to steel; however, it can also be applied over the following primers.

#### Primer:

- Hi-Pon 20-03 Epoxy Red Oxide Primer
- Hi-Pon 20-04 STE 80 Grey

#### Intermediate/Topcoat:

- 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

Unit	Base		Hardener	
	Wt	Container Size	Wt	Container Size
15 kg	12.5 kg	18L	2.5 kg	4L

### STORAGE

**Shelf life** : Part A: 12 months (25°C)  
Part B: 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.



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- 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

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