

DUFLONAR BAKING FLUOROCARBON

High Performance Polyvinylidene Fluoride (PVDF) Coating

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TECHNICAL DATA SHEET FOR
DUFLONAR BAKING FLUOROCARBON
High Performance Polyvinylidene Fluoride (PVDF) Coating

INTRODUCTION:

Duflonar high performance polyvinylidene fluoride (PVF₂) coating is intended for use on architectural aluminium surfaces when the ultimate protection against weathering is required.

70% of the binder consist of polyvinylidene fluoride, as manufactured under the trade names of Hylar 5000 or Kynar 500 base resins. All Duflonar coatings meet or exceed all the requirements of AAMA 2605-05 "Voluntary Specification, Performance Requirements and Test Procedures for SUPERIOR PERFORMING ORGANIC COATINGS ON ALUMINIUM EXTRUSIONS AND PANELS"

Duflonar retains its properties for decades and provides protection and long-term economy with inherent advantages over other forms of coatings.

FINISH / COLOUR:

Low and Medium gloss. Standard, metallic and special colours are available upon request.

FEATURES:

- * Resistant to degradation by ultraviolet light.
- * Resistant to colour change.
- * Resistant to chalking.
- * Resistant to erosion.
- * Resistant to dirt pick-up.
- * Resistant to fungal growth.
- * Resistant to chemical and solvents.
- * Flexible for post-coating forming.
- * Low in maintenance cost for the lifetime of buildings.

DUFLONAR BAKING FLUOROCARBON

High Performance Polyvinylidene Fluoride (PVDF) Coating

RECOMMENDED APPLICATION DATA

A. SOLID COLOUR

DUFLONAR 2-COAT SYSTEM	Spray Thinner	Spray Viscosity, NK-2 cup	Dry Film Thickness, Microns	Flash Off, Minutes	Baking Condition
Duflonar Flash Primer	Duflonar Flash Primer Thinner	16 – 20 sec	5 – 10	10 – 15	-
Duflonar Finishing Coat	Duflonar Finishing Coat Thinner	20 – 25 sec	Min 25	10 – 15	240°C x 15 mins

B. METALLIC / EXOTIC COLOUR

DUFLONAR 3-COAT SYSTEM	Spray Thinner	Spray Viscosity, NK-2 cup	Dry Film Thickness, Microns	Flash Off, Minutes	Baking Condition
Duflonar Flash Primer	Duflonar Flash Primer Thinner	16 – 20 sec	5 – 10	10 – 15	-
Duflonar Finishing Coat	Duflonar Finishing Coat Thinner	20 – 25 sec	Min 25	10 – 15	-
Duflonar Clear Coat	Duflonar Top Clear Coat Thinner	18 – 20 sec	10 – 15	10 – 15	240°C x 15 mins

PLEASE NOTE:

1. Baking condition: metal temperature to achieve a minimum of 235°C for 5 mins.
2. Metal preparation and pretreatment must comply to Section 6 of AAMA 2605-05 "Voluntary Specification, Performance Requirements and Test Procedures for SUPERIOR PERFORMING ORGANIC COATINGS ON ALUMINIUM EXTRUSIONS AND PANELS"

DUFLONAR BAKING FLUOROCARBON

High Performance Polyvinylidene Fluoride (PVDF) Coating

PERFORMANCE DATA

No.	Test Item	Performance	Test Method
1.	Colour Uniformity	Shall be consistent with the colour range or numerical value established between the approval source and the applicator	Visual and instrumental check
2.	Dry film thickness	Primer: 5 – 10 microns Finishing coat: Min 25 microns Clear coat: 10 – 15 microns	-
3.	Specular Gloss, 60°	20 – 40%	ASTM D523
4.	Dry Film Hardness	Min F	ASTM D3363
5.	Adhesion, dry, wet and boiling water	No removal of paint film	Crosshatch 1/16"
6.	Impact Resistance	No removal of paint film	ASTM G14
7.	Abrasion Resistance*	Min 40	ASTM D968
8.	Muriatic Acid Resistance	No blistering, and no visual change in appearance, after 15 mins	Procedure 7.7.1.1 of AAMA 2605-05
9.	Mortar Resistance*	Mortar shall dislodge easily from painted surface. No loss of film adhesion or visual change in appearance, after 24 hrs	Procedure 7.7.2.1 of AAMA 2605-05
10.	Nitric Acid Resistance	Not more than 5 ΔE units (Hunter) of colour change according to ASTM D2244	Procedure 7.7.3.1 of AAMA 2605-05
11.	Detergent Resistance*	No loss of adhesion, no blistering and no significant visual change	Procedure 7.7.4.1 of AAMA 2605-05
12.	Window Cleaner Resistance*	No blistering or noticeable change in appearance when examined by the unaided eye and no removal of film under the tape within or outside of the cross-hatched area	Procedure 7.7.5.1 of AAMA 2605-05
13.	Humidity Resistance	Blisters, not to exceed "Few" and size No. 8	ASTM D2247, 4000 hrs
14.	Salt Spray Resistance	Minimum rating of 7 on scribe or cut edges, and a minimum blister rating of 8, according to Table 1 & 2, ASTM D1654	ASTM B117, 4000 hrs
15.	Weathering*	Colour Retention: Not more than 5 ΔE units (Hunter) of colour change according to ASTM D2244 Chalk Resistance: No more than that represented by a no. 8 ratings for colours, no. 6 for whites, based on ASTM D4214 Test Method A Gloss Retention: Shall be a minimum of 50% Resistance to Erosion: Less than 10% film loss	Florida exposure South of latitude 27 degrees North at a 45 degree angle facing South for a minimum of ten (10) years

Important Note:

- All tests except those denoted by asterisk (*) were carried out in the laboratory according to AAMA 2605-05 "Voluntary Specification, Performance Requirements and Test Procedures for SUPERIOR PERFORMING ORGANIC COATINGS ON ALUMINIUM EXTRUSIONS AND PANELS"
- Colour and finish appearance (such as gloss and etc) may vary upon factory application due to differences in spray equipment, line conditions or day-to-day process variations. It is strongly recommended that final colour approval limits be made with actual production line samples or mock-ups, not laboratory prepared colour panels. Since flake orientation contributes to colour uniformity, pearlescent, mica and metallic flake colours do present the need for more stringent control in application and consideration during project design and installation.
- We reserve the rights to modify our product specifications without prior notice.

DUFLONAR BAKING FLUOROCARBON

High Performance Polyvinylidene Fluoride (PVDF) Coating

APPROVED APPLICATORS

SINGAPORE:

Name/Address	Contact Person	Tel. No.	Fax. No.
AVA GLOBAL PTE LTD 21 Joo Koon crescent Jurong Industrial Estate Singapore 629026	Mr. Vincent Ang Chairman	6862 5770	6862 5776
BESCOAT No. 32 Tuas Ave 9, Jurong Town Singapore 639184	Ms Maggie Tan Sales & Marketing Manager	6862 5782	6863 2715
FLUOROTECH PTE LTD 23 Neythal Road Singapore 628588	Mr. H. E. Quek Sales Manager	6266 6661	6266 6636
ROTOL SINGAPORE LTD 21, Tuas Ave 6, Jurong Singapore 639308	Mr. Chou Kok Wee Asst. General Manager	6862 2921	6861 7511
QUALICOAT PTE LTD 5, Gul Drive, Singapore 629457	Mr. John Pang – Sales Manager Mr. Stephen Tan – General Manager	6365 2228	6365 2808
STARCOAT PTE LTD No. 86 International Road Singapore 629176	Mr. Ng Chong Lin Director	6262 6533	6262 2309

Note: Listed according to alphabetical order

OVERSEAS:

CHINA:

Name/Address	Contact Person	Tel. No.	Fax. No.
C.M.D ALUMINIUM INDUSTRY (SHENZHEN) CO., LTD C-1, He Yi Industry Zone, Shafu Road. Shajing Town, BaoAn District, Shenzhen, China Zip code: 518104	Mr. Thomas Lin Director & General Manager	755- 8149 9010	755- 8149 9004

Name/Address	Contact Person	Tel. No.	Fax. No.
GUANGDONG JIANMEI ALUMINIUM PROFILE FACTORY CO LTD (JMA) Fengchi Industrial Area, Dali Town, Nanhai District, Foshan City, Guangdong, China Zip code: 528231	Mr Ken Lo Export Dept	757- 8557 8592	757- 8559 9322
JINXING BUILDING MATERIALS CO LTD (GOLDSTAR GROUP) South Road, Yongfeng No. 2 Industrial Lunjiao Shunde District, Foshan City Guangdong. PR. China Zip code: 528308	Mr Peace Xie Deputy General Manager	757- 2733 0295	757- 2733 0294

MALAYSIA:

Name/Address	Contact Person	Tel. No.	Fax. No.
SEIKOTECH ARCHITECTURAL COMPONENTS SDN BHD PT 17941 Tuanku Jaafar Industrial Park, Sungai Gadut, 71450 Seremban, Negeri Sembilan D.K., Malaysia	Mr. Lee Eyu Teck Operation Manager	60-6-6782288	60-6- 6778886

THAILAND:

Name/Address	Contact Person	Tel. No.	Fax. No.
MUANG THONG ALUMINIUM INDUSTRY CO., LTD 66 M.11 Soi Vilalai, Bangna-Trad., (Km.20), Bangchalong, Bangplee, Samutprakarn 10540 Thailand	Mr. Kosit Sookkongwaree Factory Manager	662 337 2348 (5 lines)	662 337 2347
SCHIMMER METAL STANDARD CO., LTD. 1/4 Moo 7 T.Bantheaw A. Sena Ayutthaya 13110 Thailand	Mr. Piphat Kovitkanit Director / GM	66 0 3537 5080	66 0 3537 5085

Note: Listed according to alphabetical order

DUFLONAR BAKING FLUOROCARBON

High Performance Polyvinylidene Fluoride (PVDF) Coating

APPROVED APPLICATOR STATUS

Applicators of **DUFLONAR** coatings are companies who meet the following minimum requirement:

1. A multi-stage aluminium cleaning are companies and chemical pretreatment system conforming to American Architectural Manufacturers Association (AAMA) AAMA 2605-05 "Voluntary Specification, Performance Requirements and Test Procedures for SUPERIOR PERFORMING ORGANIC COATINGS ON ALUMINIUM EXTRUSIONS AND PANELS"
2. Spray equipment adequate to apply a uniform coating.
3. Oven capability to fully cure the coatings for optimum hardness, mar-resistance and weather-resistance.
4. Conduct quality control check of coated panels according to our recommended In-House Quality Control Checklist ¹.
5. On-site audit must be done before the issue of "Approved Applicator Status" certification to ensure all parameters conform to requirement. Floor plan of the coating line is also required for reference.
6. As approved applicator, the company will send production panels² for verification that the finish products continue to meet our requirements and pass AAMA 2605-05 "Voluntary Specification, Performance Requirements and Test Procedures for SUPERIOR PERFORMING ORGANIC COATINGS ON ALUMINIUM EXTRUSIONS AND PANELS"
 - (a) In-house quality control / testing of production panels.
 - (b) Description of production parameters e.g.: spray viscosity, thinner used and etc.
7. Warranty certificate will only submitted upon completion of AAMA test.

¹ Please see In-House Quality Control Checklist

² The dimension / numbers of panels required: 14 x 7cm / 8pcs and 30 x 30 / 2 pcs

DUFLONAR BAKING FLUOROCARBON

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IN-HOUSE QUALITY CONTROL CHECKLIST

Quality control checklist on completed coated panels:

No.	Test item	Performance	Test Method
1.	Cure Test / MEK Rubs	Min. 100 Rubs or 50 Cycles: No change of colour and loss of gloss	--
2.	Dry film thickness	Min 30 microns (2-coat system) Min. 40 microns (3-coat system)	--
3.	Colour vs Standard	Shall be consistent with colour range or numerical value as established between approval source and the applicator	--
4.	Specular Gloss, 60°	25 – 35%	ASTM D523
5.	Film Hardness	Min F	ASTM D3363
6.	Adhesion, wet & dry	No removal of paint film	Crosshatch 1/16"
7.	Impact Resistance	No removal of paint film	ASTM G14
8.	Acid Resistance (10% Muriatic Acid)	No blistering, and no visual change in appearance, after 15 mins	Procedure 7.7.1 of AAMA 2605-05

Note:

This is the minimum quality check items, please refer to AAMA 2605-05 for the complete list of test items.

DUFLONAR BAKING FLUOROCARBON

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PROJECTS USING DUFLONAR

SINGAPORE:

NO.	LOCATION	COLOUR CODE	COLOUR NAME
1	42 CAIRHILL CONDO	2968M	
2	AUSTRALIA HIGH COMMISSION	20872M	
3	BOSCH FACTORY	20827M	
4	BUKIT PANJANG COMPLEX	2964M	
5	CAIRHILL CONDO	20377M	
6	CATHAY CINEPLEX	20782M	
7	CHANCERY LANE CONDOMINIUM	5175E	SPANISH RED
8	CHANGI AIRPORT MRT	2968M	CODE Q
9	CHANGI AIRPORT TERMINAL 1	20856E	
10	CHANGI AIRPORT TERMINAL 3	20769M	
11	CHAO YANG FACTORY	5279E	MEDIUM PINK
12	CHINA SQUARE	2964M	SC 5000
13	CHURCH STREET	20480M	
14	COURTS FURNITURE MALL	10301E	
15	COURTS FURNITURE MALL	20087M	
16	DHOBY GHAUT MRT INTERCHANGE	10238E	
17	FHTK COLDSTORE	1712E	IVORY
18	FHTK COLDSTORE	7379E	REGAL BLUE
19	FRAMEWORK FACTORY	5171E	APRICOT TONE
20	FRAMEWORK FACTORY	8204E	CHAROKE BLUE
21	FURAMA HOTEL	20377M	
22	GOLDBELL TOWER	3461M	
23	HARBOURFRONT	2968M	CODE Q
24	HARDROCK HOTEL – SENTOSA	5795E	
25	HARDROCK HOTEL – SENTOSA	8903E	
26	HDB BEDOK	1893E	LIGHT GREY
27	HDB BEDOK	9241E	OCEAN BLUE
28	HDB BUKIT BATOK N6C3	6183M	OLIVE SHEEN
29	HDB BUKIT BATOK N6C3	6200M	DARK BRONZE METALLIC
30	HDB PUNGGOL EAST	1927E	
31	HDB WOODLANDS	9418E	COSMIC BLUE
32	HEEREM	2921M	CHAMPAGNE METALLIC
33	HIGH TECH FACTORY	5239E	BANNER RED
34	HONDA SHOWROOM	2964M	
35	IKEA	1590E	LIGHT GREY
36	INLAND REVENUE HOUSE	2562E	SILVER STREAK
37	INTERNATIONAL BUSINESS PARK	20480M	
38	IOH/NDC SPACEFRAME	8348E	MID GREEN
39	ISTANA PARK	2909E	LIGHT GREY
40	JPH BRUNEI	1941E	IVROY
41	KAKI BUKIT TECH PARK	8324E	SMART GREEN
42	KATONG MALL	1882M	SILVER METALLIC
43	KPE VENTILATION HOUSE	2968M	
44	KRANJI MRT	8165E	AGED COPPER
45	LKN BUILDING	20480M	

NO.	LOCATION	COLOUR CODE	COLOUR NAME
46	MAPLE TREE DISTRICT PARK	20480M (2)	
47	MARGATED FACTORY	8179E	HARTFORD GREEN
48	MAYBANK	2968M	
49	MAYBANK	20087M	
50	MRT – JOO KOON	7133E	
51	MRT – JOO KOON	2968M	
52	MRT – PIONEER ROAD NORTH	2968M	
53	MRT – PIONEER ROAD NORTH	9240E	
54	MRT CIRCLE LINE CIVIC CENTRE	2968M	
55	NATIONAL UNIVERSITY HOSPITAL	1712E	IVORY
56	NOVENA SQUARE	2964M	SC 5000
57	NTU ADMIN ANNEX	2954E	SEAL GREY
58	NTU ADMIN ANNEX	3365E	MEDIUM GREY
59	NUS DUKE	3882M	SILVER GREY
60	NUSANTARA	2591M	GLACIER GREY
61	ORCHARD CENTRAL	20927M	
62	OVERSEA UNION HOUSE	20480M (2)	
63	PARAGON SHOPPING CENTRE	2964M	
64	PARKVIEW SQUARE	6200M	
65	PARKVIEW SQUARE	6481M	
66	PEIRCE VILLA	6170E	COLONIAL GREY
67	PONTIAC MARINA	2918E	LIGHT GREY
68	PUNGGOL MRT INTERCHANGE	2968M	
69	PUNGGOL MRT INTERCHANGE	20087M	
70	QUEEN STREET	1712E	IVORY
71	QUEEN STREET	5267E	RED
72	QUEEN STREET	9174E	TUSCANY BLUE
73	RAFFLES JUNIOR COLLEGE	8300E	
74	REPUBLIC POLYTECHNIC	20844M	
75	RIVERSIDE CONDOMIUM	9385E	BLUE
76	SAKATA	3352E	PEWTER CUP
77	SATS-MC2	3294E	CHARCOAL GREY
78	SELEGIE COMPLEX	20908M	
79	SPH BUILDING	20402M	
80	ST JAMES POWER STATION LINKWAY	2595M	
81	ST REGIS CONDO	20863M	
82	STAMFORD COURT	1712E	IVORY
83	TELETECH PARK	2964M	SC 5000
84	THE EXCHANGE	2968M	CODE Q
85	THE SAIL	3854E	ARMOUR GREY
86	THE SAIL	20893E	SAIL GREY
87	TOMLINSON CONDO	3675E	
88	TURQUOISE CONDO – SENTOSA	10574E	
89	UBI TECHPARK	20402M	
90	UE SQUARE	2968M	
91	UE SQUARE	2964M	SILVER METALLIC
92	UOB PLAZA	3840M	
93	W & T LOGISTICS	2936E	SEAFOAM GREY
94	WOODLAND CHECKPOINT	9254M	
95	WOODLAND CHECKPOINT	3254E	
96	YEW TEE STATION	8165E	AGED COPPER

OVERSEAS:

NO.	LOCATION	COLOUR CODE	COLOUR NAME
1	BEIJING, CEROIL PLAZE	1712E	IVORY
2	HONG KONG, ATUO PLAZA	1831E	OFF WHITE
3	HONG KONG, HHML	1718E	JURONG BEIGE
4	HONG KONG, HOI CHENG BUILDING	8302E	INTERSTATE GREEN
5	HONG KONG, MACDONNELL ROAD	8159E	INTERSTATE GREEN
6	HONG KONG, NAM ON STREET	8370E	INTERSTATE GREEN
7	HONG KONG, SHAM TSENG	8129E	TAYLOR GREEN
8	JAPAN, EHOSHIMA	6275E	GREY
9	JAPAN, ODAKYU SAGAMI	1892E	OFF WHITE
10	JAPAN, SAIPAN CNS GULF RESORT	2979M	LIGHT METALLIC
11	JAPAN, YAYASAN CARPARK	3338E	SILVER GREY
12	SHANGHAI, NANCHANG TOBACCO	2776E	SANDSTONE
13	SHANGHAI, NANCHANG TOBACCO	6269M	COPPER METALLIC
14	SHANGHAI, NCKU	9385E	BLUE
15	SHANGHAI, SUPREME HOUSE	1927E	MIST WHITE
16	YANGON AIRPORT	3771E	
17	VIETNAM AIRPORT	20860M	

**TECHNICAL DATA SHEET FOR
DUFLONAR FLASH PRIMER****INTRODUCTION:**

A polyvinylidene fluoride yellow primer that is necessary to ensure good adhesion and anti-corrosive property on aluminium substrate for the Duflonar Baking Fluorocarbon system.

PAINT SPECIFICATION:

Non-volatile	:	Min 40% by weight
Packing	:	20 litres
Specific Gravity	:	1.30 ± 2% kg/litre
Supplied Viscosity	:	65 ± 2 ku

APPLICATION:

Pretreatment	:	The aluminium shall be cleaned & pretreated by a multi-stage system to meet ASTM D1730, Type B, method 5 or 7. Processing must comply with ASTM B449, Section 6, Class I.
Paint Preparation	:	The paint should be thoroughly stirred to a homogenous consistency before use. It is suitable for ordinary air spray, airless spray and electrostatic spray painting application.
Thinner	:	Duflonar Flash Primer Thinner
Spray Viscosity	:	16 – 20 sec NK-2 cup (10-20% dilution)
Flash Off	:	5 – 10 minutes
Film Thickness	:	Recommended dry film thickness of 5 – 10 microns

**TECHNICAL DATA SHEET FOR
DUFLONAR FLASH PRIMER**

Theoretical coverage * : 30 m²/litre

Practical coverage * : 25 m²/litre (20% loss factor)

* Calculation based on film thickness of 10 microns per coat.

IMPORTANT NOTE:

It contains volatile and flammable solvents, ensure adequate ventilation during use and avoid using near fire. Values given as average for reference.

**TECHNICAL DATA SHEET FOR
DUFLONAR SOLID COLOUR****INTRODUCTION:**

A polyvinylidene fluoride finishing coat for the Duflonar Baking Fluorocarbon system. It contains 70% Hylar 5000 / Kynar 500 in the binder. Duflonar Flash Primer must be used as the base coat.

PAINT SPECIFICATION:

Non-volatile	:	Min 45% by weight
Packing	:	20 litres
Specific Gravity	:	1.20 ± 2% kg/litre
Supplied Viscosity	:	65 ± 2 ku

APPLICATION:

Pretreatment	:	The aluminium shall be cleaned & pretreated by a multi-stage system to meet ASTM D1730, Type B, method 5 or 7. Processing must comply with ASTM B449, Section 6, Class I.
Paint Preparation	:	The paint should be thoroughly stirred to a homogenous consistency before use. It is suitable for ordinary air spray, airless spray and electrostatic spray painting application.
Thinner	:	Duflonar Finishing Coat Thinner
Spray Viscosity	:	20 – 25 sec NK-2 cup (10-20% dilution)
Flash Off	:	5 – 10 minutes

**TECHNICAL DATA SHEET FOR
DUFLONAR SOLID COLOUR**

Film Thickness : Recommended dry film thickness of minimum 25 microns. Dry film thickness of full system must be minimum 30 microns.

Theoretical coverage* : 7.5m²/litre

Practical coverage* : 6.0 m²/litre (20% loss factor)

* Calculation based on film thickness of 25 microns per coat.

IMPORTANT NOTE:

It contains volatile and flammable solvents, ensure adequate ventilation during use and avoid using near fire. Values given as average for reference.

**TECHNICAL DATA SHEET FOR
DUFLONAR METALLIC / EXOTIC COLOUR****INTRODUCTION:**

A polyvinylidene fluoride finishing coat for the Duflonar Baking Fluorocarbon system. It contains 70% Hyar 5000 / Kynar 500 in the binder. To be used with Duflonar Flash Primer as the base coat and Duflonar Top Clear Coat as the overcoat.

PAINT SPECIFICATION:

Non-volatile	:	Min 40% by weight
Packing	:	20 litres
Specific Gravity	:	1.1 ± 2% kg/litre
Supplied Viscosity	:	65 ± 2 ku

APPLICATION:

Pretreatment	:	The aluminium shall be cleaned & pretreated by a multi-stage system to meet ASTM D1730, Type B, method 5 or 7. Processing must comply with ASTM B449, Section 6, Class I.
Paint Preparation	:	The paint should be thoroughly stirred to a homogenous consistency before use. It is suitable for ordinary air spray, airless spray and electrostatic spray painting application.
Thinner	:	Duflonar Finishing Coat Thinner
Spray Viscosity	:	20 – 25 sec NK-2 cup (10-20% dilution)
Flash Off	:	5 – 10 minutes

**TECHNICAL DATA SHEET FOR
DUFLONAR METALLIC / EXOTIC COLOUR**

Film Thickness	:	Recommended dry film thickness of minimum 25 microns. Dry film thickness of full system must be minimum 40 microns.
Theoretical coverage*	:	7.5 m ² /litre
Practical coverage*	:	6.0 m ² /litre (20% loss factor)

*Calculation based on dry film thickness of 25 microns per coat.

IMPORTANT NOTE:

It contains volatile and flammable solvents, ensure adequate ventilation during use and avoid using near fire. Values given as average for reference.

**TECHNICAL DATA SHEET FOR
DUFロンAR TOP CLEAR COAT****INTRODUCTION:**

A polyvinylidene fluoride clear overcoat for the Duflonar Baking Fluorocarbon system. It contains 70% Hylar 5000 / Kynar 500 in the binder. As a overcoat for metallic or exotic finishing coat.

PAINT SPECIFICATION:

Non-volatile	:	Min 40%
Packing	:	20 litres
Specific Gravity	:	1.00 ± 0.05
Supplied Viscosity	:	65 ± 2 ku

APPLICATION:

Pretreatment	:	The aluminium shall be cleaned & pretreated by a multi-stage system to meet ASTM D1730, Type B, method 5 or 7. Processing must comply with ASTM B449, Section 6, Class I.
Paint Preparation	:	The paint should be thoroughly stirred to a homogenous consistency before use. It is suitable for ordinary air spray, airless spray and electrostatic spray painting application.
Thinner	:	Duflonar Top Clear Thinner
Spray Viscosity	:	18 – 20 sec NK-2 cup (10-20% dilution)
Flash Off	:	5 – 10 minutes

**TECHNICAL DATA SHEET FOR
DUFロンAR TOP CLEAR COAT**

Film Thickness : Recommended dry film thickness of minimum 10 microns. Dry film thickness of full system must be minimum 40 microns.

Theoretical coverage* : 30 m²/litre

Practical coverage* : 25 m²/litre (20% loss factor)

* Calculation based on film thickness of 10 microns per coat.

IMPORTANT NOTE:

It contains volatile and flammable solvents, ensure adequate ventilation during use and avoid using near fire. Values given as average for reference.