



# HI-PON 300HT PRIMER

## TECHNICAL DATA SHEET

### PRODUCT DESCRIPTION

**Hi-Pon 300HT Primer** is a one-pack, silicone acrylic based coating which can withstand dry heat temperature up to 300°C.

### INTENDED USE

It is designed for use as a primer for long-term corrosion protection of steel exposed to high temperature (below 300°C). Suitable for use in exhaust manifolds, furnaces, boiler, chimneys and other installations exposed to high temperatures.

### GENERAL PROPERTIES

<b>Colour</b>	: Grey
<b>Gloss Level</b>	: Matt
<b>Volume Solids, %</b>	: 40 ± 2%
<b>Specific Gravity</b>	: 1.68 kg/l
<b>Flash point</b>	: 7°C
<b>VOC</b>	: 554 g/l (EPA Method 24)
<b>Typical Thickness</b>	: 20 – 30 µm dry film : 50 – 75 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.

#### Abrasive Blast Cleaning

Abrasive blast cleaning to Sa 2½ (ISO 8501-1:2007) or SSPC-SP6. For optimum performance, blast cleaned to SSPC-SP10 with a surface profile of 50 – 75 microns (2 – 3 mils). If oxidation has occurred between the blasting and application of this product, the surface should be re-blasted to the specified visual standard. Surface defect revealed by the blast cleaning process should be ground, filled or treated in the appropriate manner. For galvanised and light alloys, thorough degreasing is necessary.

#### 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, the application of Hi-Pon 300HT Primer can be performed.

Hi-Pon 300HT Primer should be applied over a surface that is dry and free from dirt, grease, oil and other contaminants and 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.



# HI-PON 300HT PRIMER

## TECHNICAL DATA SHEET

### CONDITION DURING APPLICATION

Avoid paint application when the temperature is below 10°C and relative humidity is over 85%. The temperature of steel surface must be a minimum 3°C above dew point of surrounding air.

### APPLICATION GUIDE

**Mixing** : Mixed thoroughly before use with a power agitator.

**Theoretical Coverage** : 20.0 m<sup>2</sup>/litre at 20 µm DFT  
13.3 m<sup>2</sup>/litre at 30 µm DFT

**Thinner** : Hi-Pon HT 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 : 0.015" – 0.017"  
Pressure at nozzle : 140 – 170 kg/cm<sup>2</sup>

**Typical Thickness** : 20 – 30 µm dry film  
: 50 – 75 µm wet film

**Drying Time** : Substrate Temperature : 25°C      40°C  
Surface Dry : 0.5 hrs      0.2 hrs  
Through Dry : 2 hrs      1 hrs  
Dry to recoat (min) : 2 hrs      1 hrs  
Dry to recoat (max) : 30 days      14 days

Freshly applied Hi-Pon 300HT Primer may have slightly reduced mechanical properties. This effect can however be overcome by heating the paint system to 200°C for 1 hour.

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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## TECHNICAL DATA SHEET

### RECOMMENDED PAINTING SYSTEM

The following coating system is recommended:

#### Coating System 1

- Hi-Pon 300HT Primer, 1 coat x 25 µm dry film thickness
- Hi-Pon 300HT Top Coat, 2 coats x 30 µm dry film thickness

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

### PACKAGING

Unit	Vol	Container Size
4.8 L	4.8 L	5 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 of 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

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TECHNICAL DATA SHEET

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