

● **PAINT PROPERTIES**

ITEM	V-FLON#2000 TOP COAT		CF PRIMER
Color	Each color	Clear	White, Gray
Package	1 Component		1 Component
Gloss (60°)	Over 30% gloss		Over 30% gloss
Specific gravity 23°C (73.4° F)	1.24	1.00	1.15
Viscosity 23°C (73.4° F)	95 sec (Ford cup #4)		80 sec (Ford cup #4)
Solids content	56%	39%	49%
Baking conditions	160°C(320° F) × 20 min		Wet on wet or 160°C(320° F) × 20 min
Recommended dry film Thickness per coat	40 μm (20 μm/ Twice)	15 μm/Once	30 μm/Once
Flash point	22°C (71.6° F)		27°C (80.6° F)
Ignition point	370°C (697.9° F)		240°C (464° F)
Explosion limit	1.1~15.0% (vol)		1.1~11.8% (vol)
Fire prevention law	Type 4 class 2 oil		Type 4 class 2 oil
Labor safety hygiene law	Organic provisions (type 2 organic solvents)		Organic provisions (type 2 organic solvents)
Hazardous substances	<ul style="list-style-type: none"> • Xylene • Methyl Isobutyl Ketone • Butyl Acetate 		<ul style="list-style-type: none"> • Xylene • Ethyleneglycol Monobutyl Ether • n-Butyl Alcohol
Curing agent display	—		Epoxy resin

● **PAINTING SPECIFICATION**

ITEM		V-FLON#2000 TOP COAT (BAKING TYPE)
Substrate		Aluminum curtain wall
Surface preparation		Chromate treatment
Primer		CF PRIMER
Drying condition		Wet on wet
Top coat		V-FLON#2000 TOP COAT
Drying condition		160°C(320° F) × 20 min
Gloss (60°)		80
Dry film Hardness		2H
Adhesion test (Checkers test (1mm))		10
Erichsen test (5mm)		Pass
Impact resistance (Du pont method) 1/2in ϕ × 500g × 50cm		Pass
Bending test (3mm)		Pass
Contamination resistance (magic marker, Red · Black)		Pass
Chemical resistance	5% sulfuric acid for two months	Pass
	5% muriatic acid for two months	Pass
	5% caustic soda for two months	Pass
Humidity resistance (rotary type) 98%R.H./50°C(122° F) × 3000 hr		Pass
Boiling water test (5hr)		Pass
Corrosion resistance (Salt spray test , 3000hr)		Pass
The second physical properties	Boiling water test (5hr later)	Pass
	Humidity resistance (3000hr later)	Pass
	Salt spray test (3000hr later)	Pass
	Accelerated weathering test (500hr later)	Pass
Accelerated weathering test (Sunshine carbon arc lamp method)	3000hr Gloss retention	Over 90%
	5000hr Gloss retention	Over 80%

● **ALUMINUM BAKING PAINTING**

PROCESS		CONTENT OF WORK	VISCOSITY (IHS cup NK-2)	FILM THICKNESS (μ m)
1	Surface preparation	Removing fat-chromate treatment	-	-
2	Air blow	Gorbage etc. are removed.	-	-
3	CF PRIMER	Dilution Thinner : CF PRIMER THINNER	Air spray 20-25 sec Electrostatic spray 15-25 sec	5-10
4	Setting	10-20 min	-	-
5	V-FLON#2000 TOP COAT	Dilution Thinner : V-FLON#2000 THINNER	Air spray 20-25 sec Electrostatic spray 15-25 sec	15-20
6	Setting	10-20 min	-	-
7	V-FLON#2000 TOP COAT	Dilution Thinner : V-FLON#2000 THINNER	Air spray 20-25 sec Electrostatic spray 15-25 sec	Over 20
8	Setting	10-20 min	-	-
9	Baking	160°C(320°F) × 20 min (material temperature)	-	-