

Hardtop Smart Pack

Product description

This is a two component chemically curing modified acrylic coating. The product does not contain isocyanates, neither does it generate di-isocyanates during hotwork / welding or fire. It has a glossy finish with good gloss retention. It can be used direct to metal. 1:1 mixing ratio for easy use and reduced wastage. Specially designed for application with brush and roller.

Scope

The Application Guide offers product details and recommended practices for the use of the product.

The data and information provided are not definite requirements. They are guidelines to assist with efficient and safe use, and optimum service of the product. Adherence to the guidelines does not relieve the applicator of responsibility for ensuring that the work meets specification requirements. Jotuns liability is in accordance with general product liability rules.

The Application Guide (AG) must be read in conjunction with the relevant specification, Technical Data Sheet (TDS) and Safety Data Sheet (SDS) for all the products used as part of the coating system.

Referred standards

Reference is generally made to ISO Standards. When using standards from other regions it is recommended to reference only one corresponding standard for the substrate being treated.

Application

Acceptable environmental conditions - before and during application

Before application, test the atmospheric conditions in the vicinity of the substrate for the dew formation according to ISO 8502-4.

Air temperature	5 - 50	°C
Substrate temperature	5 - 60	°C
Relative Humidity (RH)	10 - 85	%

The following restrictions must be observed:

- Only apply the coating when the substrate temperature is at least 3 °C (5 °F) above the dew point
- Do not apply the coating if the substrate is wet or likely to become wet
- Do not apply the coating if the weather is clearly deteriorating or unfavourable for application or curing
- Do not apply the coating in high wind conditions

Product mixing

Product mixing ratio (by volume)

Hardtop Smart Pack Comp A	1 part(s)
Hardtop Smart Pack Comp B	1 part(s)

Product mixing

Component A to be separately mixed to a homogenous material. A flat spatula or flat, wooden stick might be suitable as mixing tools. Mix thoroughly the total blend (comp A + comp B) until a homogeneous body is obtained, including all material on the wall of the container.

Induction time and Pot life

Paint temperature	23 °C
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Pot life	4 h
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The temperature of base and curing agent is recommended to be 18 °C or higher when the product is mixed.

Thinner/Cleaning solvent

Thinner: Jotun Thinner No. 17

Application data

Spray application

Airless spray may be used.

Other application tools

Brush application

Suitable for application with brush. Use a high quality, clean natural or synthetic bristle brush with proper shape and size. When used as primer coat, a stiff brush is recommended to secure proper substrate wetting. When used as a finish coat a more long haired brush is recommended to improve flow and appearance. To achieve specified dry film thickness it may be necessary to apply multiple coats.

Roller application

Suitable for application with roller. Use a properly sized, high quality, clean roller with natural or synthetic cover. Pre-wash new rollers in proper thinner to remove loose fibres. Roller is not recommended for application of primer coat. Addition of small volumes (5-10 %) of thinner will improve appearance when used as finish coat. To achieve specified dry film thickness it may be necessary to apply multiple coats.

Film thickness per coat

Typical recommended specification range

Dry film thickness	60	-	120	µm
Wet film thickness	100	-	200	µm
Theoretical spreading rate	9.6	-	4.8	m ² /l

Bright colours may need film thickness in the high end of the recommended specification range to achieve opacity.

Drying and Curing time

Substrate temperature	5 °C	10 °C	23 °C	40 °C
Surface (touch) dry	6 h	4 h	2.5 h	2 h
Walk-on-dry	25 h	20 h	10 h	5 h
Dry to over coat, minimum	25 h	20 h	10 h	5 h
Dried/cured for service	28 d	14 d	12 d	3 d

Drying and curing times are determined under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product.

Surface (touch) dry: The state of drying when slight pressure with a finger does not leave an imprint or reveal tackiness.

Walk-on-dry: Minimum time before the coating can tolerate normal foot traffic without permanent marks, imprints or other physical damage.

Dry to over coat, minimum: The recommended shortest time before the next coat can be applied.

Dried/cured for service: Minimum time before the coating can be permanently exposed to the intended environment/medium.

Maximum over coating intervals

Maximum time before thorough surface preparation is required. The surface must be clean and dry and suitable for over coating. Inspect the surface for chalking and other contamination and if present, remove with an alkaline detergent. Agitate the surface to activate the cleaner and before it dries, wash the treated area by low-pressure water cleaning using fresh water.

If maximum over coating interval is exceeded the surface should in addition be carefully roughened to ensure good inter coat adhesion.

Note: When recoating Hardtop XP after more than one day, the surface should be carefully roughened to ensure good intercoat adhesion.

Areas for atmospheric exposure

Average temperature during drying/curing	5 °C	10 °C	23 °C	40 °C
Itself	6 mth	5 mth	4 mth	2 mth

Areas for immersed exposure

Average temperature during drying/curing	5 °C	10 °C	23 °C	40 °C
Itself	21 d	18 d	14 d	14 d

Finish

The application process of a top-coat product significantly influences its final finish and gloss. Techniques like brushing, rolling, and spraying each have unique impacts, with spraying generally providing the smoothest and most uniform finish. Environmental factors such as temperature, humidity, and air flow also will also effect the appearance of the coating. Additionally, the quality and maintenance of tools, including brushes, rollers, and spray guns, is important. Properly calibrated and clean tools ensure a smooth application, free of imperfections.

Quality assurance

The following information is the minimum required. The specification may have additional requirements.

- Confirm that all welding and other metal work has been completed before commencing pre-treatment and surface preparation
- Confirm that installed ventilation is balanced and has the capacity to deliver and maintain the RAQ
- Confirm that the required surface preparation standard has been achieved and is held prior to coating application
- Confirm that the climatic conditions are within recommendations in the AG, and are held during the application
- Confirm that the required number of stripe coats have been applied
- Confirm that each coat meets the DFT requirements in the specification
- Confirm that the coating has not been adversely affected by rain or other factors during curing
- Observe that adequate coverage has been achieved on corners, crevices, edges and surfaces where the spray gun cannot be positioned so that its spray impinges on the surface at 90° angle
- Observe that the coating is free from defects, discontinuities, insects, abrasive media and other contamination
- Observe that the coating is free from misses, sags, runs, wrinkles, fat edges, mud cracking, blistering, obvious pinholes, excessive dry spray, heavy brush marks and excessive film build
- Observe that the uniformity and colour are satisfactory

All noted defects shall be fully repaired to conform to the coating specification.

Caution

This product is for professional use only. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly and according to Jotun's technical documentation. Applicators and operators shall use appropriate personal protection equipment when using this product. This guideline is given based on the current knowledge of the product. Any suggested deviation to suit the site conditions shall be forwarded to the responsible Jotun representative for approval before commencing the work.

For further advice please contact your local Jotun office.

Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not inhale spray mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

Accuracy of information

Always refer to and use the current (last issued) version of the TDS, SDS and if available, the AG for this product. Always refer to and use the current (last issued) version of all International and Local Authority Standards referred to in the TDS, AG & SDS for this product.

Colour variation

When applicable, products primarily meant for use as primers or antifoulings may have slight colour variations from batch to batch. Such products and epoxy based products used as a finish coat may chalk when exposed to sunlight and weathering.

Colour and gloss retention on topcoats/finish coats may vary depending on type of colour, exposure environment such as temperature, UV intensity etc., application quality and generic type of paint. Contact your local Jotun office for further information.

Reference to related documents

The Application Guide (AG) must be read in conjunction with the relevant specification, Technical Data Sheet (TDS) and Safety Data Sheet (SDS) for all the products used as part of the coating system.

When applicable, refer to the separate application procedure for Jotun products that are approved to classification societies such as PSPC, IMO etc.

Symbols and abbreviations

min = minutes	TDS = Technical Data Sheet
h = hours	AG = Application Guide
d = days	SDS = Safety Data Sheet
°C = degree Celsius	VOC = Volatile Organic Compound
° = unit of angle	MCI = Jotun Multi Colour Industry (tinted colour)
µm = microns = micrometres	RAQ = Required air quantity
g/l = grams per litre	PPE = Personal Protective Equipment
g/kg = grams per kilogram	EU = European Union
m ² /l = square metres per litre	UK = United Kingdom
mg/m ² = milligrams per square metre	EPA = Environmental Protection Agency
psi = unit of pressure, pounds/inch ²	ISO = International Standards Organisation
Bar = unit of pressure	ASTM = American Society of Testing and Materials
RH = Relative humidity (% RH)	AS/NZS = Australian/New Zealand Standards
UV = Ultraviolet	NACE = National Association of Corrosion Engineers
DFT = dry film thickness	SSPC = The Society for Protective Coatings
WFT = wet film thickness	PSPC = Performance Standard for Protective Coatings
	IMO = International Maritime Organization
	ASFP = Association for Specialist Fire Protection

Disclaimer

The information in this document is given to the best of Jotun's knowledge, based on laboratory testing and practical experience. Jotun's products are considered as semi-finished goods and as such, products are often used under conditions beyond Jotun's control. Jotun cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Jotun reserves the right to change the given data without further notice.

Users should always consult Jotun for specific guidance on the general suitability of this product for their needs and specific application practices.

If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail.