BERGER PROTECTON
PROTECTIVE COATINGS DIVISION

BR Fluorothane HS Finish

Two pack Fluoropolymer based paint

Issue Date : May 2025

Product Description

A ultra durable, premium fluoro-polymer urethane coating that cures under ambient conditions to impart superior colour and gloss retention apart from being chemical resistant and used as a finsh for Steel substrate.

Usage Areas

BR Fluorothane HS Finish has been designed as a topcoat with outstanding weathering properties. Used as a topcoat of Fluororesin paint system for various infrastructure projects of metro, railways station steel structures, stadium , tank externals, bridges, airports & architectural structures

Product Data

Composition	Fluoropolymer resin suitably cured and pigmented
Volume Solids	66 ± 2%
VOC	320 gms/ltr
Mixing Ratio	Base : Catalyst - 8:1 by volume
Application Method	Brush, Spray
Recommended DFT	30 - 70 µ per coat
Recommended WFT	45 - 106 µ per coat
Theoretical Spreading Rate	9.4 - 22 m^2/ltr/coat
Colour	Assorted Shades
Finish	Glossy

Practical Coverage : Dependent on-site condition and transfer losses due to substrate design, profile, wind, heights, application method, painter's skill etc.

Pot Life

10°C	15°C	25°C	40°C
7 hrs	5 hrs	3 hrs	2 hrs

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Typical Coating Systems

Systems compatibility can be provided on request to the Technical Service Team

Coats	Generic Systems	Compatible Products
Primer	Inorganic Zinc, Zinc Rich, Zinc Phosphate, Epoxy Clear, Epoxy Surface tolerant	Zinc anode 304, Epilux 65 ZR, Epilux 45 ZNPH, Epilux PSC Tie-Coat, Epilux 4 clear
Mid Coat	Epoxy MIO, Epoxy Intermediate	Epilux 455 HB MIO, Epilux 4 HB MIO, Epilux 485 HB Intermediate, Protecton HB INT Coating
Top Coat	Fluorothane Undercoat	BR Fluorothane HS Undercoat

Pack size

	UOM	Part A	Part B	Total
Volume	Lt/Kg	8 ltr	1 ltr	9 ltr

Storage

DO NOT expose to direct rain/ sunlight. Note : Storage life @23°C will be extended up to 24 months. Storage at elevated temperatures may reduce shelf life; and never exceed maximum room temperature of 40°C. Thereafter, subject to reinspection; consult tech-service.

Shelf life

Up to 12 months as long as the sealed original containers are kept under cover in a dry place under normal temperature conditions until use.

Note :

1. Storage life @23°C will be extended up to 24 months. Storage at elevated temperatures may reduce shelf life; and hence never exceed maximum room temperature of 40°C. Storage life, thereafter, subject to re-inspection; consult tech-service.
2. It may be noted that higher volume solid material will tend to soft settling on long term storage, and it can made to a normal homogeneous consistency by use of a slow speed 200-400 rpm power stirrer particularly in the PART A (BASE) container; and this soft settling is not considered as a failure of keeping properties.

Flash Point

Part A	Part B	Mixed Paint
22°C	22°C	22°C

Health & Safety

Please refer to the separate Safety Data Sheet available with detailed information.

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APPLICATION GUIDELINE

Substrate	Steel	
Surface preparation	**Steel** : Remove grease, oil and other contaminants preferably by Solvent Cleaning to SSPC SP1. Abrasive blast clean to a minimum of SSPC SP10 with a surface profile as defined for the respective primer. Before applying the finish coating,make use of methods to de-dusting, water jet washing to remove contaminants if any. In case of maintenance make full use of echanical tools alongwith manual chipping and wire brushing to remove loose rust and scale to SSPC SP2/SP3and use proper maintenance coating primers. Surface should be dry and clean before application of paint.	
Atmospheric Condition	Ventilation	Suitable air engineering systems, which will ensure reduction of air contaminants and thatto further help regulate the temperature and humidity of the working environment.
	Dew Point	Ensure surface temperature to be more than 3°C over the dew point temperature.
	Humidity	Do not apply when relative humidity rises above 85%.
Mixing	Stir the base thoroughly and then mix base to a homogenous mixture and then add recommended part of catalyst to uniform consistency. NOTE : DO NOT ADD THINNER beyond recommendation as it will reduce mixed VS calling for revised WFT calculations as well as challenges on flow properties.	
Thinner	Thinner 825	

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Application

Stir the container well using a low speed stirrer thoroughly before and during use.
Brush : Apply preferably without thinning. If required, add upto 5% Thinner 825.
Conventional Spray : Apply with not more than 2-5% Thinner 825. Use any standard equipment at an atomising pressure of 4.2-4.9 Kg/cm^2 using a Handgun with 66 fluid tip, 70 thou Orifice.
Airless spray : Add upto 5% Thinner 825 if requir red. Use any standard equipment having pump ratio 30 :1.
Tip size : 0.28.0.38 mm **Tip pressure :** 110-160 kg / cm^2.

Work Stoppage

Ensure to use the mixed paint within pot life as there are no methods to increase working pot life. Keep the working tools and tips free of drying and clogging. Always use fresh material and never add-up to previous mixed paints.

Clean Up

Clean all equipment immediately after use with thinner 844. It is good working practices to flush or clean all the spray equipment periodically.All the surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations.

Drying Time

Temperature	Touch Dry	Handle Dry	Hard Dry
10°C	2 hrs	12 hrs	18 hrs
23°C	1 hrs	8 hrs	14 hrs
30°C	45 min	7 hrs	12 hrs
40°C	30 min	6 hrs	9 hrs

Over Coating Intervals

	@23°C	@30°C
MIN	8 hrs	6 hrs
MAX	2 weeks	7 days

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Curing Time	7 days NOTE : Drying and Curing times are determined under controlled temperatures and at relative humidity below 85%, for the NDFT of the product.
Inspection	Refer SSPC PA2 guidelines for measurement of DFT. Do not conduct any destructive test like peel off/ pull off & high voltage Holiday test unless and otherwise mandatory in the specification. Consult Technical Service team for preparation of QAP (Quality Assurance plan).
Repair Methodology	Clean off loose paints, debris, contaminants and ensure spot repair with available tools as practiced in hand/ power tool cleaning using wire brush/buffing, emery/feathering to smoothen the edges of impaired areas. Use appropriate touch up primer followed by recommended coating system, allowing due over coating interval time to area of 2-3 inches in excess of the spot repaired portion.
Product Characteristics	• BR Fluorothane HS Finish provides excellent resistance to both splash and spillage exposure and mild fumes or external exposure, maintaining superior performance when in contact with salt and water. • It demonstrates very good resistance to splash and spillage as well as to mild fumes or external exposure from acids, alkalis, and solvents. • BR Fluorothane HS Finish withstands continuous temperatures up to 90°C. • Flexibility is very good, allowing movement without damage. • Abrasion resistance is excellent, ensuring long-lasting wear protection. • It delivers outstanding durability in harsh weather conditions.
Disclaimer	The information contained within this Data Sheet is based on information believed to be reliable at the time of its preparation. The Company will not be liable for loss or damage howsoever caused including liability for negligence, which may be suffered by the user of the data contained herein. It is the users' responsibility to conduct all necessary tests to confirm the suitability of any product or system for their intended use. No guarantee of results is implied since conditions of use are beyond our control.