NMI COATING

PRODUCT DATA
NMI 680113.

PRODUCT DESCRIPTION:

TWO COMPONENT EPOXY PHENOLIC PRIMER NMI680113.

CURING AGENT (4200530)

NMI EPOXY PRIMER COAT 680113: is designed for use as a semi flat primer base on epoxy and polyamine resins and inert pigments with an excellent barrier efficiency in moderate and in door environment.

NMI EPOXY PRIMER COAT 680113: very good adhesion and high temperature water and chemical resistance.

Standard color availability: Manufactured according RAL catalogue. When exposed to direct sun light in outdoor service become discolor and decrease of gloss.

GENERAL PROPERTIES:

Adhesion:	-Excellent to primed surfaces
Corrosion Resistance:	-Excellent on correctly primed surfaces
Temperature resistance:	-Dry: Maximum 160 ◌C. At service temperatures above 100°C/212°F, slight discoloration may be expected

PHYSICAL PROPERTIES:

Colors/Shade No	Ral No
Finish	Flat.
Volume Solid	80%
Theoretical spreading rate	8 m² /liter 100Mic. Dft.
Flash point	30 ◌C
Specific gravity	1.5-1.6 kg/liter
V.O.C.	Max. 180 gr/liter
Shelf life	1 Years (25ºC / 77ºF) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage.

MIXING:

Mixing ratio (by weight)	Component A:NMI 680113 10Part	Component B: 4200530 1Part
Pot life	0.5 hours (20 ◌C/68 ◌F)	

APPLICATION:

Conditions	Do not apply when relative humidity exceeds 80% or when the surface to be coated is less than 3 ◌C above the dew point	
Method	Airless sprays	Brush (touch-up)
Thinner (max. vol.)	30001 (10-20%)	30001 (5%)
Spray setting		
Pump ratio minimum	30:1	
Tip size	0.017” – 0.019”	
Tip pressure	150 bar / 2200 Psi (Airless spray data are indicative and subject to adjustment)	
Cleaning of tools	Thinner: NMI30001	
Indicated film thickness, dry	80 microns	
Indicated film thickness, wet	100 microns	

DRYING AND CURING TIMES AT (20 ◦C):

Dry to touch	Max.2 hours
Hard dry	12 hours
Full curing	7 day
Recoat interval, Min	Min.12 hours
Recoat interval, Max	7 days, see REMARKS

APPLICATION AND CURING CONDITIONS:

Primed surfaces

The surface must be completely clean and dry at the time of application, and its temperature must be above the dew point to avoid condensation. Minimum temperature for curing is 10°C/50°F. High humidity and/or condensation during application and the following 16 hours (20°C/68°F) may adversely affect the film formation. In confined spaces provide adequate ventilation during application and drying.

REMARKS:

PRECEDING COAT

None

SUBSEQUENT COAT

Epoxy top coat.

Film thickness

May be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate and may influence drying time and recoating intervals. Normal range is 100-200 microns 4-8 mils.

Thinning

The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner 30001 is recommended in general.

Recoating and Drying/Curing time

Recoating intervals related to later conditions of temperature:
(100 micron/4 mils dry film thickness of NMI 680113)

Physical data versus temperatures:					
Surface temperature		5°C/41°F	10°C/50°F	20°C/68°F	30°C/86°
Dry to touch approx.		16 hours	10 hours	6 hours	3 hours
Resist condensing humidity/ light showers after		4 days	2 days	24 hours	12 hours
Fully cured		20 days	14 days	7 days	5 days
Recoating interval with epoxy and polyurethane top coats	Min	24 hours	16 hours	8 hours	4 hours
	Max	15 days	12 days	7 days	5 days

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long recoating intervals. Any dirt, oil, and grease have to be removed, e.g. with suitable detergent. Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

SAFETY:

Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult RSI material safety data sheets and follow all local and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.

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