



# COATING

PRODUCT DATA  
NMI 680141.

## PRODUCT DESCRIPTION:

### ONE COMPONENT BACKING POIYESTER MELAMINE PRIMER COAT NMI680141.

**NMI 680141:** is designed for use as a gloss high reflectance primer coat base on polyester resin and organic/inorganic pigment with good reflectance efficiency in direct exposure of light.

**NMI 680141:** can be applied as an inhibitive primer on blasted steel structure and Galvanized suraced.

**Standard color availability:** Manufactured Ral color.

## GENERAL PROPERTIES:

<b>Adhesion:</b>	-Good to both grit blasted and manually prepared surfaces.
<b>Corrosion Resistance</b>	-
<b>Temperature resistance:</b>	-Dry: Maximum 160 °C

## PHYSICAL PROPERTIES:

<b>Colors/Shade No</b>	Ral No.
<b>Finish</b>	Flat.
<b>Volume Solid</b>	55 %
<b>Theoretical spreading rate</b>	13.8 m <sup>2</sup> /liter 40 Mic. Dft.
<b>Flash point</b>	45 °C
<b>Specific gravity</b>	1.4-1.5 kg/liter
<b>V.O.C.</b>	Max. 450 gr/liter
<b>Shelf life</b>	6 month (25°C / 77°F) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage.

## 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.

<b>Method</b>	Airless sprays	Air spray	Brush (touch-up)
<b>Thinner (max. vol.)</b>	30004(10-20%)	30004(25%)	30004 (5%)
<b>Spray setting</b>			
<b>Pump ratio minimum</b>	30:1		
<b>Tip size</b>	.021"	1.8 mm	
<b>Tip pressure</b>	150 bar / 2200 Psi	4 – 5 bar	
	(Airless spray data are indicative and subject to adjustment)		
<b>Cleaning of tools</b>	Thinner:NMI 30004		
<b>Indicated film thickness, dry</b>	55 microns		
<b>Indicated film thickness, wet</b>	100 microns		

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## DRYING AND CURING TIMES AT (20°C):

Flash off	10-15 min
Time for Backing	15-20 min
Temperature for Avene	160-180°C
Recoat interval, min	8 hours
Recoat interval, max	None , see REMARKS

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## SURFACE PREPARATION:

**Primed steel** Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning.

**Maintenance** Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Remove all rust and loose material by abrasive blasting or power tool cleaning. Dust off residues.

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## EMARKS:

**PRECEDING COAT:** None.

**SUBSEQUENT COAT:** None.

**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 30-40 microns/ 1.2-1.6 mils.

**Thinning:** The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner 30004 is recommended in general.

**Recoating  
And drying/curing  
Time**

Physical data versus temperatures in mild atmosphere:					
Surface temperature		5°C/41°F	10°C/50°F	20°C/68°F	30°C/86°F
Dry to touch approx.		20 hours	10 hours	6 hours	4 hours
Resist condensing humidity/ light showers after		4 days	2 days	48 hours	24 hours
Fully cured		20 days	14 days	15 days	10 days
Recoating interval with alkyd finish		Min	24 hours	16 hours	8 hours
		Max	None	None	None

**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.**

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## 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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Product data sheet 680141.



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