

**PRODUCT DESCRIPTION:****TWO COMPONENT EPOXY HIGH BUILD PRIMER  
680116.**

(CURING AGENT 4200150)

NMI PRIMER 680116: is designed for use as a high performance primer base on epoxy and polyamide resins and Tio2 as inhibitive pigments with an excellent anticorrosive efficiency and cathodic chemical in damaged area in moderate to severe environment.

NMI PRIMER 680116: can be applied as an anti corrosion primer on blasted steel structure.

**Standard color availability** Manufactured only in metal gray and reddish gray color.

**GENERAL PROPERTIES :**

<b>Adhesion:</b>	- Excellent to both grit blasted and manually prepared surfaces(5B)
<b>Corrosion Resistance:</b>	- Excellent on correctly prepared surfaces.
<b>Temperature resistance:</b>	-Dry:Maximum:130°C Wet:Maximum:50°C
<b>Tio2 in Wet film:</b>	- Min.15 %
<b>Salt spray ASTM B117:</b>	-300 hrs in single layer. 400 hrs in system.

**PHYSICAL PROPERTIES:**

<b>Colors/Shade No</b>	RAL No.
<b>Finish</b>	Flat.
<b>Volume Solid</b>	65±2 %
<b>Theoretical spreading rate</b>	8.7 m <sup>2</sup> /liter at 75 Mic. Dft.
<b>Flash point</b>	30 °C
<b>Specific gravity(Mixture)</b>	1.45-1.55 kg/liter
<b>V.O.C.</b>	Max. 300 gr/liter
<b>Shelf life</b>	1 Year (25°C / 77°F) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage.

**MIXING:**

<b>Mixing ratio (by weight)</b>	Component A 680116 8	Component B 4200150 1
<b>Pot life</b>	10 hours (25 °C/ 77 °F)	

**APPLICATION :**

<b>Conditions</b>	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	Brush (touch-up)
<b>Thinner (max. vol.)</b>	30001 (10-20%)	30001(5%)
<b>Spray setting</b>		
<b>Pump ratio minimum</b>	40:1	
<b>Tip size</b>	.021"	
<b>Tip pressure</b>	170 bar / 2500 Psi	
	(Airless spray data are indicative and subject to adjustment)	
<b>Cleaning of tools</b>	Thinner 30001	
<b>Indicated film thickness, dry</b>	65 microns	
<b>Indicated film thickness, wet</b>	100 microns	

## DRYING AND CURING TIMES AT (25 °C):

<b>Dry to touch</b>	Max.1 hour
<b>Hard dry</b>	12 hours
<b>Full curing</b>	7 days
<b>Recoat interval, min</b>	6 hours
<b>Recoat interval, max</b>	none , see REMARKS

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## SURFACE PREPARATION:

**New steel** Steel surface should ideally be abrasive blast cleaning to minimum Sa 2½. The surface must be completely clean and dry prior to application. And its temperature must be above the dew point to avoid condensation.

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## REMARKS:

**PRECEDING COAT:** None.

**SUBSEQUENT COAT:** EPOXY INTER MEDIATE and 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 50-90 microns/ 2-3.6 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**

Physical data versus temperatures:					
Surface temperature	5°C/41°F	10°C/50°F	20°C/68°F	30°C/86°F	
Dry to touch approx.	4 hours	2 hours	1 hours	40 min.	
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 intermediate	Min	12 hours	8 hours	6 hours	3 hours
	Max	None	None	6 mount	90 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.**

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## SAFETY:

Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult NMI 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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**NMI COATING**