



PRODUCT DESCRIPTION

TWO COMPONENT ZINC RICH EPOXY PRIMER 681010-3

(CURING AGENT 4200130)

NMI PRIMER ZINC 681010-3: is designed for use as a high performance zinc rich primer base on epoxy and polyamide resins and Zinc Dust as inhibitive pigments with an excellent anticorrosive efficiency and cathodic protection in damaged area in moderate to severe environment.

NMI PRIMER ZINC 681010-3: 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:

Adhesion:	- Excellent to both grit blasted and manually prepared surfaces(4B-5B)
Corrosion Resistance:	- Excellent on correctly prepared surfaces.
Temperature resistance:	- Dry: Maximum 130 °C Wet: Maximum 50 °C
Zinc content in dry film:	-65-77 %
Salt spray ASTM B117:	-500 hrs in single layer 900 hrs in system.

PHYSICAL PROPERTIES:

Colors/Shade No	Gray.
Finish	Flat.
Volume Solid	50±2 %
Theoretical spreading rate	7.3 m ² /liter at 75 Mic. Dft.
Flash point	30 °C
Specific gravity(Mixture)	2.1-2.2 kg/liter (Base : 2.5-2.7 kg/liter)
V.O.C.	Max. 280 gr/liter
Shelf life	1 Year (25°C / 77°F) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage.

MIXING

Mixing ratio (by weight)	Component A 681010-3 8	Component B 4200130 1
Pot life	10 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	40:1	
Tip size	.021"	
Tip pressure	170 bar / 2500 Psi (Airless spray data are indicative and subject to adjustment)	
Cleaning of tools	Thinner 30001	
Indicated film thickness, dry	50 microns	
Indicated film thickness, wet	100 microns	

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DRYING AND CURING TIMES AT (25 °C)

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

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.

REMARKS

PRECEDING COAT: None.

SUBSEQUENT COAT: EPOXY INTER MEDIATE and Epoxy Top Coat 780116 or 880116 .

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	40°C/104°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.

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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COATING