

**PRODUCT DESCRIPTION:****ONE COMPONENT RED IRON OXIDE ALKYD  
PRIMER 685031**

NMI PRIMER 685031 is designed for use as an anti corrosive and inhibitive primer base on alkyd resin and red iron oxide pigment as inhibitive pigment with a good anticorrosive efficiency in mild to moderate environment.

NMI PRIMER 685031 can be applied as an inhibitive primer on blasted steel structure.

**Standard color availability** Manufactured only in light gray and off white color.

**GENERAL PROPERTIES :**

<b>Adhesion:</b>	- Good to both grit blasted and manually prepared surfaces.
<b>Corrosion Resistance:</b>	- Good on correctly prepared surfaces.
<b>Temperature resistance:</b>	- Dry: Maximum 85 °C Wet: Maximum 50 °C
<b>Salt spray ASTM B117:</b>	- 400 hrs in system(P+M+T)

**PHYSICAL PROPERTIES:**

<b>Colors/Shade No</b>	Ral No.
<b>Finish</b>	Flat.
<b>Volume Solid</b>	55±2%
<b>Theoretical spreading rate</b>	11 m <sup>2</sup> /liter 50 Mic. Dft.
<b>Flash point</b>	35 °C
<b>Specific gravity</b>	1.45-1.55 kg/liter
<b>V.O.C.</b>	Max. 320 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.

**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	Air spray	Brush (touch-up)
<b>Thinner (max. vol.)</b>	30003 (10-30%)	30003 (25%)	30003 (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 30003		
<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)

<b>Dry to touch</b>	Max.1 hour
<b>Hard dry</b>	8 hours
<b>Full curing</b>	7 days
<b>Recoat interval, min</b>	6 hours
<b>Recoat interval, max</b>	14 days , see REMARKS

## SURFACE PREPARATION:

<b>New steel</b>	Steel surface should ideally be abrasive blast cleaning to minimum Sa 2/5. The surface must be completely clean and dry prior to application. And its temperature must be above the dew point to avoid condensation.
<b>Maintenance</b>	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. Touch up to full film thickness.

## REMARKS:

<b>PRECEDING COAT:</b>	None.
<b>SUBSEQUENT COAT:</b>	AIR DRYING ALKYD INTER MEDIATE OR TOP COAT.
<b>Film thickness:</b>	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 50-80 microns/ 2-3.2 mils.
<b>Thinning:</b>	The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner 30003 is recommended in general.
<b>Recoating And drying/curing Time</b>	

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		
	F								
Dry to touch approx.	12 hours		6 hours		3 hours		2 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 intermediate	Min	24 hours		16 hours		8 hours		4 hours	
	Max	None		None		None		None	

**Maximum recoating interval in moderate atmosphere is 14 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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