



# ZINC CHROMATE EPOXY

## NF-114-M3

Curing Agent: NF-114-M3-CA

### Description

**Nilifam 114-M3** is designed for use as a high performance inhibitive primer base on epoxy and polyamide resins and Zinc phosphate as inhibitive pigments with an excellent anticorrosive efficiency in moderate to severe environment.

**Nilifam 114-M3** can be applied as an inhibitive primer on blasted steel structure.

### Recommended use

#### Adhesion

Excellent to both grit blasted and manually prepared surfaces.

#### Corrosion Resistance

Excellent on correctly prepared surfaces.

#### Temperature resistance

Dry: Maximum 120°C

Wet: Maximum 60°C

### Physical properties

#### Colors/Shade No

Grey/RAL NO

#### Finish

Flat

#### Solid Volume-%

55±2

#### Theoretical spreading rate

11 m<sup>2</sup> /lit-50 Mic.

462 sq.ft./US gallon-2 mils

#### Flash point

30°C

#### Specific gravity

1.5 kg/lit-12.6 lbs/US gallon

#### V.O.C.

Max. 280 gr/lit

#### Shelf life

1 Years (25°C/77°F) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage.

### Application details

#### Mixing ratio (by weight)

Component A NF-114-M3

Component B NF-114-M3-CA

**5**

**1**

#### Pot life

8 hours (20°C/68°F)

### 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.)

NF-T-1 (10-30%)

NF-T-1 (5%)

#### Spray setting

#### Pump ratio minimum

30:1

#### Tip size

0.019"-0.021"

#### Tip pressure

150 bar/2200 Psi

(Airless spray data are indicative and subject to adjustment)

#### Cleaning of tools

NF-T-1

#### Indicated film thickness, dry

55 microns

#### Indicated film thickness, wet

100 microns

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### Drying and Curing Times at (20°C)

Dry to touch	3-4 hour
Hard dry	7 hours
Full curing	7 days
Recoat interval, min	8 hours
Recoat interval, max	7 days , 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 Intermediate 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 50-75 microns/2-3 mils.

Thinning

The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner NF-T-1 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.		12 hours	8 hours	4 hours	3 hours
Resist condensing humidity/ light showers after		2 days	1 days	7 hours	5.5 hours
Fully cured		20 days	14 days	7 days	5 days
Recoating interval with epoxy intermediate	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 should 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 Nilifam 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.