MIO-HB-EPOXY POLYAMIDE
NF-124-M5

Curing Agent: NF-124-M5-CA

Description

Nilifam 124-M5 is designed for use as a high performance, barrier protection primer and mid coat base on epoxy and polyamide resins and Micasius Iron Oxide pigments with an excellent anticorrosive efficiency in moderate to severe environment.
Nilifam 124-HB As an intermediate coat with no maximum recoating interval in EPOXY/POLYURETHANE systems.
CURING AGENT NF-124-M5-CA, polyamide, is typically for use above 5°C/41°F.

Recommended use

Excellent to both primed & grit blasted and manually prepared steel surfaces (4A).
Excellent on correctly prepared steel surfaces and primed surfaces.

Dry: Maximum 120°C
Wet: Maximum 50°C

physical Properties

Colours	Grey /RAL No
Finish	Flat
Solid by Volume-%	60±2
Theoretical spreading rate	12 m²/lit-50 Mic 505 sq.ft./US gallon-2 mils
Flash point	28°C/83°F
Specific gravity	1.5 kg/lit-12.6 lbs/US gallon
V.O.C.	Max. 280 gr/lit
Shelf life	1 Year (25ºC / 77ºF) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage.

Application Details

Mixing ratio (by weight)	Component A NF-124 **5**	Component B NF-124-CA **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	40:1	
Tip size	0.021”–0.019”	
Tip pressure	150 bar/2100 Psi	
Cleaning of tools	NF-T-1	
Indicated film thickness, dry	60 micron	
Indicated film thickness, wet	100 micron	

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Drying And Curing Times At (20°C)

Dry to touch	3-4 hours
Hard dry	6-7hours
Full curing	7 days
Recoat interval, Min	8 hours
Recoat interval, Max	14 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 at least 3°C above the dew point to avoid condensation.

Primed surfaces The surface should be stable, firm, dry and free of dust, sand, loose old paint, dirt, grease and oil. It is recommended to apply mid coat before exceeding maximum interval of primer.

Remarks

Preceding Coat Epoxy primers such as NF-114-M3 or NF-114-M10.

Subsequent Coat Epoxy and polyurethane top coat such as NF-134 or NF-232-SG.

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 50-125 microns/ 2-5 mils.

Thinning The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner 1051 is recommended in general.

Recoating and Drying/Curing time Recoating intervals related to later conditions of temperature:
(75 micron/3 mils dry film thickness)

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.		16 hours	8 hours	4 hours	3 hours
Resist condensing humidity/ light showers after		2 days	1 days	6-7 hours	5 hours
Fully cured		20 days	14 days	7 days	5 days
Recoating interval with epoxy and polyurethane top coats	Min	24 hours	16 hours	8 hours	4 hours
	Max	60 days	30 days	14 days	10 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.