

## Description

**Nilifam 232-SG** is a two-component, semi-flat acrylic polyurethane coating with good gloss and color retention.

**Nilifam 232-SG** As a finishing coat for protection of structural steel in severely corrosive atmospheric environment, where light-fastness and gloss retention are required. Minimum temperature for curing is -10°C/14°F.

## Recommended use

Excellent to primed surfaces.

Excellent on correctly prepared and primed steel surfaces.

Dry: Maximum 120°C. At service temperatures above 100°C/212°F, slight discoloration may be expected.

## Physical Properties:

<b>Colors</b>	White / RAL No.
<b>Finish</b>	Semi Flat/Semi-Gloss
<b>Volume Solid-%</b>	55±2
<b>Theoretical spreading rate</b>	12.5 m <sup>2</sup> /lit 40 Mic 526 sq.ft./US gallon-1.58 mils
<b>Flash point</b>	32°C/90°F
<b>Specific gravity</b>	1.3 kg/lit
<b>V.O.C.</b>	Max. 380gr/lit
<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 details

<b>Mixing ratio (by weight)</b>	Component A NF-232-SG <b>10</b>	Component B NF-232-SG-CA <b>1</b>
<b>Pot life</b>	5 hours (20°C/ 68°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>	NF-T-2 (10-30%)	NF-T-2 (5%)
<b>Spray setting</b>		
<b>Pump ratio minimum</b>	30:1	
<b>Tip size</b>	0.017"–0.019"	
<b>Tip pressure</b>	150 bar/2100 Psi (Airless spray data are indicative and subject to adjustment)	
<b>Cleaning of tools</b>	NF-T-2	
<b>Indicated film thickness, dry</b>	55 microns	
<b>Indicated film thickness, wet</b>	100 microns	

## Drying and Curing Times At (20°C)

Dry to touch	4 hours
Hard dry	24 hours
Full curing	7 day
Recoat interval, Min	16 hours
Recoat interval, Max	None, see Remarks

## Application And Curing Conditions

**Primed surfaces** The surface must be completely clean and dry at the time of application, and its temperature must be above the dew point to avoid condensation. Minimum temperature for curing is -10°C/14°F. At the freezing point and below, be aware of the risk of ice on the surface which will hinder the adhesion. High humidity and/or condensation during application and the following 16 hours (20°C/68°F) may adversely affect the film formation. In confined spaces provide adequate ventilation during application and drying.

## Remarks

**Preceding Coat** Epoxy Mid coat such as **NF-124** and Epoxy Primer such as **NF-114-M10**

**Subsequent Coat** None.

**Colors** Certain lead-free red and yellow colors may discolor when exposed to chlorine-containing atmosphere. Leaded colors may become discolored when exposed to sulfide-containing atmosphere.

**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 40-60 microns/ 1.6–2 mils.

**Thinning** The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner 3030 is recommended in general.

**Recoating and Drying/Curing time** Recoating intervals related to later conditions of temperature: (40 micron/1.6 mils dry film thickness)

Physical data versus temperatures:						
Surface temperature		-10°C/14°F	0°C/32°F	10°C/50°F	20°C/68°F	30°C/80°F
Dry to touch approx.		3 days	36 hours	16 hours	4 hours	2.5 hours
Resist condensing humidity/light showers after		7 days	3 days	32 hours	16 hours	12 hours
Fully cured		2 months	32 days	14 days	7 days	5 days
Recoating interval	Min	6 days	3 days	32 hours	16 hours	12 hours
	Max	None	None	None	None	None

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.