

Description

Nilifam 338 is heat resistant aluminum pigmented paint for use as a topcoat.

Nilifam 338 can be applied for long-term protection of hot pipelines, exhaust pipes, smoke stacks and other hot surfaces.

Good to both primed and blasted clean surfaces.

Maximum, dry: 600°C/1112°F

Physical Properties

Colors	Aluminum
Finish	Semi-flat (After exposure to heat the gloss is reduced.)
Solid by Volume-%	30±2
Theoretical spreading rate	12.4 m ² /lit 25 Mic. 496 sq.ft./US gallon-2 mils
Flash point	25°C
Specific gravity	1 kg/lit
V.O.C.	Max. 700 gr/lit
Shelf life	1 Year (25°C / 77°F) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage.

Application Details

Conditions	Clean and dry surface with a temperature min. 3°C above the dew point to avoid condensation. In confined spaces provide adequate ventilation during application and drying.		
Method	Airless sprays	Air spray	Brush (touch-up)
Thinner (max. vol.)	NF-T-3 (5-20%)	NF-T-3(25%)	NF-T-3 (15%)
Spray setting			
Pump ratio minimum	30:1		
Tip size	0.017"	1.8 mm	
Tip pressure	125 bar / 1800 Psi	4-5 bar	
	(Airless spray data are indicative and subject to adjustment)		
Cleaning of tools	NF-T-3		
Indicated film thickness, dry	30 microns		
Indicated film thickness, wet	100 microns		

Drying and curing time at (20°C)

Surface dry	0.5 hour
Dry to touch	1-2 hours
Recoat interval, min	See REMARKS
Recoat interval, max	See REMARKS

SURFACE PREPARATION

Surface condition	Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other Contaminant by (high-pressure) fresh water cleaning. Abrasive blasting to Sa 2½.
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Remarks**Preceding Coat**

Can be used directly on blast-cleaned steel. For maximum corrosion protection, a primer coat of one of the following paints is recommended (40 micron/1.6 mil dry film thicknesses):
NF-318-M1 or NF-510-M10.
This will lower the heat resistance reference is made to the product data sheets for the mentioned primers.

Subsequent Coat

None.

Film thickness

It is recommended to avoid too high thicknesses of the paint as this will give a risk of blistering at later heating. THINNER NF-T-3 must be added at application to secure the low dry film thickness.
Normal Range is a 25 micron/1mil .

Thinning

The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner NF-T-3 is recommended in general.

Thermo plasticity

The paint film is somewhat thermoplastic also after heating.

High temperature service

For high temperature service, the total dry film thickness of the paint system should preferably be kept at 50 micron/2 mils as maximum

First exposure to heat

Do not expose the paint system to heat before it is through dry (minimum 24 hours at 20°C/68°F).

Recoating

May be recoated when through dry (24 hours at 20°C/68°F) or after being heated for one hour to approximately 200°C/392°F.

Before recoating after exposure in contaminated environment, clean surface thoroughly by high pressure fresh water hosing and allow to dry.

Zinc silicate primer

If NF-338 is applied on zinc silicate coatings, such as NF-510-M10, popping may occur after application or after first heating up.

The best way to avoid popping is to apply a mist coat in the first pass of Nilifam-338. Let the air escape and apply the full coat of NF-338

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.