

# RED OXIDE ALKYD NF-815-M1

## Description

**Nilifam 815-M1** is designed for use as an anti corrosive and inhibitive Air-drying primer base on long oil alkyd resin and Red Oxide as inhibitive pigment with a good anticorrosive efficiency in mild to moderate environment.

**Nilifam 815-M1** can be applied as an inhibitive primer on blasted steel structure.

## Recommended use

### Adhesion

Good to both grit blasted and manually prepared surfaces (3B-4Bon Blasted SA.2).

### Corrosion Resistance

Good on correctly prepared surfaces.

### Temperature resistance

Dry: Maximum 90°C

## Physical properties

### Colors/Shade No

Red/3013

### Finish

Flat

### Solid by Volume-%

45±2

### Theoretical spreading rate

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

379 sq.ft./US gllon-2mils

### Flash point

38°C

### Specific gravity

1.4 kg/lit-13.6 lbs/US gallon

### V.O.C.

Max. 400 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

### 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

Air spray

Brush (touch-up)

### Thinner (max. vol.)

NF-T-8 (10-30%)

NF-T-8 (25%)

NF-T-8 (5%)

### Spray setting

### Pump ratio minimum

30:1

### Tip size

019"

1.8 mm

### Tip pressure

150 bar / 2200 Psi

4 – 5 bar

(Airless spray data are indicative and subject to adjustment)

### Cleaning of tools

NF-T-8

### Indicated film thickness, dry

45 microns

### Indicated film thickness, wet

100 microns

# RED OXIDE ALKYD NF-815-M1

## Drying and Curing Times at (20°C)

Dry to touch	Max.1 hour
Hard dry	48 hours
Full curing	15 days
Recoat interval, min	8 hours
Recoat interval, max	15 days , see Remarks

## Application and Curing Conditions

### New steel

Steel surface should ideally be abrasive blast cleaning to minimum Sa 2. The surface must be completely clean and dry prior to application. And its temperature must be above the dew point to avoid condensation.

### Maintenance

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

### Preceding Coat

None.

### Subsequent Coat

AIR DRYING ALKYD TOP COAT Such as NF-835 or NF-835-MT.

### 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 50-70 microns/ 2-2.8 mils.

### Thinning

The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner NF-T-8 is recommended in general.

### Recoating And drying/curing Time

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
Dry to touch approx.		12 hours	4 hours	1 hours	0.7 hours
Resist condensing humidity/ light showers after		4 days	2 days	48 hours	24 hours
Fully cured		20 days	18 days	15 days	14 days
Recoating interval with alkyd intermediate	Min	24 hours	16 hours	8 hours	4 hours
	Max	None	90 days	30 days	15 days

Maximum recoating interval in moderate atmosphere is 15 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.