



## Description

**Nilifam-124-HB** is a high-build, modified two-component epoxy paint, which cures to coating with good resistance to water, splashes of mineral oils, aliphatic hydrocarbons, and to abrasion and impact. Limited resistance to aromatic and stronger solvents and to acids and oxidizing materials.

**Nilifam-124-HB** as an intermediate coat with no maximum recoating interval in Epoxy/Polyurethane systems.

Curing agent NF-124-HB-CA, polyamide, is typically for use above 5°C/41°F.

## Recommended use

<b>Adhesion</b>	Excellent to both primed & grit blasted and manually prepared steel surfaces (5A).
<b>Corrosion resistance</b>	Excellent on correctly prepared steel surfaces and primed surfaces.
<b>Temperature resistance</b>	Dry: Maximum 120°C

## Physical constants

<b>Colours/shade:</b>	Grey/RAL NO
<b>Finish:</b>	Flat
<b>Volume solids, %:</b>	60±5
<b>Theoretical spreading rate:</b>	12 m <sup>2</sup> /lit-50 Mic.
<b>Flash point:</b>	28°C
<b>Specific gravity:</b>	1.50±0.15 kg/l
<b>Dry to touch:</b>	3-4 hours at 20°C
<b>(Initial) hardness:</b>	7 hours
<b>Fully cured:</b>	7 days
<b>VOC content:</b>	Max. 280 gr/l

## Application details

<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 spray	Brush (touch-up)
<b>Thinner (max. vol.)</b>	NF-T-1 (10-30%)	NF-T-1 (5%)
<b>Spray setting</b>		
<b>Pump ratio minimum</b>	40:1	
<b>Tip size</b>	0.021"-0.019"	
<b>Tip pressure</b>	150 bar/2500 Psi	
	(Airless spray data are indicative and subject to adjustment)	
<b>Cleaning of tools</b>	NF-T-1	
<b>Indicated film thickness, dry</b>	60 microns	
<b>Indicated film thickness, wet</b>	100 microns	



**Surface preparation**

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

Packaging (typical)	Mass (Kg)	Size of containers (litres)
Hibopoxz comp A	20	20
Hibopoxz comp B	3.6	4

Mixing	Mixing ratio (by weight)	Hibopoxz comp A	Hibopoxz comp B
		100	18
	Pot life	4 hours (20°C/ 68°F)	

**Storage & handling**

The product must be stored in accordance with national regulations. Keep the containers in a dry, cool ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.

**Shelf-life**

Hibopoxz comp A	12 month(s)
Hibopoxz comp B	12 month(s)

In some markets commercial shelf life can be indicated shorter by local legislation. The above is minimum shelf life, thereafter the paint quality is subject to re-inspection.

**Remarks**

<b>Preceding Coat</b>	Epoxy primers such as NF-114-M3 or NF-114-M4.
<b>Subsequent Coat</b>	Epoxy and polyurethane top coat such as NF-134 or NF-232.
<b>Film thickness</b>	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.
<b>Thinning</b>	The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner 1051 is recommended in general.
<b>Recoating/Drying/ Curing Time</b>	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	7 hours	5 hours
Fully cured	20 days	14 days	7 days	5 days
Recoating interval with epoxy intermediate	Min	24 hours	16 hours	8 hours
	Max	60 days	30 days	14 days



### Caution

This product is for professional use only. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly and according to Nilifam's technical documentation. Applicators and operators shall use appropriate personal protection equipment when using this product. This guideline is given based on the current knowledge of the product. Any suggested deviation to suit the site conditions shall be forwarded to the responsible Nilifam representative for approval before commencing the work.

### 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

### Tools and equipment

