



## Description

**Nilifam-115** is designed for use as an epoxy ester primer available in a wide range of colors. The product is ideally suited for metal, interior and exterior surfaces with good color and gloss retention.

**Nilifam-115** can be applied as an inhibitive primer on blasted steel structure.

## Recommended use

<b>Adhesion</b>	Excellent to prepared surfaces.
<b>Corrosion resistance</b>	Excellent on correctly prepared surfaces.
<b>Temperature resistance</b>	Dry: Maximum 120°C

## Physical constants

<b>Colours/shade:</b>	RAL NO
<b>Finish:</b>	Semi Gloss
<b>Volume solids, %:</b>	45±5
<b>Theoretical spreading rate:</b>	15 m <sup>2</sup> /lit - 30 Mic.
<b>Flash point:</b>	35°C
<b>Specific gravity:</b>	1.30±0.15 kg/l
<b>Dry to touch:</b>	Max.4 hours at 20°C
<b>(Initial) hardness:</b>	16 hours
<b>Fully cured:</b>	7 days
<b>VOC content:</b>	Max. 350 gr/l

## Application details

**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.

<b>Method</b>	Airless spray	Air spray	Brush (touch-up)
<b>Thinner (max. vol.)</b>	NF-T-1 (10-30%)	NF-T-1(25%)	NF-T-1 (5%)
<b>Spray setting</b>			
<b>Pump ratio minimum</b>	30:1		
<b>Tip size</b>	021"	1.8 mm	
<b>Tip pressure</b>	150 bar/2100 Psi	4 – 5 bar	

(Airless spray data are indicative and subject to adjustment)

<b>Cleaning of tools</b>	NF-T-1
<b>Indicated film thickness, dry</b>	45 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)
Nipester	20	20

**Storage & handling**

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

**Shelf-life**

Nipester	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**

**Preceding Coat** None.

**Subsequent Coat** AIR DRYING EPOXY ESTER INTERMEDIATE or AIR DRYING EPOXY ESTER TOP COAT.

**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 40-50 microns/ 1.6/ 2 mils.

**Thinning** The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner NF-T-1 is recommended in general.

**Recoating/Drying/ Curing Time**

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	6 hours	6 hours	2 hours.	
Resist condensing humidity/ light showers after	4 days	2 days	24 hours	24 hours	
Fully cured	20 days	14 days	15 days	10 days	
Recoating interval with epoxy ester intermediate	Min	24 hours	16 hours	8 hours	4 hours
	Max	None	None	None	None



### 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

