



## Description

**Nilifam-510-M10** is a two-component, solvent-borne, self-curing, inorganic zinc silicate with outstanding resistance against weathering and abrasion. It has excellent chemical resistance. For service temperature range, see below. Applicable by airless spray. Offers cathodic protection of local mechanical damage.

## Recommended use

General purpose, heavy-duty, rust-preventing primer. As a single, complete coating for long-term protection of steel exposed to moderately to severely corrosive environment and to abrasion. As a tank lining.

## Service Temperature

Resistant to permanent dry temperatures up to 500°C/932°F.  
Resistant to occasional short-term heating up to 500°C/932°F while permanent service temperatures are otherwise below 400°C/752°F.  
In the case of cyclic service conditions with regular periods of low and high temperatures, the temperature should be kept below 400°C/752°F. In the case of service temperatures above 400°C/752°F, it is of advantage to apply a topcoat of Nilifam 338-M6

## Physical constants

<b>Colours/shade:</b>	Metal grey/7001
<b>Finish:</b>	Flat
<b>Volume solids, %:</b>	62±5
<b>Theoretical spreading rate:</b>	10 m <sup>2</sup> /lit-50 Mic.
<b>Flash point:</b>	15°C
<b>Specific gravity (mix):</b>	2.90±0.10 kg/l
<b>Dry to touch: (Initial) hardness:</b>	Max.15 min. at 20°C
<b>Fully cured:</b>	4 hours (approx.)
<b>VOC content:</b>	4 days (approx.) Max. 236 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	Air Spray	Brush (touch-up)
<b>Thinner (max. vol.)</b>	NF-T-5 (0.3%)	NF-T-5 (0-1%)	NF-T-1 (0-1%)
<b>Spray setting</b>			
<b>Pump ratio minimum</b>	30:1		
<b>Tip size</b>	0.019"-0.023"	1.8 mm	
<b>Tip pressure</b>	100 bar/1500 Psi	5-6 bar	
	(Airless spray data are indicative and subject to adjustment)		
<b>Cleaning of tools</b>	NF-T-5		
<b>Indicated film thickness, dry</b>	62 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)
Zincat comp A	24	20
Zincat comp B	6	10

### Mixing

Mixing ratio (by weight)	Zincat comp A	Zincat comp B
	80	20
Pot life	4-5 hours (20°C/ 68°F)	

### 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

Zincat comp A	12 month(s)
Zincat comp B	3 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>	None or according to specification.
<b>Recoating</b>	Minimum interval at 20°C/68°F, 65-75% RH for recoating with: NF-124-HB (system/high-build) is 8 hours. Recoating intervals are strongly dependent on both temperature and humidity. Deviations from the standard conditions may shorten or prolong the recoating intervals. The recoating interval of 24 hours for 25 micron/1 mil NF-124-HB is only valid in case the subsequent coat is applied more than 1 week after (20°C/68°F), 75% RH, and humid weather. Otherwise, the minimum recoating interval is the same as for system/high-build.
<b>Film thickness</b>	If top coated with a heavy duty system, 50-75 micron/2-3 mils dry film thickness (75 micron/3 mils wet) is recommended. For long-term protection without topcoat, 75 micron/3 mils dry film thickness (100-125 micron/4-5mils wet) is generally recommended. In tanks 100 micron/4 mils dry film thickness (150 micron/6 mils wet) is recommended but may be applied in 125 micron/5 mils dry film thickness (200 micron/8 mils wet).
<b>Thinning</b>	The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner 3061 is recommended in general.
<b>Recoating/Drying/Curing Time</b>	Recoating intervals related to later conditions of temperature: (100 micron/4 mils dry film thickness of NF-124-HB)



### 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

