



Description

Nilifam-328-M6 is heat resistant aluminum pigmented paint for use as an intermediate. **Nilifam-328-M6** can be applied for long-term protection of hot pipelines, exhaust pipes, smoke stacks and other hot surfaces.

Recommended use

Adhesion	Good to blasted clean surfaces.
Corrosion resistance	Good in medium to severe environments
Temperature resistance	Dry: Maximum 600°C/1112°F

Physical constants

Colours/shade:	Aluminum-RAL9006
Finish:	Semi-flat (After exposure to heat the gloss is reduced.)
Volume solids, %:	35±5
Theoretical spreading rate:	12 m ² /lit-25 Mic.
Flash point:	25°C
Specific gravity:	1.10±0.10 kg/l
Dry to touch:	Max.1 hour at 20°C
(Initial) hardness:	1-2 hours
Fully cured:	After heating exposure
VOC content:	Max. 690 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.		
Method	Airless spray	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	35 microns		
Indicated film thickness, wet	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)
Alunil	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

Alunil	12 month(s)
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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	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-M6.. This will lower the heat resistance reference is made to the product data sheets for the mentioned primers.
Subsequent Coat	NF-338-M6
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/1 mil.
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



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

