



Nason[®] Industrial NI-640 Acrylic Enamel Topcoat

Product Description

NI-640 is a quick and easy-to-use single pack acrylic enamel topcoat. It is specifically formulated to give a 1K single stage topcoat that will touch dry in normal ambient conditions within 20-30 mins depending on the temperature. It will be dry to handle (without baking) in 2-3 hours (fully hard dry, up to 7 days). NI-640 Line colours give faster drying & overall better performance when compared to the typical QD (Quick Dry) alkyd enamel. This is a particular advantage when painting large objects such as tractors & mining equipment.

Gloss

High.

Note: To adjust gloss level, addition of 314-37 Nason[®] Industrial Enamel Matting Agent is recommended. Refer Table 1, below.

Colour

White; Black; Golden Yellow; AS 2700 colours.

Product Features

- Excellent gloss & colour retention
- Quick Drying
- Excellent flow & application properties
- Hard when fully dried
- Long open time & excellent overspray absorption

Product Benefits

- Extended exterior durability
- Higher throughput
- High quality high gloss finish
- Resistant to handling & mech. damage
- High productivity for spraying large items

Can be used as DTM for internal use only on properly prepared mild steel.

For improved corrosion protection, prime the substrate with Nason[®] Industrial QD ZP Alkyd Primer or Nason[®] Industrial HB ZP Alkyd Primer or Nason[®] Industrial All Purpose Etch Primer or Nason[®] Industrial HB Etch Primer or 650-04 Nason[®] Industrial 2K ZP Epoxy Primer or 617-63 Nason[®] Industrial 2K AM Epoxy Primer.

Product Uses / Applications

As an air-dry enamel where longer term exterior durability of properly prepared metal surfaces is required in light industrial environments.

- Fabricated light structural steel, sheet metal;
- Industrial plant equipment & machinery;
- Mobile mining earth moving, construction and agricultural equipment & attachments;
- Exteriors of tanks, pipelines, storage & waste bins.

Not recommended for

Where exposure to acids or alkalis may occur.
Immersion service or over thermoplastic paintwork.

Physical Data (depending on colour)

	ST100-640	RTS
Volume Solids:	39.7%	36 – 39%
Weight Solids	44.1%	41 – 54%
VOC (RFU):		547 - 574 g/L
Specific Gravity:	0.99 g/cm ³	0.98 – 1.19g/cm ³
Dry Film Thickness:		30-40 µm
Theoretical Coverage at 40 µm DFT:		9.0 – 9.7 m ² /L
Flash Point:	35°C	



Dry Time

Air Dry at 25°C & 50% RH at recommended film thickness:

Dust Free: 5 min

Dry to Handle: 2-3 hours

Dry to touch: 20-30 min

Hard Dry: overnight (8 Hours)

Full Cure: up to 7 days

Bake: Not recommended.

Surface Preparation

Cleaning: Degrease using an Axalta approved wax and grease remover.

Mild steel: Hand or power tool cleaning to AS 1627.2 St3.

Non-ferrous & FRG: Abrade surface and prime with 719-01 or 719-05 Nason®

Industrial All Purpose Etch Primer.

For DTM application (interior use only): Clean, degrease and abrade the substrate.



Application

Mix thoroughly. Up to 20% by volume of Nason® Industrial ST300-570 Enamel Thinner. For hot weather and improved flow, use Nason® Industrial ST300-502 Thinner Standard.

Filter material prior to spray application.

Note 1: Can be hardened with Nason® Fulthane 483-08 Kwik – Kure Enamel Hardener at 10:1 by volume or weight.

Note 2: For the Reducer Selection Guide, please refer to table 2.



Application Conditions

Do not apply if material, substrate or ambient temperature is less than 10°C or above 45°C. The substrate must be at least 3°C above the dew point. Relative humidity should be below 85%

Flash-off times between coats: 5 - 10 minutes

Spray Gun Setup

Airless: 0.23 – 0.30 mm 180 bar

Conventional: 1.3 -1.4 mm 2.5 – 3.0 bar 40 – 50 psi

Refer to spray equipment documentation for setting recommendations.

Number of coats: 1 - 2

Flash-off times between coats: 5 - 10 mins

Cleanup Solvents

Clean equipment using or Nason® Industrial ST300-502 Thinner Standard.

Recoating

Lightly abrade and clean surface before applying 1-2 coats of NI-640 Acrylic Enamel Topcoat

Note: Do not recoat with polyester products.

Dry Film Characteristics*

Heat Resistance:	up to 80°C
Exterior Exposure:	VERY GOOD
Oil and Petrol Resistance:	VERY GOOD
Water Resistance:	VERY GOOD
Abrasion Resistance:	VERY GOOD

Technical data sheet

Table 1- Gloss Adjustment information – guidance only

NI640 : 314-37 Mixing Ratio	WHITE/PASTEL Colours	OTHER Colours
wt/wt	Average gloss @60°	Average gloss @60°
20:80	1.0-3.0	1.0-3.0
40:60	1.5-3.5	1.5-3.5
50:50	3.0-5.5	5.0-8.0
60:40	8.0-9.0	10.0-12.0
70:30	22.0-25.0	25.0-30.0
80:20	35.0-55.0	50.0-70.0
90:10	80.0-90.0	85.0-95.0
100 - 0	>95.0	>95.0

Table 2- Reducer Selection Guide

Ambient Temperature		10°C 15°C 20°C 25°C 30°C 35°C 40°C	
ST100-640 Acrylic Enamel Topcoat	Air Dry	ST300-570 Enamel Thinner	
		ST300-502 (Standard)	

Shelf Life

24 months minimum in sealed original container.
Store at room temperature away from direct sunlight.

Availability

Nason® Industrial Tints		ST-XX
Nason® Industrial ST640 Acrylic Air Dry Enamel Topcoat	20 L	NI-640
Nason® Industrial ST640 Acrylic Air Dry Enamel Binder	4 L	ST100-640
Nason® Industrial ST640 Acrylic Air Dry Enamel Binder	12 L	ST100-640
Nason® Industrial ST640 Acrylic Air Dry Enamel Binder	20 L	ST100-640
Nason® Industrial ST570 Enamel Thinner	20 L	ST300-570
Nason® Industrial ST502 Thinner Standard	5 L	ST300-502
Nason® Industrial ST502 Thinner Standard	20 L	ST300-502
Nason® Industrial Enamel Matting Agent	4 L	314-37
Nason Fulthane Kwik-Kure Enamel Hardener	0.47L	483-08

This product is intended for use by professional trade and industrial applicators in compliance with relevant Health, Safety & Environmental standards and legislation.
The applicator must use suitable Personal Protective Equipment (PPE), in particular full body coverall, gloves, goggles and air respirator. Provide adequate ventilation when using in confined spaces
For more detailed information, refer to Material Safety Data Sheets of the products used.

This Technical Data Sheet is issued by Axalta Coatings Systems as a guidance only. The information contained herein is current and correct to the best of our knowledge at the time of issuance.
The user must ensure suitability of the product and its performance for the application at hand. Axalta Coating Systems assumes no responsibility nor provides any warranty.