



Nason[®] Industrial NI 690 ISF 2K Topcoat

Product Description

2K isocyanate-free acrylic topcoat based on amine-epoxy functional acrylic polymers.

Gloss

High.

Colour

Various factory made colours, AS2700 using Nason Industrial ST Tints.

Product Features

- Isocyanate free product
- Good resistance to sunlight exposure
- Tough finish
- Fast drying

Suitable for interior and exterior applications.

Product Benefits

Can be applied in situ
Longer exterior service life
Hard wearing coating
Early handling

Product Uses / Applications

- Shopping complexes and sporting arenas
- Handrails
- General steelwork, where aesthetic appearance is required
- Implements, agricultural and farm machinery
- Trucks, forklifts, tankers, tank exteriors
- Industrial and mining equipment
- Chemical plants, electrical generating equipment
- Concrete walls.
- Theme Parks
- Rail wagons and bogeys

Not Recommended for

Application over QD Enamel and thermoplastic paintwork.

Physical Data

Volume Solids (mixed):	Approx. 66.3% (white); 58.5% (black)
VOC:	492 g/L (mixed)
Specific Gravity (mixed):	1.03 – 1.21 g/mL
Dry Film Thickness:	50 - 75 microns
Theoretical Coverage (at 50 microns DFT):	8.9 m ³ /L (white); 9.9 m ³ /L (black)
Flash Point:	24°C



Dry Time

Air Dry at 20°C & 50% RH at recommended film thickness:

Dust Dry:	90 minutes	Dry To Handle	4 - 8 hours
Hard Dry:	24 – 30 hours		

Bake:

35 minutes @ 60°C after 20 minutes flash-off @ 20°C.

Surface Preparation

Previously painted surfaces:

Clean using an Axalta recommended wax and grease remover.

Lightly sand with Audurra P320-400 or scour with 3M Scotch Brite Pad grey, and subsequently re-clean all the areas before the application of Nason® Industrial ISF 2K Topcoat.

Test suitability of the existing coating before application of Nason® Industrial ISF 2K Topcoat.

New work:

To be applied as a finish coat over an Axalta recommended primer.

Wipe the area with Sontara® Tack Rag immediately prior application of Nason® Industrial ISF 2K Topcoat.



Application

- Mixing Ratio:
Reducer:

2:1 with Nason® Industrial ISF 2K Hardener
15-20% Imron® FleetLine THP710/THP711
Thinner or Nason® Industrial ST300-
501/502 or 861-62 Nason® Industrial
Reducer.

- Pot Life:

5 - 6 h @ 20°C

Gun Setup

- | | | | |
|-------------------------------|----------------|---------------|-------------|
| • Pressure Pot (recommended): | 1.2 – 1.4 mm | 3 - 4 bar | 45 – 60 psi |
| • Conventional: | 1.3 – 1.4 mm | 3 - 4 bar | 45 – 60 psi |
| • Airless Spray: | 0.23 – 0.28 mm | min. 1500 psi | |
| • HVLP: | 1.3 – 1.4 mm; | 0.7 bar | 10 psi |

Refer to spray equipment documentation for setting recommendations.

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|---------------------------|-----------|
| • Number of Coats: | 2 |
| • Flash-off Between Coats | 5 minutes |



Application Condition:

Do not apply if material, substrate or ambient temperature is less than 10°C or above 45°C. Substrate must be at least 3°C above the dew point. Relative humidity should be below 90%

Cleanup Solvents

Recommended Axalta gun cleaning thinner.

Dry Film Characteristics

Exterior Exposure:	GOOD
Maximum Service Temperature:	90°C (continuous service)
Humidity Resistance:	GOOD
Oil and Petrol Resistance:	GOOD

Recoating

Thoroughly scuff the surface with Audurra P320-400 or 3M Scotch Brite Pad grey.
Recoat with 1 – 2 coats of Nason® Industrial ISF 2K Topcoat, as necessary.

Shelf Life

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

Availability

Nason® Industrial ISF 2K Topcoat	10 L	ST100-690
Nason® Industrial ISF 2K Activator	5 L	ST200-547
Imron® Fleet® Line Thinner	5 L	THP710/THP711
Nason® Industrial Epoxy Reducer	20 L	861-62
Nason® Industrial Epoxy Reducer	4 L	861-62
Nason® Industrial ST501 Slow Dry Thinner	4 L	ST300-501
Nason® Industrial ST502 Standard Thinner	4 L	ST300-502
Nason® Industrial Tints		ST-XX

