

# Nason<sup>®</sup> Industrial NI-650 QD Alkyd Enamel Topcoat

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## Product Description

NI-650 Line is an economical single pack quick drying alkyd gloss spraying enamel that is specifically formulated to give a 1K single stage topcoat that will touch dry in normal ambient conditions within 20-30 min depending on the temperature. It will be dry to handle (without baking) in 3-4 hours (fully hard dry, up to 7 days) without baking. NI-650 Line colours are a low cost topcoat for the painting of objects such as machinery.

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## Gloss

High

**Note:** To adjust gloss level, addition of 314-37 Nason<sup>®</sup> Industrial Enamel Matting Agent is recommended. Refer Table 1.

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## Colour

Various

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## Product Features

- Quick Drying
- Excellent flow & application properties
- Hard when fully dried
- Easy repair & recoat

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## Product Benefits

- Fast turnaround time
- High quality, high gloss finish
- Resistant to handling damage
- Cost effective site maintenance topcoat

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

For improved corrosion protection, prime the substrate with 308-05 Nason<sup>®</sup> Industrial QD ZP Alkyd Primer Grey or 308-10 Nason<sup>®</sup> Industrial QD ZP Alkyd Primer Red Oxide or 650-04 Nason<sup>®</sup> Industrial 2K ZP Epoxy Primer.

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## Product Uses / Applications

As an air-dry enamel topcoat for the protection and decoration of primed surfaces & old finishes in light industrial environments, and has characteristic of direct-to metal when tested against appropriate performance specifications. This product is designed for machinery, tools & implements as well as industrial containers.

- Fabricated light structural steel, sheet metal;
- Mobile equipment;
- Industrial plant equipment & machinery;
- Construction & agricultural attachments, waste bins, box trailers;
- Interior office equipment.

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## Not recommended for

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

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## Physical Data (depending on colour)

	ST100-650	RTS
Volume Solids:	45.5%	36 – 39%
Weight Solids	48.4%	41 – 53%
VOC (RFU):		554 - 573 g/L
Specific Gravity:	0.99 g/cm <sup>3</sup>	0.97 – 1.18 g/cm <sup>3</sup>
Dry Film Thickness:		30-40 µm
Theoretical Coverage at 40 µm DFT:		9.0 – 9.7 m <sup>2</sup> /L



### Dry Time

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

Dust Free:	5 min	Dry to Handle:	3-4 hours
Dry to Touch:	20-30 min	Hard Dry:	overnight
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. Add 10 - 20% by volume of Nason® Industrial ST300-570 Enamel Thinner. Filter material prior to spray application.

**Note 1:** Do not use 861-60 Nason Industrial Enamel Reducer (incompatible with the tinter system).



**Note 2:** Can be hardened with Nason® Fulthane 483-08 Kwik – Kure Enamel Hardener at 10:1 by volume or weight.

### 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%.

### Spray Gun Setup

Airless:	0.23 – 0.28 mm	min. 1500 psi
Conventional:	1.8 – 2.0 mm	3 – 4 bar 45 – 60 psi
Number of coats:	2	
Flash-off times between coats:	5 - 10 mins	

### Cleanup Solvents

Clean equipment with Nason® Industrial Enamel ST300-570 Enamel Thinner

### Recoating

Lightly abrade and clean surface before applying 1-2 coats of Nason® Industrial NI-650 QD Alkyd Enamel. For better exterior durability recoat with Nason® Industrial QD HD Enamel. Do not recoat with polyester products.

### Dry Film Characteristics\*

Heat Resistance:	up to 80°C dry heat
Exterior Exposure:	GOOD
Oil and Petrol Resistance:	GOOD
Water Resistance (Immersion?):	GOOD
Abrasion Resistance:	GOOD

**Table 1**

NI650 : 314-37 Mixing Ratio	WHITE/PASTEL Colours	OTHER Colours
wt/wt	Average gloss @60°	Average gloss @60°
0 - 100	0.5-1.5	0.5-1.5
20:80	1.0-3.0	1.0-3.0
40:60	1.5-3.5	2.5-5.0
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

**Shelf life**

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

**Availability**

Nason® Industrial Tints		ST-XX
Nason® Industrial 650 QD Alkyd Enamel Topcoat	20 L	NI-650
Nason® Industrial ST650 QD Alkyd Enamel Binder	4 L	ST100-650
Nason® Industrial ST650 QD Alkyd Enamel Binder	12 L	ST100-650
Nason® Industrial ST650 QD Alkyd Enamel Binder	20 L	ST100-650
Nason® Industrial ST570 Enamel Thinner	4 L	ST300-570
Nason® Industrial Enamel Matting Agent	4 L	314-37
Nason® Fulthane 483-08 Kwik – Kure Enamel Hardener	0.47L	

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.