

NORMADUR 65 HS

Flexible Polyurethane Coating

DATA SHEET 2/08

PROPERTIES AND RECOMMENDED USAGE

Paint type:

NORMADUR 65 HS is a fast drying, flexible polyurethane coating with an aliphatic isocyanate curing agent. NORMADUR 65 HS is high-solid and contains rust preventing pigments.

Typical uses:

NORMADUR 65 HS can, in atmospheric corrosivity classes C2 and C3, be used as **a single coat system** on easily painted steel products such as doors, gas bottles, hand rails, etc. It can also be used as **a topcoat** in classes C2-C4 and C5-I and C5-M on various primers, and as **maintenance painting** on old paint surfaces. NORMADUR 65 HS has good impact resistance and it can be piled after a short drying time. It can also be used as floor coating on concrete and steel surfaces. It is very suitable also for wood, plywood, boards etc.

Most common SFS-EN ISO 12944-5 systems:

- PUR120/1-FeSa2½
- A2.06 EPPUR120/2-FeSa2½
- A4.13 EPZn(R)PUR160/2-FeSa2½
- A4.08 EPPUR240/3-FeSa2½
- A5I.05 EPZn(R)EPPUR320/3-FeSa2½

Chemical resistance:

Used in recommended paint systems, and correctly applied NORMADUR 65 HS withstands occasional splashes and spillage of water, oil and weak process chemicals.

Weather stability:

Withstands sunlight and UV radiation.

TECHNICAL DATA

Volume solids:	approx. 65 vol.%
Total mass of solids*:	approx. 890 g/l
VOC value*: (Volatile organic compound)	approx. 310 g/l

(*Values are calculated.)

Mixing ratio:

Resin 4 parts by volume
Cure 1 part by volume

Pot life: at +23°C

approx. 1 h after mixing

Drying times: at +23°C/80 µm dft:

Surface dry	1½ h
To touch	3 h
To recoat	3 h
Chemical resistant	7 d

Calculated theoretical coverage and recommended film thickness:

Dry	Wet	Coverage
50 µm	80 µm	13.0 m²/l
80 µm	125 µm	8.2 m²/l
120 µm	185 µm	5.4 m²/l
150 µm	230 µm	4.3 m²/l

Practical coverage:

Depends on wind conditions, the structure to be painted, the roughness of the surface and the application method.

Colour: A limited range from RAL, NCS, KY, SSG colours

Thinner and cleaner: OH 66 or OH 17 or OH 10

Roller thinner: OH 12

Finish: Semi gloss*

*Glossy when overcoated with NORMADUR CLEAR.

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APPLICATION INSTRUCTIONS

Surface preparations:

Ice, concrete and other solids should be removed by scraping or brushing. Remove salt and other water soluble contaminants by water cleaning with brush, high pressure, steam or alkali cleaning. Grease and oil should be removed by alkaline, emulsion- or solvent cleaning (SFS-EN ISO 8504-3, SFS-EN ISO 12944-4).

Steel surfaces:

Blast cleaning to a minimum of Sa2½ (SFS-ISO 8501-1, SFS-EN ISO 8504-2). Cold rolled plates must be roughened with abrasive paper.

Shop primed steel surfaces:

Damaged or corroded surfaces should be blast cleaned to a grade of Sa2½ (SFS-ISO 8501-2, SFS-EN ISO 12944-4).

Aluminium surfaces:

Remove grease and other contaminants. Sand-sweeping before painting improves adhesion. Normadur 65 HS does not adhere to marine aluminium without primer.

Hot dip galvanised steel surfaces:

Remove grease, oil and dirt with alkali-, emulsion- or solvent cleaning (SFS-EN ISO 12944-4). Hot dip galvanised steel surfaces are to be thoroughly sweep blast cleaned with fine abrasive. Galvanised thin steel plates should be washed with a 5 % ammonia solution followed by fresh water hosing. All galvanised and hot dip galvanised steel surfaces should be roughened and primed with EPOCOAT 21 PRIMER.

Wood and plywood surfaces:

The substrate must be clean and dry.

New concrete surfaces:

The concrete must be dry and at least 4 weeks old, with humidity no more than 4 %. (The floor humidity can be tested, if a humidity gauge is not available, by using a rubber mat. The colour of the floor under the rubber mat must not be darker than the rest of the floor after a 24 hour test.) The concrete must be hard and strong enough (at least 80 % of final strength). **The concrete must not contain additives (such as plastic dispersions, waxes, silicones or silicates) that can reduce adhesion and absorption of the paint.** Uneven surfaces should be smoothed down by grinding. Abrasive blasting is recommended to remove laitance and other contaminants. If required, a 15-20 % hydrochloric acid solution could be used.

Previously painted epoxy coating:

Grease and oil should be removed by emulsion cleaning. Surfaces should be roughened down by grinding. **Holes and cracks must be filled with epoxy filler.**

Primer on steel surfaces:

EPOCOAT 21 PRIMER, EPOCOAT 21 HB, NORMAZINC SE, NORMADUR HB

Primer on concrete:

NORMAFLOOR 105 PRIMER, NORMADUR 65 HS

Top Coat:

NORMADUR 65 HS, NORMADUR CLEAR

Environmental conditions during application:

The surface should be dry and clean. During application and drying time the temperature of the paint, air, and surface should be above 5°C and the relative humidity below 80 %. The surface temperature should be min 3°C above the dew point of the air.

Method of application:

Use an airless spray, electrostatic spray or brush. On concrete surfaces use roller. Stir the resin and cure separately and then mix both components thoroughly. The mixing ratio is 4:1 (resin:cure) by volume. If needed 5-15 % thinner (OH 66 or OH 17 or OH 10) may be added. When using a roller, use thinner (OH 12) 5-10 %.

Use a high-pressure airless spray with a nozzle tip of 0.011" - 0.015" orifice. **Don't use an adjustable spraying nozzle.** The spray angle depends on the object to be painted.

SAFETY

Please follow the environmental and safety instructions displayed on the container and Safety Data Sheet.

Use under well ventilated conditions. Do not breathe or inhale mist, use respirator mask. Avoid skin contact. Spillage on the skin should immediately removed with suitable cleanser, soap and water. In case of contact with eyes, rinse immediately with plenty of clean water and if necessary seek medical advice.

For specific information on hazardous constituents and more detailed safety measures see Safety Data Sheet.

DISCLAIMER

The above information is given to the best of our knowledge based on laboratory tests and practical experience. However, as the paint is often used under conditions beyond our control, we cannot guarantee anything but the quality of the paint itself. We reserve the right to change the given data without notice.