

NORMADUR 90 HS

Polyurethane Coating

DATA SHEET 2/08

PROPERTIES AND RECOMMENDED USAGE

Paint type:

NORMADUR 90 HS is a two component, glossy and high-solid polyurethane coating with an aliphatic isocyanate curing agent. Cures also at low temperatures.

Typical uses:

NORMADUR 90 HS can be used in atmospheric corrosivity classes C1-C3 as a gloss retaining and wear resistant **single coat system** on easily painted steel products such as doors, transport containers and agriculture machines. It can also be used as a **top coat** on steel structures, ships, containers and vehicles both in and out of doors in epoxy and polyurethane systems. NORMADUR 90 HS has a good gloss and colour retention.

Most common SFS-EN ISO 12944-5 systems:

- PUR80/1 - FeSa2½
- EPPUR120/2 - AlSaS
- A7.10 EPPUR120/2 - ZnSaS
- A4.19 EPZn(R)PUR160/2 - FeSa2½

Chemical resistance:

Used in recommended paint systems, and correctly applied NORMADUR 90 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. 60 vol.%
Total mass of solids*:	approx. 800 g/l
VOC value*: (Volatile organic compound)	approx. 370 g/l

(*Values are calculated.)

Mixing ratio:

Resin 4 parts by volume
Cure 1 part by volume

Pot life: at +23°C

approx. 1,5 h after mixing

Drying times: at +23°C / 50 µm dft:

Surface dry	½ hrs
To touch	2 hrs
To recoat	10 hrs

Calculated theoretical coverage and recommended film thickness:

Dry	Wet	Coverage
40 µm	65 µm	15.0 m ² /l
50 µm	85 µm	12.0 m ² /l
80 µm	135 µm	7.5 m ² /l

Practical coverage:

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

Colour: RAL-, NCS-, KY-, SSG-colours

Thinner and Cleaner: OH 10 or OH 26
Usually needs no thinning. If needed 0-5 %.

Finish: Gloss

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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.

Aluminium surfaces:

Remove grease and other contaminants. Sand-sweeping before painting improves adhesion. Normadur 90 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.

Primer:

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

Top Coat:

NORMADUR 90 HS

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 airless spray or brush. Stir resin and cure separately and then mix both components thoroughly. The mixing ratio is 4:1 (resin:cure) by volume. If needed, 0-5 % thinner OH 10 or OH 26 may be added. High pressure airless spray with a nozzle tip of 0,011" orifice when painting small products and 0,013-0,017" orifice when painting large surface areas. Spray angle depending 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.