

# NORMADUR HB

## Polyurethane Coating

### DATA SHEET 2/08

#### PROPERTIES AND RECOMMENDED USAGE

**Paint type:**

NORMADUR HB is a semi gloss, two component polyurethane coating with an aliphatic isocyanate curing agent. NORMADUR HB cures also at low temperatures.

**Typical uses:**

NORMADUR HB is used as a top coat indoor and outdoor surfaces of steel structures, ships, containers and vehicles in epoxy- and polyurethane paint systems in atmospheric corrosivity classes C2-C4, C5-I and C5-M when good gloss and colour retention is required.

Can also be used as a primer in polyurethane paint systems and as a single coat system on steel surfaces in corrosivity class C2.

**Most common SFS-EN ISO 12944-5 systems:**

- A4.13 EPZn(R)EPPUR160/3-FeSa2½
- A4.08 EPPUR240/3-FeSa2½
- A5I.04 EPZn(R)EPPUR240/4-FeSa2½

**Chemical resistance:**

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

**Weather stability:**

Withstands sunlight and UV radiation.

#### TECHNICAL DATA

<b>Volume solids:</b>	approx. 58 vol.%
<b>Total mass of solids*:</b>	approx. 840 g/l
<b>VOC value*:</b> (Volatile organic compound)	approx. 380 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:** 50 µm dft:

	0°C	5°C	10°C	23°C	40°C
To touch	16 h	8 h	4 h	2 h	1 h
To handle	50 h	35 h	20 h	10 h	5 h
Fully cured	20 d	15 d	10 d	5 d	2 d
To recoat	30 h	21 h	12 h	6 h	3 h

**Calculated theoretical coverage and recommended film thickness:**

Dry	Wet	Coverage
60 µm	100 µm	9,7 m²/l
80 µm	140 µm	7,2 m²/l
100 µm	170 µm	5,8 m²/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

**Finish:** Semi 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 HB 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, EPOCOAT 21 MIO, JOTAMASTIC 87, NORMASTIC 405, NORMADUR HB

**Top Coat:**

NORMADUR HB, NORMADUR 65 HS, 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 0°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, 0-10 % thinner OH 10 may be added. High pressure airless spray with a nozzle tip of 0,013"-0,018" orifice. 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.