

Technical Data

Normafloor 205

PROPERTIES AND RECOMMENDED USAGE

Paint type:

Normafloor 205 is a two component solvent free epoxy based primer.

Typical uses:

A "dust seal" varnish used for concrete floors in combination with NORMA-FLOOR epoxy paints and coatings. NORMAFLOOR 205 is also used as a binder to improve adhesion with NORMAFLOOR 2500 Screed (see separate data sheet).

Chemical resistance:

When applied correctly Normafloor 205 withstands occasional contact with water, oil and a range of process chemicals.

TECHNICAL DATA

Volume solids:	approx. 100 vol. %
Total mass of solids*:	approx. 1090 g/l
VOC value*:	approx. 0 g/l

*Values are calculated.

Mixing ratio:

Resin 2 parts by volume
Cure 1 part by volume

Pot life (+23 °C):

Approx. 20 minutes after mixing.
(1 hour when poured on the floor)

Drying times:

	+15 °C	+23 °C
Surface dry	6 h	4 h
To walk on	24 h	16 h
To recoat	12-30 h	6-24 h
Fully cured	10 d	7 d

Practical coverage:

Priming: 3-6 m²/l
Top coating: 6-10 m²/l

Depends on method of application and the porosity of the floor. For exceptionally porous floors priming twice is recommended.

Colour:

Clear

Thinner:

OH 13 or OH 17

Cleaner:

OH 17

Finish:

Gloss

APPLICATION INSTRUCTIONS

Surface preparations:

New concrete surface: The concrete must be dry and at least 4 weeks old, and humidity no more than 97 % (4 % by weight). 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. Additives such as melamine resins, silicones or silicates that might decrease the adhesion or absorption of the coating, must not be used. Loose concrete, laitance, residues of plastic dispersions and waxes should be removed from the concrete surface with abrasive blasting or grinding. If required a 15-20 % hydrochloric acid solution could be used.

Old concrete surface: Remove oils and other contaminants by emulsion cleansing. Surfaces that are contaminated by oils and fats should in addition be flame cleaned. Possible laitance removal as for new concrete surfaces.

Environmental conditions during application:

During application and drying time the temperature of the varnish should be above +15 °C, air and surface temperature should not be below +10 °C and the relative humidity below 70 %. The surface temperature should be min 3 °C above the dew point of the air. Best result and easiest working conditions are in temperatures between +18 °C - +25 °C.

Mixing the components:

The cure is added to the resin in the correct mixing ratio 2:1 (resin:cure) shortly before the application. Must be thoroughly mixed by a mechanical mixer **in a clean mixing vessel. The mixture should then be emptied into a clean vessel and mixed again. The possible sand addition is made after that during mixing.** Curing and final finish may be affected if mixing has been insufficient. The pot life of the mixture can be prolonged if it is poured on to the surface to be painted immediately after mixing.

Priming:

Normafloor 205 should be spread on the floor with a steel spreader, a fine mohair roller or a paint brush. The varnish can be thinned 15-40 % using OH 17 or OH 13 to improve absorption. If absorption is insufficient, it can be improved after 1-16 hours. If the floor is to be covered with Normafloor 2500 Epoxy Screed or if conditions during application differs from normal, quartz sand, 0,6-1,2 mm, should be spread to ensure adhesion. In order to ensure the best possible performance of the product, it is recommended that the paint is at room temperature before the application.

Further coating:

It is recommended that further surface application of solvent-free Normafloor products is carried out within 24 hrs of priming (+23 °C).

Storage and shelf life:

The product must be stored in original sealed containers at temperatures from 5°C to 30°C. The storage conditions are to keep the containers in a dry, well ventilated space away from source of heat and ignition. When stored as described above, the unopened component A will keep up to **3 years** and unopened component B to **2 years** from the date of manufacture. The date of manufacture is indicated in the label of the paint can as a batch date.

CE marking:

	
0416	
Nor-Maali Oy Vanhatie 20 15240 Lahti, Finland Declaration of performance No. NOR1-0114 NOR2-0114	
0416-CPR-7826 EN 1504-2:2004 Surface protection products - Coating Physical resistance (5.1) Chemical resistance (6.1)	
Abrasion resistance	Weight loss < 3000 mg
Capillary absorption and permeability to water	$w < 0,1 \text{ kg/m}^2 \cdot \text{h}^{0,5}$
Resistance to severe chemical attack	See chemical resistance list
Impact resistance	Class II: $\geq 10 \text{ Nm}$
Adhesion strength by pull-off test	$\geq 2,0 \text{ N/mm}^2$
Dangerous substances	See safety data sheet

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 or water. In case of contact with eyes, rinse immediately with plenty of clean water and if necessary seek medical advice.

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. Please contact our office for more specific information.

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