

# NORMASTIC 405

## high-solids epoxy coating

### TECHNICAL DATA SHEET 6/09

**PROPERTIES AND RECOMMENDED USAGE:**

**Paint type:**

NORMASTIC 405 is a two-component, pigmented with micaceous iron oxide, epoxy based primer/topcoat, which may be applied in high film thickness. Contains special ingredients which penetrate through existing rust.

**Typical uses:**

NORMASTIC 405 is used over mechanically cleaned or blast cleaned surfaces as a primer or topcoat in environment classes C2-C4 and C5-I, C5-M. Can be used as a single coat on box girders and plate structures. Also suitable for maintenance painting on deep-seated rust and old paint surfaces. NORMASTIC 405 is also suitable for immersion in fresh water and sea water on blast cleaned (Sa2½) steel surface.

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

- EP250/2-FeSt2
- EP120/1-FeSa2½
- A4.09 EP280/3-FeSa2½
- A4.15 EPZn(R)EPPUR240/3-FeSa2½
- A5M.04 EP500/2-FeSa2½
- A6.01 EPZn(R)EP360/3-FeSa2½

**Chemical resistance:**

When mixed as recommended and applied according to the instructions NORMASTIC 405 has good resistance to water and range of process chemicals when exposed to immersion or continued spillage. More precise details of chemical resistance should be clarified for each particular case.

**Weather resistance:**

NORMASTIC 405 will lose its gloss under the influence of UV-radiation, which also may cause slight yellowing in light colours.

**TECHNICAL DATA**

<b>Volume solids:</b>	approx. 80 vol.%
<b>Total mass of solids*:</b>	approx. 1230 g/l
<b>VOC value*:</b> (Volatile organic compound)	approx. 180 g/l

(\*Values are calculated.)

**Mixing ratio:**

Resin                    1 part by volume  
Cure                     1 part by volume

**Pot life:** at +23°C

approx. 1 h after mixing

**Drying times:**

200 µm dft at:	<b>+23°C</b>
To touch	3 h
To handle	5 h
To recoat (with itself)	7 h
Fully cured	7 d

When exposed to immersion min. recoating time is 24 hr's.

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

Dry	Wet	Coverage
120 µm	150 µm	6,7 m <sup>2</sup> /l
200 µm	250 µm	4,0 m <sup>2</sup> /l
300 µm	375 µm	2,7 m <sup>2</sup> /l

**Practical coverage:**

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

**Colour:** Grey, red and industrial paint colours with limitations

**Thinner and cleaner:** OH 17

**Finish:** Semimatt

# NORMASTIC 405

## high-solids epoxy coating

### APPLICATION INSTRUCTIONS

**Surface preparation:**

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:**

Exposed to weather: Sand blasting to Sa 2 or steel brushing to min. St2.

Exposed to immersion: Sand blasting to min. Sa2½ (SFS-ISO 8501-1, SFS-EN ISO 8504-2).

**Old painted surfaces:**

NORMASTIC 405 may be used over most types of properly prepared and tightly adhering coatings, however a test patch is recommended for use over existing coating.

**Primer:**

NORMASTIC 405, NORMAZINC SE, EPOCOAT 21 PRIMER, EPOCOAT 21 HB

**Top coat:**

NORMASTIC 405, EPOCOAT 210, NORMADUR 65 HS, NORMADUR 90 HS, NORMALOX 333

**Environmental conditions during application:**

The surface to be coated must be dry. During application and drying, the temperature of the coating, air and surface should be above +10°C, and the relative air humidity below 80 %. The temperature of the surface to be coated should be at least 3°C above the dew point of the air. Exhaust gases during drying time may cause yellowing of the paint film.

**Method of application:**

Use high pressure airless spray or brush. Stir resin and cure separately and then mix both components thoroughly. The mixing ratio is 1:1 (resin:cure) by volume. Thin only when needed 5-10 % (OH 17). High pressure airless spray with a nozzle tip of 0,017"-0,023" 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.