

# NORMAZINC SE

## Zinc Epoxy Primer

### DATA SHEET 9/08

#### PROPERTIES AND RECOMMENDED USAGE

##### Paint type:

NORMAZINC SE is a two-component zinc epoxy primer. Complies with the compositional requirements for SSPC Paint 20 level 2 and ISO 12944.

##### Typical uses:

NORMAZINC SE is recommended to use as a primer in epoxy systems in environment classes C3-C4 and C5-I/C5-M on blast cleaned steel surfaces. Provides cathodic protection and prevents corrosion under the paint film. Can also be used thinned as a zinc epoxy shopprimer (20 µm).

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

A3.11 EPZn(R)EP160/2-FeSa2½  
 A4.13 EPZn(R)EP160/3-FeSa2½  
 A4.13 EPZn(R)PUR160/2-FeSa2½  
 A5I.04 EPZn(R)EPPUR240/4-FeSa2½

##### Chemical resistance:

Used in recommended paint systems and correctly applied NORMAZINC SE withstands occasional splashes and spillage of water and a wide range of weak process chemicals.

#### TECHNICAL DATA

<b>Volume solids:</b>	approx. 53 vol.%
<b>Total mass of solids*:</b>	approx. 1740 g/l
<b>VOC value*:</b> (Volatile organic compound)	approx. 420 g/l

(\*Values are calculated.)

##### Mixing ratio:

Resin 3 parts by volume  
 Cure 1 part by volume

##### Pot life: at +23°C

approx. 8 hrs after mixing

##### Drying times:

	40 µm dft at:	+23°C
Surface dry		10 min
To recoat:		
<input type="checkbox"/> with epoxy paints		1½ h
<input type="checkbox"/> with other type of paints		4 h

When exposed to immersion min. recoating time is 12 hr's.

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

Dry	Wet	Coverage
40 µm	75 µm	13,3 m²/l
60 µm	115 µm	8,8 m²/l
80 µm*	150 µm	6,7 m²/l

\* In complicated structures, painting is recommended to be done with two coats.

##### Practical coverage:

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

**Colour:** Bluish grey

**Thinner and cleaner:** OH 17

**Finish:** Matt

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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, detergent or solvent cleaning (SFS-EN ISO 8504-3, SFS-EN ISO 12944-4).

**Steel surfaces:**

To be blast cleaned to a min of Sa2½ (SFS-ISO 8501-1, SFS-EN ISO 8504-2).

**Touch-up:**

For touch-up purposes surface must be cleaned to St 3 with grinder.

**Primer:**

NORMAZINC SE

**Top coat:**

NORMASTIC 405, EPOCOAT 21 PRIMER, EPOCOAT 21 HB, EPOTEX HB, NORMASPEED 100 PRIMER, NORMADUR 65 HS

*(Note! See recoating times front page)*

**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 air humidity below 80 %. The surface temperature should be min 3°C above the dew point of the air.

**Method of application:**

Use high pressure airless spray or brush. Stir resin and cure separately (slow stirring) and then mix both components thoroughly with propeller stirrer. The mixing ratio is 3:1 (resin:cure) by volume. High pressure airless spray with a nozzle tip of 0,013"-0,018" orifice. Spray angle depending on the object to be painted.

**NOTE:**

Leave the paint after mixing 30 min before spraying to prevent any air bubbles occurring.

**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.