NOREGUARD HS

TECHNICAL DATA SHEET 9/19

PROPERTIES AND RECOMMENDED USAGE

Paint type
A two-component, fast drying high solids epoxy coating. Product contains active rust preventing pigments. The paint cures in low temperatures.

Typical and recommended uses
NOREGUARD HS is recommended to use as a primer, mid or top coat on zinc epoxy primer or other two-component epoxy primer in environmental classes C2-C5. Can be used as a single-coat system in environmental classes C1-C3.

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

Weather resistance
Epoxy paints have a natural tendency to chalk and discolor on exterior exposure.

Colour
RAL-, NCS-, KY-, SSG-colours with limitations. The objects painted with the same shade, but using different paint types, might have differences in the appearance and shade due to the variation in the paint properties, gloss levels and application methods.

Finish
Semigloss

TECHNICAL DATA

Volume solids*	78 ± 2%
Total mass of solids*	1300 g/l
VOC value*	210 g/l

* Values are calculated

Mixing ratio

Resin	5 parts by volume
Cure	1 part by volume

Pot life (+23 °C)
approx. 1 h after mixing

Packaging

	Volume (l)	**Size of container (l)**
Comp A	15	20
Comp B	3	5

Drying time 80 µm

	+5 °C	**+10 °C**	**+23 °C**
Surface dry	4 h	3 h	2 h
To touch	10 h	7 h	4 h
To recoat - same type of paint - polyurethanes	 8 h 10 h	 6 h 8 h	 3 h 4 h
Fully cured	14 d	10 d	7 d

The maximum overcoating time is 3 months without roughening provided the surface is free from dirt and grease. If the coating has been exposed to direct sunlight for some time, special attention must be paid for the removal of chalking with the suitable method before the painting work. Drying times are typical on recommended film thicknesses at given temperatures.

Calculated theoretical coverage and recommended film thickness

Dry	**Wet**	**Coverage**
80 µm	105 µm	9.5 m²/l
120 µm	155 µm	6.5 m²/l
150 µm	195 µm	5.1 m²/l
200 µm	255 µm	3.9 m²/l

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

Thinner
OH 17

Cleaner
OH 17

APPLICATION INSTRUCTIONS

Surface preparations
All solid impurities that could prevent adhesion should be removed from the surfaces to be painted. Remove salts and other water soluble impurities using fresh water with brush, high pressure-, steam- or alkali cleansing. Remove grease and oils by alkali-, emulsion- or solvent cleansing (SFS-EN ISO 8504-3, SFS-EN ISO 12944-4). The surfaces should be rinsed carefully with fresh water after clensing. Old, painted surfaces, in which the maximum overcoating interval has expired, the additional roughening with suitable method is recommended. The place and time for the surface preparation should be chosen correctly, to avoid contamination and moistening of the treated surface before the paint application.

Steel surfaces
Blast cleaning to minimum of Sa 2½ (SFS-EN ISO 8501-1, SFS-EN ISO 8504-2).

Primer
NORMAZINC SE, NORECOAT HS PRIMER, NOREGUARD HS

Top coat
EPOCOAT 210, EPOTEX HB, NOREPOX HS, HARDTOP XP, HARDTOP XPF, NORMADUR 50 HS, NORMADUR 65 HS, NORMAFINE 50 TC, NORMAFINE HS, NOREGUARD HS

Environmental conditions during application
The surface to be coated must be dry. During the application, the temperature of the coating should be at least +10 °C. During the application and drying of the paint, the temperature of the surface and the air should be above +5 °C and 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.

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 5:1 (resin:cure) by volume. If needed thin 0-10 % (thinner OH 17). High pressure airless spray with a nozzle tip of 0,013”-0,018 orifice. Spray angle depending on the object to be painted. Pressure ratio of the spray pump must be minimum 45:1. In order to ensure the best possible performance, it is recommended that the paint is at room temperature before the application.

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 2 years and unopened component B to 2 years from the date of manufacture. The manufacturing date found in the label is also the batch number of the paint.

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. The product is intended for professional use only. If there are deviations in the different language versions of the technical data sheets, the English version applies.