

NOREPOX AQUA DTM

TECHNICAL DATA SHEET 10/23

PROPERTIES AND RECOMMENDED USAGE

Paint type

Quick drying, water-borne two-component epoxy primer, topcoat and direct-to-metal coating with polyamine adduct curing agent. Product contains rust preventing pigments.

Typical and recommended uses

Recommended to use as a primer, topcoat or direct-to-metal coating in epoxy paint systems in environmental classes C2 - C4. Can also be coated with polyurethane paints.

Chemical resistance

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

Colour

RAL and NCS colours. More information from Nor-Maali Oy's sales department. Note! Colour darkens when it dries. 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

Semi gloss

Thinner

OH 00

Cleaner

Water

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.

Approved as belonging to emission class M1 for building materials



TECHNICAL DATA

Volume solids*	50 ± 2 %
Total mass of solids*	814 g/l
VOC value*	62 g/l

* Values are calculated

Mixing ratio

Resin	4 parts by volume
Cure	1 part by volume

Pot life (+23 °C)

approx. 1.5 h after mixing

Packaging

	Volume (l)	Size of container (l)
Comp A	16	20
Comp B	4	5

Drying time 80 µm

	+15 °C	+23 °C
Surface dry	30 min	20 min
To touch	2 h	1 h 30 min
To handle	10 h	8 h
To recoat		
- polyurethanes	8 h	6 h
- itself	6 h	4 h
Fully cured	10 d	7 d

Drying times are typical on recommended film thicknesses at given temperatures. **Ventilation needs to be efficient enough. Moisture must be removed from the coating. Relative humidity must be below 50 %.** The maximum overcoating time is 4 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.

Calculated theoretical coverage and recommended film thickness

Dry	Wet	Coverage
80 µm	160 µm	6.2 m ² /l
100 µm	200 µm	5.0 m ² /l
120 µm	240 µm	4.1 m ² /l

As many of the paint's properties will change if too thick coats are applied, it is not recommended that the product is applied to a film thickness that is more than double of the thickest recommended film.

Practical coverage

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

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 cleansing. Old, painted surfaces, in which maximum overcoating interval has expired, 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 Sa 2½ (SFS-ISO 8501-1, SFS-EN ISO 12944-4).

Aluminium surfaces

Remove grease and other contaminants. Sand sweeping before painting improves adhesion. NOREPOX AQUA DTM does not adhere to marine aluminium without primer.

Primer

NOREPOX AQUA DTM, EPOCOAT 21 PRIMER, NORECOAT FD PRIMER, NORECOAT HS PRIMER, NORMAZINC SE

Primer has to be thoroughly undamaged and rustless before the topcoat is applied.

Top coat

NOREPOX AQUA DTM, NORMADUR AQUA DTM, NORMADUR 50 HS, NORMADUR 65 HS, NORMAFINE 20, NORMAFINE 50 TC, NORMAFINE 80, NORMAFINE HS, EPOTEX HB, NOREPOX HS

Environmental conditions during application

The surface should be dry and clean. During application and drying time the temperature of the air and surface should be above 15 °C and the relative humidity below 50 %. The surface temperature should be min. 3 °C above the dew point of the air.

Mixing the components

The mixing ratio is 4 : 1 (resin : cure) by volume. Thinning 0 - 5 % (OH 00). **Components are stirred mechanically first separately and then together thoroughly down to the bottom.** Insufficient mixing and/or incorrect mixing ratio will result in uneven curing and impaired film properties. Thinner will be added to the ready mixture. Pot life is 1.5 hours. **There is no visible pot life so the time has to be checked with a clock.** After 1.5 hours the mixture is not applicable for use.

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.

Method of application

Use an airless spray or brush. **In order to ensure the best possible performance of the product, it is recommended that the paint is at room temperature (> 20 °C) before the application.** Airless spray: Pump ratio (min.): 1-component equipment: 30:1 and 2-component equipment: 60:1, use 100 Mesh (yellow) spray gun filter and a nozzle tip of 0.011" – 0.015" orifice. The spray angle depends on the object to be painted.

To avoid solvent contamination of the water-borne paint the spraying equipment has to be conditioned before use. All equipment containing solvents in the pump, hoses and gun have to be thoroughly cleaned. If the application equipment is made of stainless steel, designed for and only used for application of water-borne coatings, there is no need for this cleaning procedure. Ensure the good ventilation during the application and drying time. (Note that evaporated water is lighter than air.)

If the spraying equipment has been used for painting solvent-borne paints, cleaning before spraying:

Circulate thinner OH 17 through the equipment and hoses, then thinner OH 04/OH 13 before fresh clean water.

Cleaning after spraying:

Clean the equipment and hoses with water. Then circulate thinner OH 04/OH 13 and finally thinner OH 17.

Cleaning of the spraying equipment when it is only used for painting water-borne paints:

1-component spraying equipment: Clean the equipment and hoses with water, if needed OH 04/OH 13 and OH 17. After cleaning with OH 17, rinse the spraying equipment with OH 04/OH 13 and finally with fresh water.

2-component spraying equipment: Ask instructions from Nor-Maali Oy's sales department.

Storage and shelf life

The product must be stored in original sealed containers at temperatures from 5 °C to 30 °C. **The product should not freeze.** The storage conditions are to keep the containers in a dry, well ventilated space away from the source of heat and ignition. When stored as described above, the unopened component A will keep up to 1 year and unopened component B to 1 year from the date of manufacture. The manufacturing date found in the label is also the batch number of the paint.