

NORMADUR 65 HS

TECHNICAL DATA SHEET 8/20

PROPERTIES AND RECOMMENDED USAGE ON CONCRETE SURFACES

Paint type

NORMADUR 65 HS is a fast drying, flexible polyurethane coating with an aliphatic isocyanate curing agent. NORMADUR 65 HS is high solid and contains rust preventing pigments.

Typical and recommended uses

Used as a floor coating on concrete surfaces. NORMADUR 65 HS has good impact resistance.

Chemical resistance

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

Weather resistance

Withstands sunlight and UV radiation.

	
Nor-Maali Oy Vanhatie 20 15240 Lahti, Finland 17 DoP Nr. NOR1-0420 0416-CPR-7826	
EN 1504-2:2005 Surface protection products - Coating Physical resistance (5.1)	
Abrasion resistance	Weight loss < 3000 mg
Capillary absorption and permeability to water	W ₃ (w < 0,1 kg/m ² ·h ^{0.5})
Impact resistance	Class II: ≥ 10 Nm
Adhesion strength by pull-off test	≥ 2.0 N/mm ²
Dangerous substances	See safety data sheet

TECHNICAL DATA

Volume solids*	65 %
Total mass of solids*	890 g/l
VOC value*	310 g/l

* Values are calculated

Mixing ratio

Resin	4 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	8 / 16	10 / 20
Comp B	2 / 4	2.5 / 4

Drying time 80 µm

	-5 °C	+10 °C	+15 °C	+23 °C
Surface dry	12 h	1 h	45 min	30 min
To touch	30 h	3.5 h	2.5 h	2 h
To overcoat	48 h	6 h	4.5 h	3 h
Fully cured	-	10 d	8 d	7 d

Drying times are typical on recommended film thicknesses at given temperatures.

Practical coverage on concrete surfaces

Priming	Top coating
4-7 m ² /l	4-9 m ² /l

Practical coverage depends on the method of application and the porosity of the surface. For exceptionally porous surfaces, priming two times is recommended.

Colour

NCS-, RAL-, 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.

Thinner

OH 10, OH 17, OH 66 (slow)

Cleaner

OH 17

Finish

Semigloss (gloss if coated with Normadur Clear)

APPLICATION INSTRUCTIONS FOR CONCRETE SURFACES

New concrete surface

The concrete must be dry and at least 4 weeks old, and humidity no more than 97 % (4 % by weight). If a humidity gauge is not available, the floor humidity can be tested 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. The concrete must be hard and strong enough (at least 80 % of the final strength) and 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.

Previously painted epoxy coating

Grease and oil should be removed by emulsion cleaning. Surfaces should be roughened down by grinding. Holes and cracks must be filled with a epoxy filler.

Old concrete surface

Grease and other dirt is removed from uncoated surfaces by emulsion cleaning. Grease removal can be made more effective by flame cleaning. An old coating or laitance is removed by sand blasting, milling or grinding. Holes and cracks must be filled with a epoxy filler. Other methods as for 'New concrete surfaces'.

Asphalt surface

Asphalt should be over 6 months old, dry and clean.

Primer

NORMAFLOOR 105 GPR, NORMAFLOOR 205

Top coat

NORMADUR 65 HS, NORMATOP CLEAR

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

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

On concrete surfaces use roller. Stir the resin and cure separately and then mix both components thoroughly. The mixing ratio is 4:1 (resin:cure) by volume. When using a roller, use thinner (OH 12) 5-10 %. In order to ensure the best possible performance of the product, it is recommended that the paint is at room temperature before the application.

Priming (concrete surfaces)

Thinned paint should be spread on the floor with a steel spreader, mohair roller or a paint brush. If absorption is insufficient, repairing can be done after 8 hours (+23 °C). On a porous or new concrete surface the priming is performed with Normafloor 105 GPR epoxy primer.

Top coating (concrete surfaces)

The application of the coating is recommended to make within 8 h – 3 days after priming (+23 °C). The top coating is applied with 5-10 % thinned NORMADUR 65 HS. Should be spread with a fine mohair roller, roller or a paint brush.

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 1,5 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.