

NORMAFINE 20

TECHNICAL DATA SHEET 9/20

PROPERTIES AND RECOMMENDED USAGE

Paint type

Fast drying, semi matt, flexible polyurethane coating with an aliphatic isocyanate curing agent. NORMAFINE 20 contains rust preventing pigments.

Typical and recommended uses

NORMAFINE 20 can be used in environmental classes C2 and C3 as a durable single coat (DTM) system. It can be used as a topcoat in classes C2-C5 on various primers, and as maintenance coating on old paint surfaces. Can also be used as a primer in polyurethane paint systems. Can be used on general structural steel constructions such as storage tanks, transport containers, transportation vehicles (trucks, trains etc.), agricultural, construction and earthmoving (ACE) equipment. NORMAFINE 20 has good impact resistance and coating properties.

Chemical resistance

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

Weather resistance

Whitstands sunlight and UV radiation.

TECHNICAL DATA

Volume solids*	56 ± 2 %
Total mass of solids*	920 g/l
VOC value*	380 g/l

* Values are calculated

Mixing ratio

Resin	8 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	10
Comp B	1	1

Drying time 50 µm

	+23 °C
To touch	20 min
To handle	1 h
To recoat, polyurethanes	30 min
Fully cured	7 d

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

Calculated theoretical coverage and recommended film thickness

Dry	Wet	Coverage
80 µm	145 µm	6.8 m ² /l
100 µm	180 µm	5.5 m ² /l
120 µm	215 µm	4.6 m ² /l

Practical coverage

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

Colour

NCS-, RAL-, KY-, SSG-colours with limitations. Aluminium shades 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 66 (slow), OH 17 (statics)

Cleaner

OH 17

Finish

Semi matt

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 a min. of Sa 2½ (SFS-ISO 8501-1, SFS-EN ISO 8504-2). Cold rolled plates must be roughened with abrasive paper.

Shop primed surfaces

Damaged or corroded surfaces should be blast cleaned to a grade of Sa 2½ (SFS-ISO 8501-2, SFS-EN ISO 12944-4).

Aluminium surfaces

Remove grease and other contaminants. Sand sweeping before painting improves adhesion. Does not adhere to marine aluminium without primer.

Primer

EPOCOAT 21 PRIMER, EPOCOAT 21 HB, NORMAZINC SE, NORECOAT FD PRIMER, NORMAFINE 20

Top coat

NORMAFINE 20, NORMAFINE 50 TC, NORMAFINE HS, NORMAFINE 80, NORMADUR 65 HS, NORMADUR 50 HS

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.

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.

Method of application

Use airless spray or brush. Stir the resin and cure separately and then mix both components thoroughly. The mixing ratio is 8:1 (resin:cure) by volume. If needed thin 5-10 % (thinner OH 10). Use a high pressure airless spray with a nozzle tip of 0,011"-0,015" orifice. The spray angle depending the object to be painted. In order to ensure the best possible performance of the product, 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 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.