

NORMAFINE 50 TC

TECHNICAL DATA SHEET 1/21

PROPERTIES AND RECOMMENDED USAGE

Paint type

Semigloss, two-component, high solids acrylic polyurethane topcoat with an aliphatic isocyanate curing agent. The paint cures at low temperatures.

Typical and recommended uses

Recommended as a topcoat on steel structures, ships, containers and vehicles both in- and outdoors in epoxy and polyurethane paint systems. The paint has a good gloss and colour retention. Suitable topcoat for environmental classes C2-C5 on various primers.

Weather resistance

Withstands sunlight and UV radiation.

TECHNICAL DATA

Volume solids*	65 ± 2 %
Total mass of solids*	1020 g/l
VOC value*	310 g/l

* Values are calculated

Mixing ratio

Resin	9 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	9	10
Comp B	1	1

Drying time 50 µm

	+10 °C	+23 °C
Surface dry	2 h	50 min
To touch	5 h	2 h
To recoat	30 h	7 h

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

Calculated theoretical coverage and recommended film thickness

Dry	Wet	Coverage
50 µm	80 µm	12.5 m ² /l
80 µm	125 µm	8.0 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. 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

Cleaner

OH 17

Finish

Semigloss

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 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.

Primer

EPOCOAT 21 PR, EPOCOAT 21 HB, NORECOAT FD PRIMER, NORECOAT HS PRIMER, NORMASTIC 405, NORMAZINC SE, PENGUARD EXPRESS

Top coat

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Environmental conditions during application

The surface should be dry. 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

Use high pressure airless spray or brush. Stir resin and cure separately and then mix both components thoroughly. The mixing ratio is 9:1 (resin:cure) by volume. If needed thin 0-10 % (thinner OH 10). High pressure airless spray with a nozzle tip of 0,011" - 0,015 orifice. Spray angle depending on the object to be painted. 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 1½ 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.