NORMAFLOOR 2500

TECHNICAL DATA SHEET 4/20

PROPERTIES AND RECOMMENDED USAGE

Paint type
NORMAFLOOR 2500 is a solvent free highly filled heavy duty epoxy screed. It is a mix of NORMAFLOOR 205 Primer, coloured sand or screed quartz sand. Recommended thickness is 4 - 6 mm.

Typical and recommended uses
Concrete floors exposed to aggressive mechanical and/or moderate chemical stress in wood processing and chemical industry.

Applications
Pulp- and paper mills, slaughter houses, laundries, warehouse ramps etc.

Chemical resistance
Resistant to water and a range of process chemicals in occasional contact and immersion stress.

TECHNICAL DATA

Volume solids*	100 %
Total mass of solids*	1090 g/l
VOC value*	0 g/l

* Values are calculated (without sand filling.)

Mixing ratio and package sizes (Standard packages)

Normafloor 205	**4 mm**
Resin (l)	20
Cure (l)	10
Coloured sand (0.6 – 1.2 mm)	100 l = 150 kg
Total	130 l

In more than 5 mm thich screed is recommended to use also 1.0 - 1.8 mm coloured sand partly.

Pot life (+23 °C)
approx. 30 minutes after mixing (in container)
approx. 1 - 2 hours after mixing (poured on the floor)

Drying time

	+23 °C
To walk on	24 h
Fully cured	7 d

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

Calculated theoretical coverage and recommended film thickness

Dry	**Ready mixed**	**NORMAFLOOR 205**
4.0 mm	0.25 l/m²	1.1 l/m²
6.0 mm	0.17 l/m²	1.7 l/m²

Colour
Depending on the coloured sand used.

Thinner
MUST NOT BE THINNED

Cleaner
OH 17
Compressive strength (ASTM C 579) approx. 90 N/mm²
Tensile strength (ASTM C 307) approx. 11 N/mm²
Bond strength (BS 1881/207) approx. 2 N/mm²

APPLICATION INSTRUCTIONS

New concrete surfaces
The concrete must be dry and at least 4 weeks old, and humidity no more than 97 % (4 % by weight). The floor humidity can be tested, if a humidity gauge is not available, 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. 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.

Old concrete surfaces
Remove oils and other contaminants by emulsion cleansing. Surfaces that are contaminated by oils and fats should in addition be flame cleaned. Possible laitance removal as for new concrete surfaces.

Environmental conditions during application
During application and drying time the temperature of the varnish should be above +15 °C, air and surface temperature should not be below +10 °C and the relative humidity below 70 %. The surface temperature should be min 3 °C above the dew point of the air. Best result and easiest working conditions are in temperatures between +18 °C - +25 °C. Application direct sunlight and rising surface temperatures can result in bubbling of the surface due to release of air or moisture from concrete.

Mixing the components
The cure is added to the resin in the correct mixing ratio 2 : 1 (resin : cure) shortly before the application. Must be thoroughly mixed by a slow rotating mechanical mixer. The mixture should then be emptied into a larger vessel where the sand is added during continuous mixing (mixing with concrete mixer or slow rotating mechanical mixer). Curing and final finish may be affected if mixing has been insufficient. The pot life of the mixture can be prolonged if it is poured on to the surface to be painted immediately after mixing.

Priming
To improve adhesion and to avoid air bubbles the concrete surface is primed with thinned NORMAFLOOR 205 solvent free epoxy primer according to data sheet. If the concrete is damp or new and the tem-perature is below +15 °C, the primer recommended is NORMAFLOOR 105 Epoxy Primer. In order to ensure the best possible performance it is recommended that the paint is at room temperature before the application.

Method of application
Recoating starts 6 - 24 hours after priming. The mixture should be poured evenly over the whole floor where it then is spread by a height adjustable steel spreader (mortar board or massbox) to required thickness. The final surface should be polished with either a steel spreader or a “helicopter” polisher.

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 3 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.

CE

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Vanhatie 20
15240 Lahti, Finland
DoP Nr. NOR1-0420
0416-CPR-7826

EN 1504-2:2004
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 $kg/m^2 \cdot h^{0.5}$)
Impact resistance	Class II: ≥ 10 Nm
Adhesion strength by pull-off test	≥ 2.0 N/mm^2
Dangerous substances	See safety data sheet

CE

Nor-Maali Oy
Vanhatie 20
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DoP Nr. NOR6-0420

SR-B2, 0-RWA10-IR10
EN 13813:2002
Synthetic resin screed

Release of corrosive substances	SR
Capillary absorption and permeability to water	W_3 (w < 0,1 $kg/m^2 \cdot h^{0.5}$)
Abrasion resistance EN 13892-5	RWA 10
Adhesion strength by pull-off test	B2.0
Impact resistance	IR10
Dangerous substances	See safety data sheet