



NORMASPEED 100 PRIMER

TECHNICAL DATA SHEET 5/24

PROPERTIES AND RECOMMENDED USAGE

Paint type

NORMASPEED 100 PRIMER is a one component, very fast drying, modified acrylic based anti corrosion primer. It dries also at temperatures below the freezing point, down to -10 °C, and it can be overcoated with alkyd-, acryl- and polyurethane paints.

Typical and recommended uses

As a primer and intermediate coat on steel-, cast iron and galvanized steel surfaces in environmental classes C2 and C4 - C5. It is recommended for use on structural steel, machinery, pipes and tank exteriors, bridges, ship hulls and –equipment. In field conditions it can be used as a fast drying primer / repair paint in alkyd-, acryl- and polyurethane systems.

TECHNICAL DATA

Volume solids*	43 ± 2 %
Total mass of solids*	880 g/l
VOC value*	480 g/l

* Values are calculated

Packaging

	Volume (l)	Size of container (l)
Normaspeed 100 Pr	10 / 20	10 / 20

Drying time 60 µm

	+23 °C
Surface dry	10 min
To touch	1 h
To recoat	2 h

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

Calculated theoretical coverage and recommended film thickness

Dry	Wet	Coverage
40 µm	95 µm	10.5 m ² /l
60 µm	140 µm	7.1 m ² /l
80 µm	185 µm	5.4 m ² /l

Practical coverage

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

Colour

Oxide red, grey, limited number of other colours.

Thinner

OH 07

Cleaner

OH 07

Finish

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 minimum of Sa 2½ (SFS-ISO 8501-1, SFS-EN ISO 8504-2). Cold rolled surfaces should be cleaned to a grade St2.

Shop primed surfaces

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

Galvanized surfaces

On hot dip galvanized surfaces remove zinc salts and other contaminants by sand brushing. Grease and oils should be removed by alkali-, emulsion or solvent cleansing. Washing with an ammonia solution (5 %) followed by fresh water hosing.

Primer

NORMASPEED 100 PRIMER

Top coat

NORRAPID 10, NORRAPID 12, PIONER TOPCOAT, NORMAPREN 40, NORMADUR 65 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 between -10 °C - +50 °C and the relative humidity below 85 %. The surface temperature should be min 3 °C above the dew point of the air.

Method of application

Dipping, airless spray or brush. The paint must be thoroughly mixed before application. If needed 5 - 10 % thinner OH 07 can be added. High pressure airless spray with a nozzle tip of 0.013" - 0.018" orifice. Spray angle depending on 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. In case of touch up painting with solvent borne paints one should pay attention, that Normaspeed 100 Primer is not tolerant to scrubbing with the brush. When overcoating with brush, it is recommended to use light strokes in one direction only.

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 product will keep up to 3 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.