NORECOAT FD

TECHNICAL DATA SHEET 11/19

PROPERTIES AND RECOMMENDED USAGE

Paint type
A two-component fast drying high solids epoxy paint with a special hardener. Cures in low temperatures.

Typical and recommended uses
NORECOAT FD is used over blast cleaned steel surfaces as a primer, midcoat or single coat in epoxy paint systems in environmental classes C2-C5. Specially recommended for vehicle chassis of transport vehicles and automotive industry. Also suitable for steel frameworks of industry and office buildings, pipe bridges, conveyors and structural constructions of process industry. Can also be overcoated with polyurethane coatings.

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

Weather resistance
Epoxy paints have natural tendency to chalk and discolor on exterior exposure.

Colour
Black, grey, red, beige, off white

Finish
Matt

TECHNICAL DATA

Volume solids*	68 %
Total mass of solids*	1160 g/l
VOC value*	290 g/l

* Values are calculated

Mixing ratio

Resin	4 parts by volume
Cure	1 part by volume

Pot life (+23 °C)
approx. 2 h after mixing

Packaging

	Volume (l)	**Size of container (l)**
Comp A	16	20
Comp B	4	4

Drying time 80 µm

	-5 °C	**0 °C**	**+5 °C**	**+10 °C**	**+23 °C**
To touch	20 h	14 h	8 h	5 h	2.5 h
To handle	48 h	30 h	16 h	10 h	5 h
To recoat					
- same type of paint	24 h	18 h	10 h	7 h	1.5 h
- polyurethanes	-	20 h	12 h	9 h	2.5 h
- Normadur Aqua 90 TC	-	-	-	-	3 h
Fully cured	-	21 d	14 d	10 d	7 d

The maximum overcoating time is 3 months without roughening provided the surface is free from dirt and grease. If the coating has been exposed to direct sunlight for some time, special attention must be paid for the removal of chalking with the suitable method before the painting work.

Calculated theoretical coverage and recommended film thickness

Dry	**Wet**	**Coverage**
80 µm	120 µm	8.3 m²/l
120 µm	175 µm	5.7 m²/l
150 µm	220 µm	4.5 m²/l

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

Thinner
OH 17, OH 31 (slow)

Cleaner
OH 17

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 clensing. 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 minimum of Sa 2½ (SFS-ISO 8501-1, SFS-EN ISO 8504-2).

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).

Primer
NORECOAT FD, NORECOAT FD PRIMER, NORMAZINC SE

Top coat
EPOCOAT 210, EPOTEX HB, NOREPOX HS, NORMADUR 50 HS, NORMADUR 65 HS, NORMADUR AQUA 90 TC

Environmental conditions during application
The surface to be coated must be dry. During application and drying, the tem-perature of the coating should be at least +10 °C and the temperature of the air and surface above -5 °C, and the relative air humidity below 80 %. The temperature of the surface to be coated should be at least 3 °C above the dew point of the air.

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 4:1 (resin:cure) by volume. If needed thin 0-10 % (thinner OH 17). High pressure airless spray with a nozzle tip of 0,013”-0,018 orifice. Spray angle depending on the object to be painted. Pressure ratio of the spray pump must be minimum 45:1. 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 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.