NORECRYL 50

TECHNICAL DATA SHEET 5/19

PROPERTIES AND RECOMMENDED USAGE

Paint type
Two component, isocyanate free acrylic coating with rust-preventing pigments. Suitable as single coat/direct to metal (DTM) paint or topcoat in paint systems.

Typical and recommended uses
Recommended to use in atmospheric corrosivity classes C2-C5 as a single coat (DTM) system on easily painted steel products such as doors, gas bottles, earth movers, agriculture machines, etc. It can also be used as a topcoat in classes C3-C5 on various primers. This product has good impact resistance.

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

Weather resistance
Medium weather proof.

TECHNICAL DATA

Volume solids*	65 %
Total mass of solids*	1030 g/l
VOC value*	300 g/l

* Values are calculated

Mixing ratio

Resin	6 parts by volume
Cure	1 parts by volume

Pot life (+23 °C)
approx. 3.5 h after mixing

Packaging

	Volume (l)	**Size of container (l)**
Comp. A	8.4	10
Comp. B	1.4	2

Drying time 120 µm

	+23 °C
Surface dry	40 min
To touch	2.5 h
To handle	6 h
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	125 µm	8.0 m²/l
120 µm	185 µm	5.4 m²/l
140 µm	215 µm	4.6 m²/l

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

Colour
A limited range from NCS and RAL colours. 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 17

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 maximum over coating 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 Sa 2½ (SFS-ISO 8501-1, SFS-EN ISO 12944-4).

Primer
EPOCOAT 21 PRIMER, EPOCOAT 21 HB, NORECOAT FD PRIMER, NORMASTIC 405, NORMAZINC SE, NORECOAT HS

Top coat
NORECRYL 50

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 +10 °C and the relative humidity below 70 %. The best result will be obtained when the relative humidity is below 50 % and surface is above +15 °C. The surface temperature should be min. 3 °C above the dew point of the air.

Mixing the components
The mixing ratio is 6:1 (resin : cure) by volume. The thinner OH 17 can be added 10-15 %. The resin part and the cure are stirred mechanically before application. Add a cure to a resin in a correct mixing ratio and stir thoroughly down to the bottom. The thinner will be added to the ready mixture.

Method of application
Use airless spray. In order to ensure the best possible performance of the product, it is recommended that the paint is at room temperature (> 20 °C) before the application. With airless spray use 100 Mesh (yellow) spray gun filter and a nozzle tip of 0,011”-0,015” orifice. The spray angle depends on the object to be painted.

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 1 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.