

NORMASPEED AQUA

TECHNICAL DATA SHEET 8/19

PROPERTIES AND RECOMMENDED USAGE

Paint type

Fast drying, acrylic based water-borne primer.

Typical and recommended uses

Recommended as a primer on blast cleaned steel surfaces. For environmental classes C1-C3 NORMASPEED AQUA can be overcoated with water borne acrylic and alkyd coatings. Can also be overcoated with solvent borne acrylic, alkyd, epoxy, polyamide and polyurethane coatings.

TECHNICAL DATA

Volume solids*	40 %
Total mass of solids*	640 g/l
VOC value*	45 g/l

* Values are calculated

Packaging

	Volume (l)	Size of container (l)
Normaspeed Aqua	20	20

Drying time 60 µm / RH 50 %

	+23 °C
To touch	1 h
To handle	1,5 h
To recoat	
- with water borne 1-comp. coatings (min)	40 min
- with solvent based (min)	24 h

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

Calculated theoretical coverage and recommended film thickness

Dry	Wet	Coverage
40 µm	100 µm	10 m ² /l
80 µm	190 µm	5 m ² /l

Practical coverage

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

Colour

Grey

Thinner

OH 00

Cleaner

Water

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

Cold rolled steelsurfaces

Remove any grease from the surface to be painted. Roughening the surface with sandpaper or phosphating is recommended.

Primer

NORMASPEED AQUA

Top coat

AKVANOR 80 TOPCOAT, NORRAPID 10, PIONER TOPCOAT, EPOCOAT 21 PRIMER, EPOCOAT 210, NORMADUR 65 HS

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 60 %. 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.

Method of application

Use airless spray, mohair roller or brush. The paint must be thoroughly mixed before application. Can be thinned with OH 00 if necessary (0-5 %). 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.

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.

Airless spray

With airless spray, spray gun filter and a nozzle tip of 0,011"-0,015" orifice. The spray angle depends on the object to be painted. To avoid solvent contamination of the water-borne paint the spraying equipment has to be conditioned before use. All equipment containing solvents in the pump, hoses and gun have to be thoroughly cleaned. If the application equipment is made in stainless steel, designed for and only used for application of water-borne coatings this preparation and cleaning procedure is not needed. Ensure the good ventilation during the application and drying time. (Note that evaporated water is lighter than air.)

Before spraying

Circulate thinner OH 17 through the equipment and hoses, then thinner OH 04 before fresh clean water.

After spraying

Clean the equipment and hoses with water and detergent. Then circulate thinner OH 04 and finally thinner OH 17.

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 1 year 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.