

# NORECOAT HS PRIMER

## TECHNICAL DATA SHEET 3/22

### PROPERTIES AND RECOMMENDED USAGE

#### Paint type

A two-component, fast drying high solids epoxy primer pigmented with micaceous iron oxide. The paint cures in low temperatures.

#### Typical and recommended uses

NORECOAT HS PRIMER is specially recommended for blast cleaned steel surfaces as a primer or a midcoat in epoxy paint systems in environmental classes C2 - C5. It is also suitable for frameworks of industry buildings, pipe bridges, conveyors and structural constructions of process industry. Suitable for the projects, where there is a requirement for use of Mastic type coatings. NORECOAT HS PRIMER can also be used for immersion service in fresh water and sea water (see table below).

#### Approved systems

Immersion class	System
Im1 high	2 x 200 µm DFT
Im1 very high	3 x 200 µm DFT
Im2 high	2 x 250 µm DFT
Im2 very high	3 x 200 µm DFT

#### Colour

Grey

#### Finish

Semimatt

### TECHNICAL DATA

Volume solids*	78 ± 2 %
Total mass of solids*	1390 g/l
VOC value*	190 g/l

\* Values are calculated

#### Mixing ratio

Resin	5 parts by volume
Cure	1 part by volume

#### Pot life (+23 °C)

approx. 1 h after mixing

#### Packaging

	Volume (l)	Size of container (l)
Comp A	15	20
Comp B	3	5

#### Drying time 80 µm

	+5 °C	+10 °C	+23 °C
Surface dry	3 h	2.5 h	1.5 h
To touch	8 h	6 h	3 h
To recoat			
- same type of paint	7 h	5 h	2 h
- polyurethanes	14 h	10 h	3 h
- Normadur Aqua DTM	-	-	4 h
Fully cured	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	105 µm	9.5 m <sup>2</sup> /l
120 µm	155 µm	6.4 m <sup>2</sup> /l
150 µm	195 µm	5.1 m <sup>2</sup> /l
200 µm	255 µm	3.9 m <sup>2</sup> /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

#### 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 cleansing. Old, painted surfaces, in which the maximum overcoating interval has expired, the 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

**Exposed to weather:** Blast cleaning to Sa 2 or wire brushing to min. St 2.

### Primer

NORECOAT HS PRIMER, NORMAZINC SE

### Top coat

EPOCOAT 210, EPOTEX HB, NOREPOX HS, HARDTOP XP, HARDTOP XPF, NORMADUR 50 HS, NORMADUR 65 HS, NORMAFINE 50 TC, NORMAFINE HS, NOREGUARD HS

### Environmental conditions during application

The surface to be coated must be dry. During the application, the temperature of the coating should be at least +10 °C. During the application and drying of the paint, the temperature of the surface and the air should be above +5 °C and 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.

### 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.

### 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 5 : 1 (resin : cure) by volume. If needed thin 0 - 10 % (thinner OH 17). High pressure airless spray with a nozzle tip of 0.015" - 0.019" orifice. Spray angle depending on the object to be painted. Pressure ratio of the spray pump must be minimum 45 : 1. Use of white (50 - 60 mesh) spray gun filters is recommended. 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 1 year 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.