



NOREPOX HS

TECHNICAL DATA SHEET 11/21

PROPERTIES AND RECOMMENDED USAGE

Paint type

NOREPOX HS is a two-component resin modified epoxy topcoat with a special hardener. Can be piled after a short drying time. The paint cures at low temperatures.

Typical and recommended uses

NOREPOX HS is used over blast cleaned steel surfaces as a single-coat (DTM) system in environmental classes C2 - C3 and as a topcoat in epoxy paint systems in environmental classes C2 - C5. Norepox HS is specially recommended for frameworks of industry buildings, pipe bridges, conveyors and structural constructions of process industry.

Chemical resistance

Used in recommended paint systems and correctly applied withstands occasional splashes and spillage of water, oil and weak process chemicals. If you need more specific information regarding to chemical resistance of Norepox HS, please contact to Nor-Maali Oy's technical service.

Weather resistance

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

TECHNICAL DATA

Volume solids*	68 ± 2 %
Total mass of solids*	1100 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. 1 h after mixing

Packaging

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

Drying time 80 µm

	+5 °C	+10 °C	+23 °C
To touch	8 h	5 h	2.5 h
To handle	16 h	7 h	5 h
To recoat with same type of paints	10 h	7 h	4 h
Fully cured	14 d	10 d	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	120 µm	8.5 m ² /l
120 µm	180 µm	5.6 m ² /l

Practical coverage

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

Colour

Industrial colours with limitations. 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, OH 31 (slow)

Cleaner

OH 17

Finish

Semi gloss

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).

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).

Aluminium surfaces

Remove grease and other contaminants. Sand sweeping before application improves adhesion.

Galvanized surfaces

Remove grease, zinc salts and other contaminants. Sand sweeping before application improves adhesion.

Primer

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

Top coat

NOREPOX HS, EPOCOAT 210, EPOTEX HB,
NORMADUR 65 HS, NORMADUR 50 HS,
NORMADUR 90 HS, NORMADUR HB

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 to be coated must be dry. During application and drying, the temperature of the coating should be at least +5 °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. Exhaust gases during drying process may cause yellowing of the paint film.

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. 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.