

# NORMADUR 65 ALUMINIUM

## TECHNICAL DATA SHEET 1/20

### PROPERTIES AND RECOMMENDED USAGE

#### Paint type

Semi gloss, two-components polyurethane paint with an aliphatic isocyanate curing agent.

#### Typical and recommended uses

Can be used in environmental classes C2-C4 as a topcoat in epoxy- and polyurethane paint systems when good gloss retention is required. Typical uses are steel structures, car tires, fire doors, containers and vehicles indoors and outdoors.

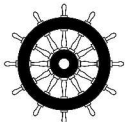
#### Chemical resistance

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

#### Weather resistance

Withstands sunlight and UV radiation.

#### Quality system approval according to Marine Equipment Directive 2014/90/EU



0809

### TECHNICAL DATA

|                              |          |
|------------------------------|----------|
| <b>Volume solids*</b>        | 45 ± 2 % |
| <b>Total mass of solids*</b> | 530 g/l  |
| <b>VOC value*</b>            | 500 g/l  |

\* Values are calculated

#### Mixing ratio

|              |                   |
|--------------|-------------------|
| <b>Resin</b> | 4 parts by volume |
| <b>Cure</b>  | 1 part by volume  |

#### Pot life (+23 °C)

approx. 1 h after mixing

#### Packaging

|        | Volume (l) | Size of container (l) |
|--------|------------|-----------------------|
| Comp A | 8          | 10                    |
| Comp B | 2          | 2.5                   |

#### Drying time 50 µm

|             | +23 °C |
|-------------|--------|
| Surface dry | 30 min |
| To touch    | 3 h    |
| To recoat   | 3 h    |
| To varnish  | 15 min |

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

#### Calculated theoretical coverage and recommended film thickness

| Dry   | Wet    | Coverage               |
|-------|--------|------------------------|
| 40 µm | 90 µm  | 11.4 m <sup>2</sup> /l |
| 60 µm | 135 µm | 7.5 m <sup>2</sup> /l  |

#### Practical coverage

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

#### Colour

Aluminium

#### Thinner

OH 10, OH 66 (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.

### Primer

EPOCOAT 21 PRIMER, EPOCOAT 21 HB, BARRIER NM/NORMAZINC SE, NORECOAT FD PRIMER

### Top coat

NORMADUR 65 ALUMIINI, NORMADUR CLEAR

### 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 +5 °C and the relative humidity below 80 %. The surface temperature should be min 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

Airless spray or brush. Colour shade on brushed surface differs from sprayed surface. Also on touch-up painting the colour shade differs regardless of the method of application. The risk of clouding increases substantially if large surfaces is applicated. Stir the 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 10 or OH 66). Use a high pressure airless spray with a nozzle tip of 0,013" - 0,015" orifice. The spray angle depends on the object to be painted. It is recommended to spray on the same thinning ratio and nozzle tip and also in the same conditions if wanted the same colour shade. In order to ensure the best possible performance of the product, 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 1,5 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.