

NORMAPRIME

TECHNICAL DATA SHEET 6/21

PROPERTIES AND RECOMMENDED USAGE

Paint type

NORMAPRIME is an alkyd based anticorrosive primer.

The product is a part of a complete system which meets the requirements of IMO FTPC being a material with low flame-spread characteristics and not producing excessive quantities of smoke and toxic products at elevated temperatures (Certificate NO VTT-C-11380-15-15).

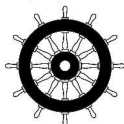
Typical and recommended uses

As a primer in alkyd system for steel structures. This product is part of a complete system which is certified not to spread surface flames. Dries fairly quickly and is resistant against dry heat up to 120 °C.

Chemical resistance

Resistant to occasional water and aliphatic solvent splashes. It is not resistant to acids and alkalis.

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



0809

TECHNICAL DATA

| | |
|-----------------------|----------|
| Volume solids* | 50 ± 2 % |
| Total mass of solids* | 990 g/l |
| VOC value* | 400 g/l |

* Values are calculated

Packaging

| | Volume (l) | Size of container (l) |
|------------|------------|-----------------------|
| Normaprime | 20 | 20 |

Drying time 40 µm

| | +23 °C |
|-------------|--------|
| Surface dry | 1 h |
| To touch | 3 h |
| To recoat | 8 h |

Drying times are typical on recommended film thicknesses at given temperatures. The paint can be overcoated with chemically equivalent alkyd paints containing xylene or stronger solvents within 24 hours or 5 days from the previous coat. If the paint film needs to be abraded before complete oxidation or recoated; there should be at least 5 days between abrading and coating.

Note! The film thickness and prevailing conditions affect significantly the complete oxidation and it can take several days, even weeks to reach the final state.

Calculated theoretical coverage and recommended film thickness

| Dry | Wet | Coverage |
|-------|--------|------------------------|
| 40 µm | 80 µm | 12.5 m ² /l |
| 50 µm | 100 µm | 10.0 m ² /l |
| 60 µm | 120 µm | 8.3 m ² /l |
| 80 µm | 160 µm | 6.2 m ² /l |

Practical coverage

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

Colour

White, grey

Thinner

OH 02

Cleaner

OH 17

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 2 (SFS ISO 8501-1, SFS-EN ISO 8504-2).

Shop primed surfaces

Damaged or corroded surfaces should be blast cleaned to Sa 2. Undamaged areas should be thoroughly washed (SFS ISO 8501-2, SFS-EN ISO 12944-4).

Primer

NORMAPRIME

Top coat

NORMACRYL 60, PILOT II

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 should be dry and clean. During application and drying time the temperature of the air and surface should be above +5 °C and the relative humidity below 85 %. The surface temperature should be min 3 °C above the dew point of the air.

Method of application

Use airless spray, conventional spray or brush. The paint must be thoroughly mixed before application. If needed, up to 10 % thinner OH 02 can be added. High pressure airless spray with a nozzle tip of 0,015" - 0,021" orifice. Spray angle depending on the object to be painted. 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 product will keep up 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.