



NORMAZINC PLUS

TECHNICAL DATA SHEET 11/19

PROPERTIES AND RECOMMENDED USAGE

Paint type

NORMAZINC PLUS is a two-component zinc epoxy primer. Complies with the compositional requirements for SSPC Paint 20 level 1 and ISO 12944.

Typical and recommended uses

NORMAZINC PLUS is recommended to use as a primer in epoxy systems in environment classes C5 High and C5 Very high on blast cleaned steel surfaces. Also suitable for SILKO and SSG approved systems. Provides cathodic protection and prevents corrosion under the paint film.

Chemical resistance

Used in recommended paint systems and correctly applied withstands occasional splashes and spillage of water and a wide range of weak process chemicals.

Colour

Grey

Finish

Matt

TECHNICAL DATA

| | |
|------------------------------|----------|
| Volume solids* | 54 ± 2 % |
| Total mass of solids* | 2250 g/l |
| VOC value* | 400 g/l |

* Values are calculated

Mixing ratio

| | |
|--------------|-------------------|
| Resin | 9 parts by volume |
| Cure | 1 part by volume |

Pot life (+23 °C)

approx. 7.5 h after mixing

Packaging

| | Volume (l) | Size of container (l) |
|--------|-------------------|------------------------------|
| Comp A | 9 | 10 |
| Comp B | 1 | 1 |

Drying time 50 µm

| | +5 °C | +10 °C | +15 °C | +23 °C |
|---------------------|--------------|---------------|---------------|---------------|
| Surface dry | 30 min | 20 min | 10 min | 5 min |
| To recoat | | | | |
| - epoxy paints | 8 h | 3 h | 1.5 h | 30 min |
| - other paint types | 16 h | 6 h | 4 h | 2.5 h |

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

Calculated theoretical coverage and recommended film thickness

| Dry | Wet | Coverage |
|------------|------------|-----------------|
| 40 µm | 75 µm | 13.3 m²/l |
| 60 µm | 115 µm | 8.8 m²/l |
| 80 µm* | 150 µm | 6.7 m²/l |

In complicated structures, painting is recommended to be done with two coats. Recommended maximum film thickness is 80 µm.

Practical coverage

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

Thinner

OH 17, OH 31 (slow)

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 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 min Sa 2½ (SFS-ISO 8501-1, SFS-EN ISO 8504-2) or for maintenance UHPWJ to WJ2 (NACE No.5/SSPCSP).

Touch up

For touch-up purposes surface must be cleaned to St 3 with grinder.

Primer

NORMAZINC PLUS

Top coat

EPOCOAT 210, EPOCOAT 21 HB, EPOCOAT 21 PRIMER, EPOTEX HB, NORECOAT HS PRIMER, NOREGUARD HS, NOREPOX HS, NORMADUR 50 HS, NORMADUR 65 HS, NORMADUR 90 HS, NORMAFINE 20, NORMAFINE 50 TC, NORMAFINE 80, NORMAFINE HS, NORMASTIC 405

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 paint, air and surface should be above +5 °C and the relative air humidity below 80 %. The surface temperature should be min 3 °C above the dew point of the air.

Method of application

Use high pressure airless spray or brush. Stir resin and cure separately (slow stirring) and then mix both components thoroughly with propeller stirrer. The mixing ratio is 9 : 1 (resin : cure) by volume. 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 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 3 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.