



NOREFAST HS

TECHNICAL DATA SHEET 1/23

PROPERTIES AND RECOMMENDED USAGE

Paint type

NoreFast HS is a two component, gloss and high solids isocyanate-free polyurethane paint.

Typical and recommended uses

NoreFast HS can be used in environmental classes C2 - C5 as a gloss retaining topcoat (TC) on selected epoxy primers. NoreFast HS provides unique combination of extremely fast dry to handle time and user-friendly pot-life of several hours. The paint is recommended for easily painted steel products such as machinery, industrial equipment, agricultural machines and heavy transportation equipment, where high gloss and excellent surface properties are required. With selected epoxy primers fast overcoating interval (2 - 4 hours) enables fast throughput for the whole painting process.

Weather resistance

Withstands sunlight and UV radiation.

Colour

NCS-, RAL-, KY-, SSG-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.

Finish

Gloss

Thinner

OH 26

Cleaner

OH 17

TECHNICAL DATA

Volume solids*	77 ± 2 %
Total mass of solids*	1180 g/l
VOC value*	195 g/l

* Values are calculated

Mixing ratio

Resin	10 parts by volume
Cure	1 part by volume

Pot life (+23 °C)

approx. 3 h after mixing

Packaging

	Volume (l)	Size of container (l)
Comp A	9	10
Comp B	0.9	1

Drying time 60 µm

	+15 °C	+23 °C
To touch	1 h	30 min
To handle	1.5 h	1 h
To recoat itself		
- minimum	2 h	1.5 h
- maximum	1 month	1 month
Fully cured	4 d	3 d

Drying times are typical on recommended film thicknesses at given temperatures. If the painting conditions or film thickness differ much, contact Nor-Maali Oy's technical service.

Overcoating at +23 °C

Recommended primers	Min	Max
NorECOat FD Primer	3 h	1 week
NorECOat HS Primer	4 h	1 week
Normazinc Plus	30 min	1 week

Calculated theoretical coverage and recommended film thickness

Dry	Wet	Coverage
60 µm	80 µm	12.5 m ² /l
80 µm	105 µm	9.5 m ² /l

As many of the paint's properties will change if too thick coats are applied, it is not recommended that the product is applied to a film thickness that is more than double of the thickest recommended film.

Practical coverage

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

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

NORECOAT FD PRIMER, NORECOAT HS PRIMER, NORMAZINC PLUS

Top coat

NOREFAST HS

Environmental conditions during application

The surface should be dry. During application and drying time the temperature of the paint, air and surface should be above +15 °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

Use an airless spray, electrostatic spray or brush. Stir the resin and cure separately and then mix both components thoroughly. The mixing ratio is 10 : 1 (resin : cure) by volume. If needed 0 - 10 % thinner (**OH 26**) may be added. Use a high-pressure airless spray with a nozzle tip of 0.008" – 0.011" orifice. Don't use an adjustable spraying nozzle. The spray angle depends 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.

With *NoreFast* HS it is recommended to plan the painting work and order carefully, when painting complex structures. Especially, in the prolonged application, overlapping of the ready full coat areas should be avoided.

Especially when mixing small amounts, we recommend measuring the components by weight or by using a measuring stick or measuring cup with the given mixing ratio.

Storage and shelf life

The product must be stored in original sealed containers at temperatures from +15 °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 1 year 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.