

NORECRYL AQUA DTM

TECHNICAL DATA SHEET 10/23

PROPERTIES AND RECOMMENDED USAGE

Paint type

Two component, water-based, isocyanate free acrylic coating with rust-preventing pigments. Suitable as single coat/direct to metal (DTM) paint.

Typical and recommended uses

Recommended to use in atmospheric corrosivity classes C2 - C3 as a single coat (DTM) system on easily painted steel products.

Chemical resistance

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

Weather resistance

Medium weather proof.

Colour

A limited range from NCS and RAL colours. 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

Semi-gloss

Thinner

OH 00

Cleaner

OH 00

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.

TECHNICAL DATA

Volume solids*	50 ± 2 %
Total mass of solids*	733 g/l
VOC value*	57 g/l

* Values are calculated

Mixing ratio

Resin	4 parts by volume
Cure	1 parts by volume

Pot life (+23 °C)

approx. 8 h after mixing

Packaging

	Volume (l)	Size of container (l)
Comp. A	16	20
Comp. B	4	5

Drying time 100 µm

	+15 °C	+23 °C
Surface dry	5 min	5 min
To touch	30 min	30 min
To handle	4 h	4 h
Fully cured	7 d	7 d

Drying times are typical on recommended film thicknesses at given temperatures. **Ventilation needs to be efficient enough. Moisture must be removed from the coating. Relative humidity must be below 50 %.**

Calculated theoretical coverage and recommended film thickness

Dry	Wet	Coverage
80 µm	165 µm	6.0 m ² /l
120 µm	250 µm	4.0 m ² /l
140 µm	290 µm	3.4 m ² /l

Practical coverage

Depends on 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 over coating 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 2½ (SFS-ISO 8501-1, SFS-EN ISO 12944-4).

Top coat

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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 15 °C and the relative humidity below 50 %. The surface temperature should be min. 3 °C above the dew point of the air.

Mixing the components

The mixing ratio is 4 : 1 (resin : cure) by volume. The thinner OH 00 can be added 0 - 5 %. The resin part and the cure are stirred mechanically before application. Add a cure to a resin in a correct mixing ratio and stir thoroughly down to the bottom. The thinner will be added to the ready mixture.

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 airless spray. **In order to ensure the best possible performance of the product, it is recommended that the paint is at room temperature (> 20 °C) before the application.** With airless spray use 100 Mesh (yellow) spray gun filter and a nozzle tip of 0.011" - 0.015" orifice. The spray angle depends on the object to be painted.

To avoid solvent contamination of the water-borne paint the spraying equipment has to be conditioned before use. All equipment containing solvents in the pump, hoses and gun have to be thoroughly cleaned. If the application equipment is made of stainless steel, designed for and only used for application of water-borne coatings, there is no need for this cleaning procedure. Ensure the good ventilation during the application and drying time. (Note that evaporated water is lighter than air.)

If the spraying equipment has been used for painting solvent-borne paints, cleaning before spraying:

Circulate thinner OH 17 through the equipment and hoses, then thinner OH 04/OH 13 before fresh clean water.

Cleaning after spraying:

Clean the equipment and hoses with water. Then circulate thinner OH 04/OH 13 and finally thinner OH 17.

Cleaning of the spraying equipment when it is only used for painting water-borne paints:

1-component spraying equipment: Clean the equipment and hoses with water, if needed OH 04/OH 13 and OH 17. After cleaning with OH 17, rinse the spraying equipment with OH 04/OH 13 and finally with fresh water.

2-component spraying equipment: Ask instructions from Nor-Maali Oy's sales department.

Storage and shelf life

The product must be stored in original sealed containers at temperatures from 5 °C to 30 °C. **The product should not freeze.** The storage conditions are to keep the containers in a dry, well ventilated space away from the 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.