

NORMATHANE 50 FD

TECHNICAL DATA SHEET 11/23

PROPERTIES AND RECOMMENDED USAGE

Paint type

Normathane 50 FD is a two component chemically curing aliphatic acrylic polyurethane coating. Product is very fast drying and it provides a semi gloss finish with excellent hardness. It is a high solids product. Product contains no solvents on the Hazardous Air Pollutants (HAPs) list. Minor amounts of such solvents may come in through tinting of some colors.

Typical and recommended uses

To be used as topcoat in atmospheric environments from C2 to C5 on various primers. The paint dries quickly and provides excellent surface hardness early in the curing process. This enables fast throughput in the production and stacking of the painted 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

Withstands sunlight and UV radiation.

Colour

RAL, NCS, 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

Semi gloss

TECHNICAL DATA

| | |
|------------------------------|----------|
| Volume solids* | 61 ± 2 % |
| Total mass of solids* | 960 g/l |
| VOC value* | 370 g/l |

* Values are calculated

Mixing ratio

| | |
|--------------|-------------------|
| Resin | 5 parts by volume |
| Cure | 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 | 1.6 | 2 |

Drying time 80 µm

| | +10 °C | +15 °C | +23 °C |
|-------------|------------|------------|--------|
| Surface dry | 50 min | 30 min | 15 min |
| To touch | 1 h 45 min | 1 h 15 min | 45 min |
| To recoat | 2 h | 1.5 h | 1 h |
| To handle | 3 h | 2 h | 1.5 h |
| Fully cured | 10 d | 7 d | 5 d |

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

Calculated theoretical coverage and recommended film thickness

| Dry | Wet | Coverage |
|-------|--------|------------------------|
| 50 µm | 80 µm | 12.2 m ² /l |
| 80 µm | 130 µm | 7.6 m ² /l |

Practical coverage

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

Thinner

OH 26, OH 10

OH 10 may be used, where aromatic solvents are accepted.

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.

Primer

EPOCOAT 21 PRIMER, EPOCOAT 21 HB, NORECOAT HS PRIMER, NORECOAT FD PRIMER, NORMASTIC 405, EPOCOAT AQUA PRIMER

Top coat

NORMATHANE 50 FD

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 +10 °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 or brush. In order to ensure uniform and smooth appearance of the coating, the airless spray equipment should be used for the application. Stir the resin and cure separately and then mix both components thoroughly. The mixing ratio is 5 : 1 (resin : cure) by volume. If needed 0 - 10 % thinner (OH 26 or OH 10) may be added. Use a high pressure airless spray with a nozzle tip of 0.011" - 0.015" orifice. 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.**

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 3 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.