



NORMAPREN 40

TECHNICAL DATA SHEET 1/19

PROPERTIES AND RECOMMENDED USAGE

Paint type

NORMAPREN 40 is a semi gloss modified acrylic based coating.

Typical and recommended uses

It is used as a top coat in acrylic and alkyd paint systems in environment classes C2-C5 on blast cleaned steel surfaces. NORMAPREN 40 is used as a protective paint without primer as well as a humidity barrier (over 200 µm) on concrete surfaces and as a top coat on plastisol coated surfaces. Can also be used on plywood and chipboard surfaces.

Chemical resistance

Resistant to continuous water splashes and to occasional diluted chemical spillages. It is not resistant to solvents, oils or strong acids or alkalis.

	
Nor-Maali Oy Vanhatie 20 15240 Lahti, Finland 17 DoP Nr. NOR4-0114 0416-CPR-7826	
EN 1504-2:2004 Surface protection products - Coating Physical resistance (5.1) Chemical resistance (6.1)	
Abrasion resistance	Weight loss < 3000 mg
Capillary absorption and permeability to water	w<0.1 kg/m ² ·h ^{0.5}
Resistance to severe chemical attack	See chemical resistance list
Impact resistance	Class II: ≥ 10 Nm
Adhesion strength by pull-off test	≥ 1.0 N/mm ²
Dangerous substances	See safety data sheet

TECHNICAL DATA

Volume solids*	44 %
Total mass of solids*	730 g/l
VOC value*	490 g/l

* Values are calculated

Packaging

	Volume (l)	Size of container (l)
Normapren 40	10 / 20	10 / 20

Drying time 70 µm

	+23 °C
Surface dry	30 min
To touch	2 h
To recoat	5 h

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

Calculated theoretical coverage and recommended film thickness

Dry	Wet	Coverage
50 µm	115 µm	8.8 m ² /l
70 µm	160 µm	6.3 m ² /l
100 µm (betoni)	225 µm	4.4 m ² /l

Practical coverage

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

Colour

RAL-, NCS-, KY- and SSG-colours.

Thinner

OH 07

Cleaner

OH 07

Finish

Semi gloss

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.

Concrete surfaces

Old paint should be blast cleaned. Dust and flaking should be brushed off.

Coil coating surfaces

High water pressure cleaning should be used to remove contamination that prevents adhesion and grease should be washed away with a detergent cleaner.

Primer

NORMASPEED 100 PRIMER, NORMAZINC SE

Top coat

NORMAPREN 40

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 +0°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 or brush. The paint must be thoroughly mixed before application and can if necessary be thinned 0-10 % (thinner OH 07). High pressure airless spray with a nozzle tip of 0,011"-0,015". 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.