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NORDCOAT 2

3X1kg PART NUMBER 8110-0200

HEAVY DUTY CORROSION, ACID AND WEAR RESISTANT COATING

Tested against South African National Standard 1217

DESCRIPTION

NORDBAK® NORDCOAT 2 is an outstanding heavy duty corrosion, acid and wear resistant coating which can be used on steel, as well as a wide variety of other substrates.
NORDBAK® NORDCOAT 2 is a two part 100% solids co-polymer coating giving maximum coating thickness in a one-coat application.

RECOMMENDED APPLICATIONS

Food Processing Plants	Acid Production Plants
Sugar Mills	Water Purification and Storage
Chemical Plants	Sewerage Works
Battery Bays	Fruit Processing
Acid Storage tanks	De-ionised Water Storage Tanks
Mineral Extraction Plants	Laboratories
Steam Cleaning Bays	Cold Storage Rooms
Electro Plating Plants	Fertiliser Factories
Fish Processing Factories	Animal Cages
Abattoirs	High Temperature applications
Dairies and Cheese Factories	Phosphoric Acid Plants
Petrochemical Plants	

GENERAL CHEMICAL RESISTANCE – IMMERSION

De-ionised Water	Lactic Acids
Hydrogen peroxide	Nitric Acid up to 35%
Molasses	Orthophosphoric Acid-dilute concentrations
Sodium Hypochlorite	Sulphuric Acid – 50%
Ethylene Glycol	Citric Acid
Petrol and Petrochemicals	Hydrochloric Acid – 20%
All Hydroxides	

PHYSICAL PROPERTIES

Coating Specification	200 – 250µm, per coat.
Recommended coating thickness	400 – 450 µm (2 coats)
Standard Colour	Black (Blue available on request)
Shelf-life	12 months
Pot life	Generally 30 minutes
Gel Time	Dependant upon ambient substrate temperatures
Final Cure Time	6 hours @ 20°C
Kit size	3 x 1kg
Coverage @ 400 µm	According to profile on steel, ± 3.75 m^2/per kit

ADVANTAGES

The solvent free formulation ensures no shrinkage, resulting in wet film thickness being equal to dry film thickness (up to 250µm per coat).
Application by coarse bristle paintbrush which has been cut to a length of 20mm.
No toxic fumes when used in enclosed areas though adequate ventilation essential.

OPERATIONAL TEMPERATURE RANGE
220^{0}C plus continuous

SANS 1217 Results

	Evaluation	Requirements
Resistance to indentation	83	80 min
Adhesion (MPa)	15.8	15 min
Water absorption (g/m^2)	9.5	10 max
Resistance to water	No defects	No Defects
Cathodic disbondment	5.7mA	30 max
Disbonded area	0mm^2	600 max
Impact Resistance (J)	>10	4 min
Resistance to MEK	Complies	No defects
Di-electric strength (kV/mm)	4.6	10 min
Odour and taste	Complies	Not objectionable
Salt fog test (7 weeks)	No visible defects	None

SURFACE PREPARATION
STEEL
Steel surfaces should be dry grit blasted to SA 2½ with a blast profile of between 50–70µm. Ensure that the surface is free of laitance, oil and grease contamination. Coating must be applied within 4 hours of blasting.
NOTE: All steels should be free of any chemical residues prior to coating and dry grit blasting.
CONCRETE
Do not coat concrete that has not fully cured (28 days) or has been treated with a hardening solution unless previously tested. All surfaces are to be washed and then acid washed with a mild hydrochloric / sulphuric solution (not exceeding 5%) to ensure the removal of all grease and other contaminants leaving the concrete visually clean. The entire surface must then be flushed with water and allowed to dry.
APPLICATION
To ensure adequate curing, minimum substrate temperature should be above 10^{0}C
DO NOT MIX RESIN AND HARDENER UNTIL READY TO COMMENCE.
Ensure no ingress of water during mixing. Mix resin thoroughly using a low speed power drill (400 rpm. max for 2 minutes). Pour all the hardener into the resin and mix thoroughly until a uniform colour is achieved. All of the mixed product should be split into shallow paint roller trays and applied without delay. If a second coat is required, it should be applied whilst the first coat is still tacky to the touch.
TYPICAL PHYSICAL PROPERTIES

Compressive strength	118 MPa
Tensile strength	46 MPa
Flexural strength	81 MPa

APPLICATION TEMPERATURE

Material	10^{0}C - 30^{0}C	Surfaces	10^{0}C - 40^{0}C	Ambient	10^{0}C - 40^{0}C
Humidity	0 - 85%				

STORAGE CONDITIONS
Store indoors on pallets at temperatures between 10ºC and 35ºC

NOTE: APPLY NORDCOAT DIRECTLY TO THE STEELWORK AND ENSURE THAT ALL OTHER COATINGS / PRIMERS HAVE BEEN THOROUGHLY REMOVED. IF A PREVIOUSLY COATED AREA IS TO BE OVERCOATED, PLEASE CONSULT NORDBAK®S TECHNICAL SERVICES DEPARTMENT.

For further product information please refer to our website www.nordbak.co.za
NORDBAK (PTY) LTD
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