NORDCOAT 6 COLOURS

Technical Data Sheet
February 2023

5L PART NUMBER 8110-0650

CORROSION RESISTANT COATING

Tested against South African National Standard 1217

TECHNICAL DATA

Components	Two Parts – Resin & Hardener
Appearance (Resin)	Charcoal Grey Other colours on request
Appearance (Hardener)	Amber
Kit sizes	6 x 1kg 5 Liters

DESCRIPTION:

NORDBAK® NORDCOAT 6 is a two-component co-polymer coating based on a general-purpose epoxy resin and finely structured curing system dressed in vibrant colours.

NORDBAK® NORDCOAT 6 is an outstanding corrosion, acid and water-resistant coating which can be used on steel, as well as a wide variety of other substrates.

NORDBAK® NORDCOAT 6 is a solvent-based co-polymer coating giving maximum coating thickness of 100µm in a one coat application (roller and brush application). Two coats are recommended for most industrial applications.

NORDBAK® NORDCOAT 6 may be applied by brush, roller or spray. For Acid environments refer to **NORDBAK TECHNICAL SERVICES DEPARTMENT.**

RECOMMENDED APPLICATIONS

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

PHYSICAL PROPERTIES

Standard Colours	Charcoal, Grey. Other colours on request
Shelf Life	12 Months
Pot Life	90 Minutes
Curing Time	12 Hours @ 20°C
Theoretical Spreading Rate @ 70µm (Spray Application)	10m² per litre
Coating Specification	±100 µm per coat (roller and brush application). ±70 per coat (Airless Spray = Nozzle 517) ±100 per coat (Airless Spray = Nozzle 519) Recommended thickness 200 - 225µm (minimum DFT)

SANS 1217 Results

	Evaluation	Requirements
Resistance to indentation	91	80 min
Adhesion (MPa)	>20.4	15 min
Water absorption (g/m2)	-3.1	10 max
Resistance to water	No defects	No defects
Cathodic disbondment	5.6mA	30 max
Disbonded area	0mm2	600 max
Impact Resistance (J)	>10	4 min
Resistance to MEK	Complies	No defects
Di-electric strength (kV/mm)	6.9	10 min
Odour and taste	Complies	Not objectionable
Salt fog test (7 weeks)	No visible defects	None

ADVANTAGES

Application by spray, paintbrush, or roller. Care should be taken when used in enclosed areas and adequate ventilation is essential.

OPERATIONAL TEMPERATURE RANGE

110°C continuous for pneumatic flow. Immersion dependent on contents.

SURFACE PREPARATION

STEEL

Steel surfaces should be dry grit blasted to SA 2½ with a blast profile of between 80 – 100µm. (Ultra-high water blasting to SP 10 – WJ 2 will suffice provided a profile between 30 and 50µm exists.)

Ensure that the surface is free of laitance, oil and grease contamination. Coating must be applied within 4 hours of blasting. All steels should be free of any chemical residues prior to coating and dry grit blasting.

NORDBAK® has a wide variety of resin systems now available. **Crusher:** NORDBAK® Fast-set and Deep Pour Grouts, NORDBAK® Trowel mix, NORDBAK® Primary, High Performance and Standard **Backing Compounds:** Wearing compounds include NORDBAK® **High Temperature Wearing Compound**: NORDBAK® High Temperature Pneu Wear, NORDBAK® Regular Wearing Compound, NORDBAK® Nordwear 5, Nordwear 8 and Nordtile wearing compounds and the Nordcoat Acid resistant coating range.

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Note: If the surface cannot be grit blasted, the surface may be prepared using a wire brush. Ensure that all rust residues are removed and further clean surface using epoxy thinners and a cloth.

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°C.
- 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.
- For brush or roller 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.

DO NOT MIX RESIN AND HARDENER UNTIL READY TO COMMENCE.

SPRAY, ROLLER AND BRUSH APPLICATION

Airless Spray Application	
Nozzle 517 =	±70µm film thickness at 25°C approximately
Nozzle 519 =	±100µm film thickness at 25°C approximately.
Roller and Brush Application	±100µm film thickness at 25°C approximately.

APPLICATION TEMPERATURE

Material	10°C - 30°C
Surfaces	10°C - 40°C
Ambient	10°C - 40°C
Humidity	0 - 85%

IF A PREVIOUSLY COATED AREA IS TO BE OVERCOATED, PLEASE CONSULT NORDBAK®S TECHNICAL SERVICES DEPARTMENT.

TECHNICAL TIPS FOR WORKING WITH NORDCOAT 6:

Working time and cure depends on temperature and mass:

- The higher the temperature, the faster the cure.
- The larger the mass of material the faster the cure.

To speed up the curing time at low temperatures:

- The lower the temperature, the longer the cure.
- In cold weather, store kits in a warm area and warm the resin to at least 15°C before mixing.
- Pre-heat repair surface until warm to the touch.

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PROTECTION:

- All work is to be done in a well-ventilated area.
- Overalls and eye protection required.
- Refer to Material Safety Data Sheet.

STORAGE:

Store indoors on pallets at temperatures between 10°C and 35°C. Keep container tightly closed and away from acids and oxidizers. If product is removed from container do not return it to original container as contamination may have occurred.

DISCLAIMER:

The information provided in this data sheet including the recommendations for use and application of this product are based on our knowledge and practical experience and laboratory tests of the product as at the date hereof. This data sheet shall be used as a guide to the user's application.

This product has been designed for specific applications based on normal working and operating conditions, and although it may be used in different applications and working conditions such instances are beyond our control. Therefore Nordbak shall not be liable for the suitability/merchantability of our product in your application unless we have specifically advised so in writing. Accordingly, we advise that you conduct your own investigations to confirm the suitability of our product, as it ultimately remains the user's responsibility to protect property and persons against hazards emanating from the handling and use thereof. Accordingly, any civil liability as a result of damages, injury, or death, in respect of the information in this data sheet, or any other written or oral recommendation(s) regarding the suitability of this product, are hereby excluded. Furthermore Nordbak shall not be liable under any circumstances for any consequential or incidental damages of any kind, including but not limited to loss of profits.

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