

5L PART NUMBER 8110-0620

### CORROSION RESISTANT COATING

#### TECHNICAL DATA

Components	Two Parts – Resin & Hardener
Appearance (Resin)	Grey
Appearance (Hardener)	Amber
Kit sizes	5 Litres

#### DESCRIPTION:

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

**NORDBAK® NORDCOAT 6 ACID** is a solvent-based copolymer coating giving maximum coating thickness of 100-125µm per coat. Two coats are recommended for most industrial applications.

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

#### 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	

#### PHYSICAL PROPERTIES

Shelf Life	12 Months
Pot Life	90 Minutes
Curing Time	12 Hours @ 20°C
Theoretical Spreading Rate @ 70µm	10m <sup>2</sup> per litre
Coating Specification	± 100µm per coat. Recommended thickness 200 - 250µm (minimum DFT)

#### SANS 1217 Results

	Evaluation	Requirements
Resistance to indentation	91	80 min
Adhesion (MPa)	>20.4	15 min
Water absorption (g/m <sup>2</sup> )	-3.1	10 max
Resistance to water	No defects	No defects
Cathodic disbondment	5.6mA	30 max
Disbonded area	0mm <sup>2</sup>	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 surface should be dry grit blasted to SA 2½ with a blast profile of between 30 – 50µm (Ultra high water blasting to SP 10 WJ 2 will suffice provided a profile between 30 – 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.

**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.

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.

### 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 APPLICATION

- Nozzle 517** ± 70µm film thickness at 25°C approximately  
**Nozzle 519** ± 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 NORDBAK 6 ACID:

#### 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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