



NP-9500 METAL PRIMER

NORMAC NP-9500 is a two-component polymer-based primer for bonding Polyurethane (PU) to ferrous and non-ferrous substrates. Requires two application coats after cleaning and mechanically roughening the metal substrate. When bonding PU to PU only one coat is required.



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The directions for the use of our products are based upon tests believed to be reliable but no warranty is given. Since conditions for the use of this product are beyond the sellers control, all risks are assumed by the user. Please contact your local agent or call Normac Adhesive Products Inc. for further assistance.

METAL SUBSTRATE COVERAGE:

Theoretical coverage: 16.39 sqm @ 25 micron/kg (80 sqft/lb @ .001")

Recommended DFT: 50 micron (.002")

Coverage based on DFT: 8.2 sqm @ 50 micron/kg (40 sqft @ .002"/lb)

Solids content: 48%

MIXING INSTRUCTIONS:

Mechanical mix by stirring and shaking

Appearance: Amber clear

Induction time: 5 minutes

Mix Ratio by volume: 3A:1B

Mix Ratio by weight: 100A: 33B

Dilution: Up to 50% MEK (Methyl Ethyl Ketone)

APPLICATION CONDITIONS

Ambient and surface temperature should be similar and between 7°C to 45°C (45°F to 113°F). Warming surfaces and surrounding air is a good option when working in colder temperatures. Relative humidity should be below 85% and dew point is maintained 3°C (5°F) above substrate temperature for the duration of the application. Always protect the area from contaminants and direct sunlight.

APPLICATION INSTRUCTIONS (23°C / 73°F):

Apply two coats 30 minutes apart by brush, roller, or spray. Metal surface preparation includes grit-blasting using standard SSPC-SPI0 near white including a 2-3 mil profile. Other forms of surface preparation are possible and should be tested individually to assure adequate adhesion strength.

Working Time: 4 - 6 hours

Dry Times: 30 min.

DFT: 50 micron (.002")

Recoat Time: Minimum 30 min. maximum 5 days, free from contaminants

Clean up: Non oil based solvent such as Ethyl Acetate

TECHNICAL DATA:

Transportation: DGR

Storage: Under 27°C (80°F) away from heat, sparks, and open flame.

Shelf life: 3 years, unopened

Mixed Viscosity: 62cps

Flammable liquid

Flash Point: -5°C (23°F)

AVAILABLE KIT SIZES:

400 g, 1 kg, 3 kg, 15 kg, 60 kg

SAFETY:

Flammable liquid. See the NORMAC NP-9500 product SDS. Strict adherence to regional safety regulations must be practiced.