
PAINT TYPE	Air drying, thixotropic water borne primer.
USAGE	Used as a protection of steel against corrosion. Can be used as a single-coat - primer and topcoat in one product.
SPECIAL PROPERTIES	Good adhesion provides effective protection against corrosion of steel. Good adhesion to aluminium, zinc, silumin, copper, brass, and some plastic types such as acrylic, PVC, polystyrene, polycarbonate, ABS and SMC. Is thixotropic in formulation, which provides a good "safety margin" if the coating is applied in thick coats. Is produced without use of chromate containing anti-corrosion pigment.

TECHNICAL DATA

Solids	44 %		
Total mass of solids	667 g/l		
Volatile organic compound (VOC)	62 g/l		
Recommended film thickness and theoretical spreading rate	Dry film (µm) 40	Wet film (µm) 85	Theoretical spreading rate (m ² /l) 12
Drying time at +23 °C / 50 % RH	Approx. 30 minutes		
- dust free (ISO 1517)	1 - 2 hours		
- touch dry (ISO 3678)			
Drying time at +80 °C / 50 % RH	Heat dry: Dry through after 30 min.		
	The drying times are based on a film thickness of approx. 40 µm dry film and a relative air humidity of max. 60 % and air circulation.		
- re-coatable	After 3 hours.		
Thinner	See page 2.		
Clean up	Water. A solution of water and TEKNOCLEAN 6480-00 may also be used.		
Finish	Mat and satin.		
Colours	Can be supplied in any colour with reference to RAL, NCS S or other colour systems.		
Storage	See additional information.		
HEALTH AND SAFETY	See Safety Data Sheet.		

DIRECTION FOR USE

Surface preparation

Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods. Subsequently the surfaces are pre-treated.

Cold rolled steel: Clean with suitable pre-treatment chemical agent.

Warm rolled steel: Shot blasting or sandblasting to preparation grade SA 2½ according to ISO standard 8501-1:1988.

Aluminium: Suitable chemical pre-treatment.

Electric zinc-coated steel: Suitable chemical pre-treatment.

Hot-zinc-coated steel: Hot-zinc-coated steel structures that are exposed to atmospheric corrosion can be painted if the surfaces are sweep blast-cleaned (SaS) till matt all over. Suitable cleaning agents are, e.g. aluminium oxide and natural sand. It is not recommended to paint zinc-coated objects that are subjected to immersion strain.

Application conditions

The surface to be painted must be dry. When coating and curing the temperature of the air, paint and surface must be above +15 °C and the relative air humidity below 70 %.

Application

<u>Equipment</u>	<u>Thinner</u>	<u>Suggested viscosity</u> <u>DIN-cup 4 mm 20 °C</u>
Air spraying	Water	50-100 s
Airless		Undiluted or up to approx. 5 % water

ADDITIONAL INFORMATION

Storage: See label.
Store in a tightly closed container.

The product must be stored frost-free.

Re. adhesion to plastic

Adhesion to plastic should be tested before production as different varieties may occur depending on the type of plastic.

The above information is normative and based on laboratory tests and practical experiences. The information is noncommittal, and we cannot accept liability for the results obtained under working conditions beyond our control, and consequently the buyer or the user is not released from the obligation to test the suitability of our products for specific means and application methods under the actual application conditions. Our liability covers only damage caused directly by defects in the products supplied by Teknos. The latest versions of Teknos' Technical Data Sheets and Safety Data Sheets are available from our homepage www.teknos.com.