TECHNICAL DATA SHEET
3 25.09.2016

TEKNOCRYL AQUA 2780

Air-drying topcoat

2780-09

USE	Air-drying, thixotropic water borne topcoat.
ANVENDELSE	Used as a protection of steel and primed surfaces against corrosion.
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 “sagging safety” if the coating is applied in thick coats.

TECHNICAL DATA

Solids by volume	38 ±2 %		
Total mass of solids	482 g/l		
Volatile organic compound (VOC)	See Safety Data Sheet.		
Recommended film thickness and theoretical spreading rate	Dry film (µm) 40	Wet film (µm) 85	Theoretical spreading rate (m²/l) 12
Drying time at +23 °C / 50 % RH **- surface dry (ISO 1517)** **- touch dry (ISO 3678)**	 Approx. 30 min. 1-2 hours		
Drying time at +80 °C / 50 % RH	Heat drying: Completely dry 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.		
- overcoatable	After 3 hours.		
Thinner	See page 2.		
Cleaning	Water. A solution of water and TEKNOSOLV 7030-00 may also be used.		
Gloss	Matt and satin.		
Colour range	Can be supplied in any colour required e.g. with reference to RAL, NCS S or other colour systems.		
Primer	Maximum adhesion and protection against corrosion is obtained by priming with TEKNOCRYL AQUA 2780-01.		
Storage	See page 2.		

HEALTH AND SAFETY See Safety Data Sheet.

PTO

INSTRUCTION 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. Phosphatising.

Hot-zinc-coated steel: Shot or abrasive blasting to preparation grade SA 2½ according to ISO standard 8501-1:1988.

Aluminium: Suitable chemical pre-treatment. Chromating if exterior use is required.

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

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. Zinc phosphatising. Chromating. It is not recommended to paint galvanized 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 %.

Spraying conditions

Equipment	Thinner	Suggested viscosity DIN-cup 4 mm 20 °C
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.