
PAINT TYPE	Air drying, thixotropic and water borne.
USE	Used as protection of steel against corrosion. Can be used as a single-coat - primer and topcoat in one product.
SPECIAL PROPERTIES	Good adhesion to steel, aluminium, zinc, aluminium/silicon alloy, copper, brass and some plastic types such as acrylic, PVC, polystyrene, polycarbonate, ABS and SMC. Provides an efficient protection against corrosion. Is thixotropic in formulation, which provides a good "sagging safety" when applied. Produced without use of chromate containing anti-corrosion pigments.

TECHNICAL DATA

Solids	44 %		
Total mass of solids	655 g/l		
Volatile organic compound (VOC)	73 g/l		
Recommended film thickness and theoretical spreading rate	Dry film (µm) 40	Wet film (µm) 85	Theoretical spreading rate (m ² /l) 8 - 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	Dry through after 30 minutes.		
	The drying times are based on a film thickness of 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	Satin.		
Colours	The colours are produced by use of colour-mixing machine. As the RAL, NCS S and other references are stored in the computer memory; delivery times are kept to a minimum. If the colour has to be matched exactly to a previously supplied batch or a different product, this variant should not be used. As there are 2 paint systems, the conformity with series 2780 cannot be guaranteed.		
Packing	Is delivered in 10 litre containers with a content of 9 litres of paint + colouring paste.		
Delivery	Delivery of any colour should take place within 48 hours.		
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.

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

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

Re.: Coating of plastic

Adhesion to plastic should be tested for each application as different plastic qualities may cause variation.

Storage: See label.

When tinting special colours, however, max. 6 month from tinting date.

Store in a tightly closed container.

The product must be stored frost-free.

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.