TECHNICAL DATA SHEET
2 02.09.2014

TEKNODUR 3510
Two component topcoat
3510-23

TYPE	Two component reaction drying topcoat.
USE	Topcoat for synthetics and MDF.
SPECIAL PROPERTIES	Resistant to weak acids, bases and solvents, in line with stoving topcoats. Re-coating must be carried out within max 36 hours, as otherwise poor adhesion between the layers may be the result. Application of silk screen-printing must be carried out within max 24 hours to obtain sufficient adhesion. For internal use if an abrasion resistant and robust surface is required.

TECHNICAL DATA

Hardener	For this type use TEKNODUR HARDENER 7340.
Mixing ratio by volume	4.4:1
Pot life, +23 °C	Approx. 3 hours.
Solids	45 ± 2 %
Total mass of solids	820 g/l
Volatile organic compound (VOC)	See Safety Data Sheet.

Recommended film thickness and theoretical spreading rate	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m²/l)
	30	60	15

Drying time at +23 °C / 50 % RH	
- dust free (ISO 1517)	Approx. 15 minutes
- touch dry (ISO 3678)	Approx. 1 hour
Drying time at +80 °C / 50 % RH	Dry through after 20 minutes.

- overcoatable

	by itself	
	+ °C	**+23 °C**
min.	-	1hour
max.	-	36 hours

Thinner	See page 2.
Clean up	TEKNOSOLV 6220-00.
Finish	Can be supplied in a gloss level of approx. 30 measured at an angle of 60°.
Colours	Can be supplied in any colour required with reference to RAL, NCS S or other colour systems. The product is part of TEKNOTINT tinting system.

PTO

Primer

Max. adhesion is achieved by using one of the following primers:

Synthetics
TEKNOSEAL 1120
TEKNODUR FILLER 3310

MDF
TEKNODUR FILLER 3310

Storage

See additional information.

HEALTH AND SAFETY

See Safety Data Sheet.

DIRECTIONS FOR USE

Mixing of the components

To achieve a satisfactory result, it is important that the hardener is mixed correctly; **incomplete stirring or incorrect dosage may result in the product not curing correctly, which will impair the properties of the product.** 15 minutes after the addition of hardener the viscosity increases. Final adjustment of the spraying viscosity has to be made after this time period.

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 +10 °C and the relative air humidity below 80 %.

Application

Equipment	Thinner	Suggested viscosity DIN-cup 4 mm 20 °C
Air-spraying	TEKNOSOLV 6220-00 (standard)	20-25 s
	TEKNOSOLV 7120-00 (fast)	20-25 s

ADDITIONAL INFORMATION

Drying at 80 °C of TEKNODUR 3510 matt versions results in a somewhat higher gloss than drying at 20 °C.

Adhesion and compatibility to plastic types should be tested before application as variation may occur, dependent upon the type of plastic.

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