

<b>PAINT TYPE</b>	2-component reaction drying polyurethane.
<b>USE</b>	Used as a topcoat in polyurethane coating systems on steel and metal.
<b>SPECIAL PROPERTIES</b>	Produces a high gloss, impact-resistant and flexible surface, resistant to weak acids and bases. The product has good weather resistance, which further can be improved by painting with TEKNODUR 3740-29.

**TECHNICAL DATA**

<b>Mixing ratio</b>	Base (comp. A): Hardener (comp. B) TEKNODUR HARDENER 0100-01	See label See label
<b>Pot life, +23 °C</b>	Approx. 6 hours	
<b>Solids</b>	Approx. 50 ± 2 %	
<b>Total mass of solids</b>	760 g/l	
<b>Volatile organic compound (VOC)</b>	450 g/l	
<b>Recommended film thickness and theoretical spreading rate</b>	Dry film (µm) 40	Wet film (µm) 85 Theoretical spreading rate (m <sup>2</sup> /l) 12

**Drying time at +23 °C / 50 % RH (dry film 40 µm)**

- dust free (ISO 1517:1973)      Approx. 1 hour  
 - touch dry (DIN 53150:1995)      Approx. 6 hours

**- overcoatable (dry film 40 µm)**

by itself		
Surface temperature		
	min.	max.
<b>+5 °C</b>	After 20 hours	10 days
<b>+23 °C</b>	After 12 hours	5 days

Increase in film thickness and rise in the relative humidity of the air in the drying space usually slow down the drying process.

<b>Thinner</b>	See page 2								
<b>Clean up</b>	TEKNOSOLV 6220.								
<b>Finish</b>	Can be supplied in gloss and matt to a minimum of 60 measured at an angle of 60 <sup>0</sup> .								
<b>Colours</b>	Can be supplied in any colour required with reference to RAL, NCS S or other colour systems.  For accuracy of yellow, red and orange topcoats pink primer should be used.								
<b>Primer</b>	<table border="0" style="width: 100%;"> <tr> <td style="vertical-align: top;"><u>Metals</u></td> <td style="vertical-align: top;"><u>Synthetics</u></td> </tr> <tr> <td>INERTA PRIMER 3210</td> <td>TEKNODUR FILLER 3310</td> </tr> <tr> <td>TEKNODUR PRIMER 3420</td> <td>TEKNODUR PRIMER 3420</td> </tr> <tr> <td>TEKNODUR PRIMERHB 3450</td> <td></td> </tr> </table>	<u>Metals</u>	<u>Synthetics</u>	INERTA PRIMER 3210	TEKNODUR FILLER 3310	TEKNODUR PRIMER 3420	TEKNODUR PRIMER 3420	TEKNODUR PRIMERHB 3450	
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TEKNODUR PRIMERHB 3450									

**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. The surfaces are prepared according to the different materials as follows:

OLD PAINTED SURFACES SUITABLE FOR OVERCOATING: Any impurities that might be detrimental to the application of paint (e.g. grease and salts) are removed. The surfaces must be dry and clean. Old, painted surfaces that have exceeded the maximum overcoating time are to be roughened as well. Damaged parts are prepared in accordance with the requirements of the substrate and the maintenance coating.

The place and time of the preparation are to be chosen so that the prepared surface will not get dirty or damp before the subsequent treatment.

**Mixing of components:** To achieve a satisfactory result, it is important that the hardener is mixed correctly. 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 %.

<b>Application</b>	<u>Equipment</u>	<u>Thinner</u>	<u>Suggested viscosity DIN-cup 4 mm 20 °C</u>
Air-spraying		6220-00 (standard)	18-25 s
		6290-00 (slow)	18-25 s
		7120-00 (fast)	18-25 s
Airmix		6220-00	20-30 s
Airless		6220-00	25-40 s

**ADDITIONAL INFORMATION** The hardener-can must be opened with caution, as pressure may develop in the can during storage.  
 The storage stability is shown on the label. Store indoors in a cool and dry place and in a tightly closed can.  
 The hardener reacts with air humidity and therefore the opened can is to be kept carefully closed, and it is recommended to be used within 14 days of opening.  
  
 Additional instructive information for surface preparation can be found in standards EN ISO 12944-4 and ISO 8501-2.

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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](http://www.teknos.com).

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