

TYPE	TEKNODUR AQUA 3393 is a water borne two pack polyurethane topcoat where the hardener used is an aliphatic isocyanate resin.
USE	<p>The systems are used as 1-layer and 2-layer system directly on various composite materials and certain plastics.</p> <p>The use of TEKNODUR AQUA 3394 varnish is recommended where the topcoat is required to have excellent gloss and colour retention.</p>

TECHNICAL DATA

Mixing ratio	Base (Comp. A):	9 parts by volume
	Hardener (Comp. B) TEKNODUR AQUA HARDENER 7323	1 part by volume
Pot life, +23 °C	3 hours.	
Solids	38 ± 2 % by volume	
Total mass of solids	Paint: Approx. 600 g/l	
Volatile organic compound (VOC)	Approx. 60 g/l	
Recommended film thickness and theoretical spreading rate	Dry film (µm) 57	Wet film (µm) 150
	Theoretical spreading rate (m ² /l) Approx. 7	

Used as a 2-layer system approx. 100 µm of both TEKNODUR AQUA 3393 and TEKNODUR 3394 must be applied.

Practical spreading rate The values depend on the application technique, surface conditions, overspray, etc.

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

- dust free (ISO 1517:1973) After 30 minutes
 - touch dry (DIN 53150:1995) After 2 hours

- overcoatable, (dry film 40 µm)

Surface temperature	by itself or 3394-XX	
	min.	max.*
+10 °C	after 6 hours	after 14 days
+23 °C	after 1 hour	after 14 days

* Maximum overcoating interval without roughening.

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

Thinner Water.

Clean up Water, TEKNOSOLV 7030.

Finish (60°)
 3393-X2: gloss 15-20 (with TEKNODUR AQUA HARDENER 7323-02)
 3393-X3: gloss 25-30 (with TEKNODUR AQUA HARDENER 7323-03)
 3393-X6: gloss 55-60 (with TEKNODUR AQUA HARDENER 7323-06)

Colours By agreement.

HEALTH AND SAFETY See Safety Data Sheet.

DIRECTION FOR USE**Surface preparation**

Clean the surfaces for any contaminants before painting.
The surfaces are prepared according to the different materials as follows:

PREVIOUSLY PAINTED SURFACES: Any impurities such as 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.

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 the components

Slowly add the hardener in one go during mechanically stirring. The stirring time is at least 5 minutes. Inadequate stirring or wrong mixing ratio results in imperfect curing and impaired film properties. Dosage may also be done through a 2-K mixing system.

Ready paint is to be used within the pot-life. After this the mixture is unfit for use.

Application

For application conventional spraying is recommended (airless, airmix, aricoat) with nozzle size 0.011-0.013". The components are not to be thinned separately.

The hardener of the paint and the ready paint mixture contain isocyanates. In poorly ventilated areas and especially when using spray application we recommend the use of a fresh air mask. In short or temporary work a mask with combined filter A2-P2 can be used. In this case eyes and face are to be protected. See Material Safety Data Sheet.

The hardener-can must be opened with caution, as pressure may develop in the can during storage.

Application conditions and drying

The surface to be painted must be dry. During the application and drying period the temperature of the ambient air, the surface and the paint shall be above +18 °C and the relative air humidity above 50 % and below 70 %.

Surface temperature, film thickness, drying temperature and ventilation affect the drying of the paint.

Low temperatures and insufficient ventilation slow down the drying process.

Cleaning of equipment

Clean painting equipment used for application carefully:

1. Wash with solvent, e.g. TEKNOSOLV 7030 after base (Comp. A) and the mixed product. TEKNOSOLV 6220 may be used after hardener (Comp. B).
2. Wash with washing solvent for water borne paints after base (Comp. A) and the mixed product.
3. Rinse with water after base (Comp. A) and the mixed product.

ADDITIONAL INFORMATION

The storage stability is shown on the label. Store indoors in a cool and dry place in 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.

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.
