

TEKNODUR AQUA BASECOAT

3520-71

PAINT TYPE	TEKNODUR AQUA BASECOAT 3520-71 is a water-based, one-pack basecoat.
USAGE	<p>The BASECOAT is used on a suitable primer in vehicle and transportation equipment painting.</p> <p>Water- or solvent-based polyurethane varnish can be used for top varnish.</p> <p>The viscosity of TEKNODUR AQUA BASECOAT 3520-71 has been adjusted to be suitable for bell application.</p>

TECHNICAL DATA

Solids	Effect colours: 20 \pm 2% by volume Ordinary colours: 24 \pm 2% by volume		
Total mass of solids	Effect colours: abt. 230 g/l, Ordinary colours: abt. 280 g/l		
Volatile organic compound (VOC)	abt. 80 g/l		
Recommended film thickness and theoretical spreading rate	Dry film (μm)	Wet film (μm)	Theoretical spreading rate (m²/l)
	Effect colours: 10	50	20
	15	75	13,3
	Ordinary colours: 15	63	16
As many of the paint's properties will change if too thick coats are applied, it is not recommended that the product is applied to a film thickness that is more than double of the thickest recommended film.			
Practical spreading rate	The values depend on the application technique, surface conditions, overspray, etc.		
Drying time at +23°C / 50% RH (dry film 15 μm)			
- dust free (ISO 9117-3:2010)	after 15 min		
- touch dry (ISO 9117-5:2012)	after 30 min		
Overcoatable, 50% RH (dry film 15 μm)	after 30 min		
Thinner	Water		
Clean up	Water, TEKNOCLEAN 6480 washing agent or TEKNOSOLV 1935.		
Colours	By agreement.		

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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.

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 +15°C and the relative air humidity below 70%. Additionally the temperature of the surface to be painted and the paint must be at least 3°C above the dew point of the ambient air.

Especially when applying with a spray the relative air humidity should be above 30% to avoid the onset of the drying process to be too fast.

Surface temperature, film thickness, drying temperature and ventilation affect the drying of the paint. The paint is dry when all water has evaporated from the paint film. It is essential that all painted surfaces have sufficient ventilation. If the painted surface will be exposed to weathering, moisture or low temperatures (below +10°C) thick paint films are to be avoided and the last coat must be allowed to dry for at least 24 hours (at +23°C) before exposure.

Low temperatures and insufficient ventilation slow down the drying process.

Application

Before use stir the paint thoroughly.

The paint is thinned by water into a spraying viscosity of 21 - 23 s, ISO 6 -cup, 6 mm. In effect colours wet film is sprayed first, thereafter for a short evaporation time (abt. 1 - 3 min.) a thin spray mist layer. The ordinary colours are completed without stopping. The surface can be varnished when the surface is matt throughout. The varnishing is to be done on the same day.

Cleaning of the equipment

When painting equipment used for application of solvent-borne paints is used for water-borne paints the equipment must be cleaned carefully:

1. Wash with solvent.
2. Wash with washing solvent for water-borne paints, e.g. TEKNOSOLV 6060.
3. Rinse with water.

When shifting from water-borne to solvent-borne paints act in reverse order.

When changing colours in painting lines the cleaning can be done with TEKNOCLEAN 6480 washing agent.

ADDITIONAL INFORMATION

The storage stability is shown on the label. Store in a cool place and in tightly closed containers. Do not transport or store the paint in temperatures below 0°C.

The information of this data sheet is normative and based on laboratory tests and practical experience. Teknos guarantees that the product quality conforms to our quality system. Teknos accepts, however, no liability for the actual application work, as this is to a great extent dependent on the conditions during handling and application. Teknos accepts no liability for any damage resulting from misapplication of the product. This product is intended for professional use only. This implies that the user possesses sufficient knowledge for using the product correctly with regard to technical and working safety aspects. The latest versions of Teknos data sheets, material safety data sheets and system sheets are on our home pages www.teknos.com.



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