



TEKNODUR AQUA PRIMER 3760-70 Polyurethane Paint

PAINT TYPE	TEKNODUR AQUA PRIMER 3760-70 is a water-borne, two pack polyurethane paint. The hardener used is an aliphatic isocyanate resin.
USAGE	The paint is used as a primer in a water-borne polyurethane systems exposed to atmospheric corrosion. The paint will adhere well onto most plastic surfaces. The paint will form an even and easy to sand surface. Because of the many different types of plastics it is best to get in touch with the manufacturer to make sure of the adhesion onto the substrate in question. The viscosity has been adjusted to suit for use in 2K-painting lines.

TECHNICAL DATA

Mixing ratio	Base (Comp. A): Hardener (Comp. B): TEKNODUR AQUA HARDENER 7314	6 parts by volume 1 part by volume	
Pot life, +23 °C	1½ h		
Solids	35 ±2% by volume		
Total mass of solids	abt. 610 g/l		
Volatile organic compound (VOC)	abt. 160 g/l		
Recommended film thickness and theoretical spreading rate	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m ² /l)
	20	57	17,5
	30	85	11,7
	40	114	8,8

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 40 µm)

- dust free (ISO 9117-3:2010)	after 2 h
- touch dry (ISO 9117-5:2012)	after 6 h
- drying in elevated temperature, +60 °C	after 1 h

Overcoatable, 50% RH (dry film 40 µm)

surface temperature	by itself, TEKNODUR AQUA BASECOAT 3520 or with TEKNODUR AQUA 3390	
	min.	max.*
+10°C	after 1 d	after 14 d
+23°C	after 6 h	after 14 d

* 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	TEKNOSOLV 1936
Clean up	Water, TEKNOCLEAN 6480 washing liquid or TEKNOSOLV 9529
Finish	Semi-matt
Colours	By agreement.

SAFETY MARKINGS See Safety Data Sheet.

DIRECTION FOR USE**Surface preparation**

Plastic surfaces are washed with emulsifying washing agent and rinsed with clean water.

Make sure before application that the possible release agents have been removed from the plastic surface.

It is best to check with the manufacturer to make sure of the suitability of the surface preparation methods (corona treatment, flaming).

Mixing of the components

The base and hardener are mixed together and stirred mechanically thoroughly before application down to the bottom of the vessel. The hardener is mixed undivided and in one go into the base. The stirring time is at least 5 minutes. Inadequate stirring results in imperfect curing and impaired film properties.

Ready paint is to be used within 1½ h from mixing. After this the mixture is unfit for use.

Application

For the application it is recommended to use conventional spray.

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.

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 +10°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.

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.

As the static electricity on synthetic surfaces causes problems it is recommended not to paint when the relative humidity of the air is below 40% during the time of application.

Cleaning of the equipment

The parts of the painting lines that contain the paint mixture can be rinsed between the application with TEKNOCLEAN 6480 washing liquid. Do not feed TEKNOCLEAN 6480 washing liquid into the hardener line. After finishing the application the line is rinsed with e.g. TEKNOSOLV 9534.

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.

ADDITIONAL INFORMATION

The storage stability is shown on the label. The hardener reacts with air humidity. Store in a cool and dry place in a tightly closed can.

MUST NOT FREEZE.

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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