

PAINT TYPE	TEKNODUR COMBI 3440-05 is a two pack anticorrosive pigmented polyurethane paint with low solvent content where the hardener used is an aliphatic isocyanate resin.
USE	Used as a one layer paint on aluminium and anodized aluminium.
SPECIAL PROPERTIES	The paint produces a film with good mechanical and weather resistance. The product must be dried at about 60 °C for 1 hour as the adhesion and mechanical properties will be improved.

TECHNICAL DATA

Mixing ratio	Base (Comp. A): Hardener (Comp. B) TEKNODUR HARDENER 7230	6 parts by volume 1 part by volume	
Pot life, +23 °C	1½ hour.		
Solids	62 ± 2 % by volume		
Total mass of solids	Approx. 1110 g/l		
Volatile organic compound (VOC)	Approx. 360 g/l		
Recommended film thickness and theoretical spreading rate	Dry film (µm) 40 80 100	Wet film (µm) 65 129 162	Theoretical spreading rate (m ² /l) 15 7.7 6.2

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 80 µm)

- dust free (ISO 1517:1973) After 30 minutes
 - touch dry (DIN 53150:1995) After 5 hours

- overcoatable (dry film 80 µm)

Surface temperature	by itself	
	min.	max.
+5 °C	after 20 hours	2 days
+23 °C	after 4 hours	24 hour
+60 °C	1 hour	24 hour

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

Thinner Standard thinner:
TEKNOSOLV 6220

Finish Semigloss.

Colours The paint is included in the Teknotint tinting system.

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 surface are prepared according to the different materials as follows:

ALUMINIUM SURFACES: Clean with suitable pre-treatment chemical agent. Surfaces that are exposed to weathering are also roughened up with sweep blast-cleaning (AlSaS) or sanding.

ANODIZED ALUMINIUM SURFACES: It is important that anodizing is done according to valid standards. It is recommended that Teknos' laboratory has tested and approved the quality of the anodizing before use of TEKNODUR 3440. Clean the surfaces with TEKNOSOLV 6560.

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

Take into consideration the pot life of the mixture when estimating the amount to be mixed at a time. Before painting the base and hardener are mixed in right proportion. Stir thoroughly down to the bottom of the vessel. Inadequate stirring or incorrect mixing ratio results in imperfect curing and impaired film properties.

Application

Before use stir the paint thoroughly.
If required the paint is diluted with TEKNOSOLV 6220.
Do not use universal diluent or thinner, since they react with the hardener.
Apply the paint with brush, conventional spray or airless spray. Airless spray nozzle 0.11" - 0.015".

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 both eyes and face are to be protected.

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

Before use clean the spray gun and paint vessels with the paint's own thinner.

Application conditions

During the application and drying period the temperature of the ambient air, the surface and the paint shall be above +5 °C and the relative humidity below 80 %.

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.

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.

Use opened hardener within two weeks.

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.
