

PAINT TYPE	TEKNODUR COMBI 3442 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. The paint can also be used as a topcoat in polyurethane and epoxy coating systems. It is suitable for use on steel, zinc and aluminium surfaces. The paint can be used on several different types of substrates and on many well attached old paint surfaces.
SPECIAL PROPERTIES	The paint produces a high gloss film with good mechanical and weather resistance. The use of TEKNODUR 0250 or TEKNODUR 0290 polyurethane varnish is recommended on objects when the topcoat is required to have excellent gloss and colour retention.

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	58 ± 2 % by volume	
Total mass of solids	975 g/l	
Volatile organic compound (VOC)	380 g/l	
Recommended film thickness and theoretical spreading rate	Dry film (µm) 40 80	Wet film (µm) 67 133
		Theoretical spreading rate (m ² /l) 15 7.5

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
 - fully cured After 7 days

- overcoatable, 50 % RH (dry film 80 µm)

Surface temperature	By itself	
	min.	max.
+5 °C	after 20 hours	-
+23 °C	after 4 hours	-

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 3442-X7: Semi-gloss - gloss
 3442-X9: High gloss

Colours	By agreement. TEKNODUR 3442-09 colours are produced on tinting machine.
HEALTH AND SAFETY	See Safety Data Sheet.
DIRECTION FOR USE	
Surface preparation	<p>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:</p> <p>STEEL SURFACES: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1). Roughening the surface of thin-plate improves the adhesion of the paint to the substrate.</p> <p>ALUMINIUM SURFACES: Treat the surfaces with Cleaning Agent. Surfaces that are exposed to weathering are also roughened up with sweep blast-cleaning (AISaS) or sanding.</p> <p>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.</p> <p>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.</p>
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	<p>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 0.15" - 0.017".</p> <p>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.</p> <p>The can with hardener must be opened with caution, as pressure may develop in the can during storage.</p> <p>Before use clean the spray gun and paint vessels with the paint's own thinner.</p>
Application conditions	<p>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 %.</p> <p>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.</p>
ADDITIONAL INFORMATION	<p>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.</p> <p>Use opened hardener within two weeks.</p> <p>Additional instructive information for surface preparation can be found in standards EN ISO 12944-4 and ISO 8501-2.</p>