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| 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 for the surface treatment of steel rafters. The paint can also be used as a topcoat in polyurethane and epoxy coating systems. Suitable for use on steel surfaces. |
| SPECIAL PROPERTIES | The paint can be applied in high film thickness and the flow coalescence on welding is good. |

TECHNICAL DATA

| Mixing ratio | Base (Comp. A): Hardener (Comp. B) TEKNODUR HARDENER 7227-23 | 8 parts by volume 1 part by volume | | | | | | | | | | | |
|--|---|--|---------------------|-----------|--|------|------|--------------|----------------|---|---------------|---------------|---|
| Pot life, +23 °C | 1½ hour | | | | | | | | | | | | |
| Solids | 56 ± 2 % by volume | | | | | | | | | | | | |
| Volatile organic compound (VOC) | 400 g/l | | | | | | | | | | | | |
| Recommended film thickness and theoretical spreading rate | Dry film (µm) 80 120 | Wet film (µm) 142 214 Theoretical spreading rate (m²/l) 7.00 4.67 | | | | | | | | | | | |
| 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) - touch dry (DIN 53150:1995) - fully cured | After 30 minutes After 5 hours After 7 days | | | | | | | | | | | | |
| - overcoatable, 50 % RH (dry film 80 µm) | <table border="1"> <tr> <th rowspan="2">Surface temperature</th><th colspan="2">By itself</th></tr> <tr> <th>min.</th><th>max.</th></tr> <tr> <td>+5 °C</td><td>after 20 hours</td><td>-</td></tr> <tr> <td>+23 °C</td><td>after 4 hours</td><td>-</td></tr> </table> | | Surface temperature | By itself | | min. | max. | +5 °C | after 20 hours | - | +23 °C | after 4 hours | - |
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| +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 | 20-40 | | | | | | | | | | | | |
| Colours | By agreement. TEKNODUR 3442-07 colours are produced on tinting machine. | | | | | | | | | | | | |

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 surfaces are prepared according to the different materials as follows:

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.

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.

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 0.15"-0.025".

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 can with hardener 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.