

TYPE	2-K PU combi coating.
USE	To be used on metal as single-layer coat or in combination with primer for build-up of corrosion classes.
SPECIAL PROPERTIES	It has a good resistance against sun, moist, gasoline, oil and chemicals. It does not chalk and is weather and impact-proof. Containing corrosion inhibitor. At 120 µm dry film: Corrosion class C3 (ISO 12944).

TECHNICAL DATA

Hardener	M 1353.		
Mixing ratio	See label.		
Potlife at 25 °C	1 hour		
Solids by volume	Without hardener:	55-70 %	
	With hardener:	55-70 %	
Volatile organic compound (VOC)	300-360 g/l depending on colour		
Density	Without hardener:	1.50-1.60	
	With hardener:	1.45-1.55	
Recommended film thickness and theoretical spreading rate	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m ² /l)
	120	200	5
Drying time at 20 °C / 60 % RH (120 µm dry film)			
- dust free	½-1 hour		
- surface dry (ISO 1517)	1-2 hours.		
- overcoatable	Overcoatable with 2-K EP or 2-K PU after min. 6 hour, max. 6 months – eventually light sanding. With all air-drying coats within min. 6 hours, max. 10 days - eventually light sanding.		
Drying time – stoving or forced drying 50-80 °C	De-aeration time: 10 min. Stoving time: 40-60 min.		
Thinner	TEKNOSOLV 6120-00 or TEKNOSOLV 7140-00.		
Cleaning	TEKNOSOLV 7140-00.		
Gloss (60°)	At your request.		
Colour range	Available in all RAL and NCS-S colours or at your request.		
Storage	See page 2.		
HEALTH AND SAFETY	See Safety Data Sheet.		

DIRECTIONS FOR USE**Surface preparation**

The surface must be clean, dry and free from grease, oil, rust and iron scale.

Cold-rolled steel: Please contact our technical department for further information.

Hot-rolled steel: Abrasive blasting to preparation grade SA 2½ (ISO 8501-1:1988).

Galvanized steel: Please contact our technical department for further information.

Other surfaces: Please contact our technical department for further information.

Recommended primer

TEKNODUR PRIMER.

Application conditions

Application to follow right after the surface preparations. When coating the temperature of the ambient air, paint and surface must be above 10 °C and the relative humidity below 80 %. Additionally, the temperature of the surface to be painted must be at least 3 °C above the dew point of the ambient air to avoid condensation.

Application data

Equipment
Airless

Nozzle
0.015"-0.019"

ADDITIONAL INFORMATION

The storage stability is shown on the label.
Store in a tightly closed container.

The product must be stored at temperatures between +5 °C and +25 °C.

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.
