

TYPE	TEKNODUR COMBI 93200 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 top coat in Polyurethane 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	It has a good resistance against sun, moist, gasoline, oil and chemicals. It does not chalk and is weather and impact-proof.

TECHNICAL DATA

Hardener	TEKNODUR HARDENER 901500-00.		
Mixing ratio	See label.		
Potlife at 25 °C	2 hours		
Solids by volume	Without hardener:	50-70 %	
	With hardener:	50-70 %	
Volatile organic compound (VOC)	320-400 g/l depending on colour		
Density	Without hardener:	1.0-1.6	
	With hardener:	1.0-1.6	
Recommended film thickness and theoretical spreading rate	Dry film (µm) 120	Wet film (µm) 200	Theoretical spreading rate (m ² /l) 5
Drying time at 20 °C / 40-60 % RH (120 µm dry film)			
- dust free	½-1 hour		
- surface dry (ISO 1517)	2-3 hours.		

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

Surface temperature	by itself	
	min.	max.*
+5 °C	After 20 h	18 months or extended**
+23 °C	After 4 h	18 months or extended **

* A completely clean surface is mandatory to ensure the best intercoat adhesion. If the maximum overcoating interval has been exceeded, the surface must be roughened before overcoating. Increase in film thickness and rise in the relative humidity of the air in the drying space slow down the drying process and effect the overcoating properties.

** Maximum overcoating interval can be extended in certain circumstances. To determine if extended overcoating interval is applicable please consult Teknos representative in written form.

If some other top coats besides the ones mentioned above are used, please contact Teknos representative for overcoating recommendations.

Drying time – stoving or forced drying 50-80 °C De-aeration time: 10 min.
Stoving time: 40-60 min.

Thinner Fast thinner: TEKNOSOLV 7140-00
Slow thinner: TEKNOSOLV 6190-00
Standard thinner: TEKNOSOLV 6220-00

Cleaning TEKNOSOLV 7140-00.

Colour range Available in all RAL and NCS-S colours or at your request.

Storage See page 3.

HEALTH AND SAFETY See Safety Data Sheet.

DIRECTIONS 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.

ZINC SURFACES: Hot-dip-galvanized steel structures that are exposed to atmospheric corrosion can be painted if the surfaces are sweep blast-cleaned (SaS) till matt all over. Suitable cleaning agents are, e.g. aluminium oxide and natural sand. It is not recommended according to standard ISO 12944-5 to paint hot-dip-galvanized objects that are subjected to immersion strain. Painting of hot-dip-galvanized objects that are subjected to immersion strain must be discussed separately with Teknos.

It is recommended that new zinc-coated thin-plate structures are treated with sweep blast-cleaning (SaS). Surfaces that have been weathered to matt can be treated also with suitable washing agent for galvanized surfaces.

ALUMINIUM SURFACES: Treat the surfaces with suitable washing agent for galvanized surfaces. Surfaces that are exposed to weathering are also roughened up with sweep blast-cleaning (AlSaS) or sanding.

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.
When needed, thin the paint with TEKNOSOLV 9526 or TEKNOSOLV 6220.
Do not use universal diluent or thinner, since they react with the hardener.
Apply by conventional spray or airless spray. Use airless spray nozzle size 0.013 - 0.019".

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.

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

Application conditions

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 +5 °C and the relative air 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.
