TECHNICAL DATA SHEET
4 10-05-2017

TEKNODUR COMBI 93206

Lacquer
93206-XX

TYPE	TEKNODUR COMBI 93206 is a two-pack anticorrosive-pigmented polyurethane paint with low solvent content where the hardener used is an aliphatic isocyanate resin.
USE	Applied as a single-layer system on metal or in combination with metallisation for build-up of corrosion classes for steel constructions with high demands.
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 90150-00 (M 1353).
Mixing ratio	See label.
Pot life, +25 °C	Approx. 2 hours
Solids by volume	Without hardener 61-65 % With hardener 58-62 %
Volatile organic compound (VOC)	Approx. 340 g/l depending on colour.
Density	Without hardener 1,45-1,55 With hardener 1,40-1,50

Recommended film thickness and theoretical spreading rate	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m²/l)
	120	200	5

Drying time at +20 °C / 60 % RH (120 µm dry film)	
- dust free	30 min.
- surface dry (ISO 1517)	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 times – 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 6120-00.
Gloss (60°)	50-70.
Colour range	Available in all RAL and NCS-S colours or at your request.
HEALTH AND SAFETY	See Safety Data Sheet.

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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-zinc-coated 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 to paint galvanized objects that are subjected to immersion strain. 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 Cleaning Agent.

ALUMINIUM SURFACES: Treat the surfaces with PELTIPESU Cleaning Agent. 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 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, dilute the paint with TEKNOSOLV 6120 or TEKNOSOLV 7140. Do not use universal diluent or thinner, since they react with the hardener. Apply by conventional spraying or airless spraying. Airless nozzle size 0.011-0.013". 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 mixing vessels with a thinner suitable for the paint.

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

Storage: See label.
Store in a tightly closed container. The hardener reacts with air humidity. Use opened hardener within two weeks.

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

Additional instructive information for surface preparation can be found in standards EN ISO 12944-4 and ISO 8501-2.