

<b>PAINT TYPE</b>	2-component reaction drying polyurethane primer.
<b>USE</b>	Primer for steel, aluminium, zinc and polyurethane plastic. Primer / sealer for treatment of MDF.
<b>SPECIAL PROPERTIES</b>	Excellent adhesion to the above mentioned materials. Provides an efficient protection of steel against corrosion in connection with a suitable topcoat. Has a pore tight, hard, impact resistant elastic surface. Efficient protection against water uptake by MDF.

## TECHNICAL DATA

Mixing ratio by volume	Base (Comp. A): Hardener (Comp. B): TEKNODUR HARDENER 7320		7 parts by volume 1 part by volume
Pot life, +23 °C	Approx. 8 hours.		
Solids	Approx. 42 %		
Total mass of solids	747 g/l		
Volatile organic compound (VOC)	511 g/l		
Recommended film thickness and theoretical spreading rate	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m²/l)
	40	80	10
Drying time at +23 °C / 50 % RH			
- dust free (ISO 1517)	Approx. 30 minutes		
- touch dry (ISO 3678)	Approx. 2 hours		
Drying time at +80 °C / 50 % RH	Dry through after 30 minutes.		

The drying times are based on a film thickness of 40 µm.

- overcoatable

with itself				with TEKNODUR topcoat			
+ °C		+23 °C		+ °C		+23 °C	
min.		2 hours				2 hours	
max.		7 days				7 days	

<b>Thinner</b>	See page 2.
<b>Clean up</b>	TEKNOSOLV 6220-00.
<b>Finish</b>	Can be supplied in a gloss level of maximum 10 measured at an angle of 60°.
<b>Colours</b>	Can be supplied in white, black, grey, oxide red, oxide yellow and pink.
<b>Storage</b>	See additional information.
<b>HEALTH AND SAFETY</b>	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. Subsequently the surfaces are pre-treated.

**Cold-rolled steel:** Clean with suitable pre-treatment chemical agent.

**Hot-rolled steel:** Shot or abrasive blasting to preparation grade SA 2½ according to ISO standard 8501-1:1988.

**Hot-zinc-coated steel:** 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 zinc-coated objects that are subjected to immersion strain.

**Aluminium:** Suitable chemical pre-treatment.

**Recommended shop primer:** KORRO SS 3120.

**Polyurethane plastic:** The plastic must be free from release- and motive agent and dust.

**MDF:** Sanding with grain 240.

### Mixing of the components

To achieve a satisfactory result, it is important that the hardener is mixed correctly; incomplete stirring or incorrect dosage may result in the product not curing correctly, which will detract from the properties of the product. 15 minutes after the addition of hardener the viscosity in-creases. Final adjustment of the spraying viscosity has to be made after the time period.

### Application conditions

The surface to be painted must be dry. When coating and curing the temperature of the air, paint and surface must be above 10 °C and the relative air humidity below 80 %.

### Application

<u>Equipment</u>	<u>Thinner</u>	<u>Suggested viscosity</u> <u>DIN-cup 4 mm 20 °C</u>
Air spraying	TEKNOSOLV 6220-00	20-40 s
Airless (nozzle: 0.013"-0.018")	TEKNOSOLV 6220-00	Undiluted or up to approx. 5% thinner

### ADDITIONAL INFORMATION

Adhesion to plastic must be tested for each application as different plastic compounds may cause variation.

Storage: See label.

Store in a tightly closed container.

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](http://www.teknos.com).