

PAINT TYPE	2-component reaction drying polyurethane primer.
USE	Primer for steel, aluminium, zinc and polyurethane plastic.
SPECIAL PROPERTIES	Excellent adhesion to the abovementioned materials. Provides an efficient protection of steel against corrosion together with a suitable topcoat. Has a pore tight, hard, impact resistant elastic surface.

TECHNICAL DATA

Hardener	For this type use TEKNODUR HARDENER 7320-00.		
Mixing ratio by volume	Base (comp. A)		7 parts by volume
	Hardener (comp. B) TEKNODUR HARDENER 7320-00		1 part by volume
	Base (comp. A)		9 parts by weight
	Hardener (comp. B) TEKNODUR HARDENER 7320-00		1 part by weight
Pot life, +23 °C	Approx. 6 hours.		
Solids	Approx. 42 %		
Total mass of solids	749 g/l		
Volatile organic compound (VOC)	506 g/l		
Recommended film thickness and theoretical spreading rate	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m ² /l)
	40	90	10-12
Drying time at +23 °C / 50 % RH - dust free (ISO 1517) - touch dry (ISO 3678)	Approx. 30 minutes		
	Approx. 3 hours		
Drying time at +80 °C / 50 % RH	Dry through after 30 minutes.		
- overcoatable	by itself or TEKNODUR		
	+ °C		+23 °C
	min.		2 hours
	max.		7 days
Thinner	See page 2.		
Clean up	TEKNOSOLV 6220-00.		
Finish	-		
Colours	Oxide red.		
Storage	See additional information.		
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. 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.

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 must 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	6220-00	20-40 s
Airmix/aircoat	6220-00	Delivery viscosity
Airless (nozzle: 0.011" – 0.015")	6220-00	Delivery viscosity

ADDITIONAL INFORMATION

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.