

<b>TYPE</b>	TEKNODUR PRIMER 93400 is a PU primer.
<b>USE</b>	To be used on metal in combination with topcoat for build-up of corrosion classes.
<b>SPECIAL PROPERTIES</b>	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.

**TECHNICAL DATA**

<b>Hardener</b>	M 6751.		
<b>Mixing ratio</b>	See label.		
<b>Potlife at 25 °C</b>	4-5 hours.		
<b>Solids by volume</b>	Without hardener:	36-46 %	
	With hardener:	36-46 %	
<b>Volatile organic compound (VOC)</b>	Approx. 470 g/l depending on colour.		
<b>Density</b>	Without hardener:	1.25-1.45	
	With hardener:	1.25-1.45	
<b>Recommended film thickness and theoretical spreading rate</b>	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m <sup>2</sup> /l)
	40	95	10.2
<b>Drying time at 20 °C / 60 % RH (40 µm dry film)</b>			
- dust free	30 min.		
- surface dry (ISO 1517)	2 hours		
- overcoatable	Overcoatable with TEKNODUR COMBI, wet in wet application.  With itself or TEKNODUR PRIMER after min. 2 hours, and max. 7 days.		
<b>Drying time – stoving or forced drying 60-80 °C</b>	De-aeration time: 10-15 min. Stoving time: 20-30 min.  Over-curing as a result of higher temperatures or longer stoving time than stated might cause adhesion problems between the layers.		
<b>Thinner</b>	TEKNOSOLV 6120-00 or TEKNOSOLV 7140-00.		
<b>Cleaning</b>	TEKNOSOLV 6120-00.		
<b>Gloss (60°)</b>	Mat		
<b>Colour range</b>	Available in rose-pink, yellow or light grey or any colour at your request.		
<b>Storage</b>	See page 2.		
<b>HEALTH AND SAFETY</b>	See Safety Data Sheet.		

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**DIRECTIONS FOR USE****Surface preparation**

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

**Cold-rolled steel:** Degreasing and phosphatising.

**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**

Possibly SHOP PRIMER or ZINCDUST 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  
0.011"-0.013"

**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.

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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).

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