

PAINT TYPE	TEKNOPOX 0156 is a two-pack epoxy paint with low solvent content.
USE	Used as a one-layer paint on spray metallized surfaces, where "mist coat" technique is used. In middle corrosive environments TEKNOPOX 0156 can be used as a primer in epoxy polyurethane systems.
SPECIAL PROPERTIES	TEKNOPOX 0156 is applied by twin-feed spray. The paint film withstands heavy abrasion, oils, grease, solvents and chemical splashing. Over time TEKNOPOX 0156 epoxy paint will turn yellow and when exposed to the weather it will chalk. It is recommended to coat with a polyurethane paint such as TEKNODUR 3740 if good gloss and colour stability is required.

TECHNICAL DATA

Mixing ratio	Base (Comp. A): Hardener (Comp. B): TEKNOPOX HARDENER 7291-00	4 parts by volume 1 part by volume
Pot life, +23 °C	1 hour	
Solids	63 ± 2 % by volume	
Total mass of solids	Approx. 1220 g/l	
Volatile organic compound (VOC)	Approx. 330 g/l	
Recommended film thickness and theoretical spreading rate	Dry film (µm) 80 120 150	Wet film (µm) 127 190 240
		Theoretical spreading rate (m ² /l) 7.9 5.2 4.2

As many of the paint's properties will change if too thick coats are applied, it is not recommended that the product is applied to a film thickness that is more than double of the thickest recommended film.

Practical spreading rate	The values depend on the application technique, surface conditions, overspray, etc.
Drying time at +23 °C / 50 % RH (dry film 80 µm)	
- dustfree (ISO 1517:1973)	After 1 hour
- touch dry (DIN 53150:1995)	After 3 hours

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

	By itself or TEKNODUR 3740	
Surface temperature	min.	max. *
+10 °C	after 10 hours	after 7 days
+23 °C	after 3 hours	after 3 days

* Maximum overcoating interval without roughening.

Increase in film thickness and rise in the relative humidity of the air in the drying space usually slow down the drying process.

Thinner and clean up	TEKNOSOLV 9506.
Finish	Semi-gloss.
Colours	RAL 7035.
HEALTH AND SAFETY	See Safety Data Sheet.

DIRECTION FOR USE**Surface preparation**

Remove from the surfaces any contaminations 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. After degreasing the thin-plate is matted down to a homogeneous rough surface.

ZINC SURFACES: Hot-dip-galvanized steel structures 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).

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.

Shopprimer

KORRO E Epoxy, KORRO SE Zink Epoxy and KORRO SS Zink Silicate Prefabrication Primers can be used, when required.

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 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 shell be above 10 °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.

Application

Before use stir the paint thoroughly.
If required the paint is diluted with TEKNOSOLV 9506, but the product is delivered ready for use for airless spraying without dilution.

Apply preferably by airless spray as only this method provides the recommended film thickness in a single operation. Use airless spray nozzle 0.013 – 0.019". Brush or roller can be used for touching up and painting small areas.

When twin-feed spray is used for application, the mixing ratio of the dosage pump must be 4:1. The feed pump pressure and the consumption of components. The components cannot be thinned if a twin-feed spray with fixed mixing ratio is used.

ADDITIONAL INFORMATION

The storage stability is shown on the label. Store in a cool place and in tightly closed containers.

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.
