

**TEKNOPOX 3296****Epoxy Coating**

PAINT TYPE	TEKNOPOX 3296 is a two-pack low solvent content epoxy coating.		
USAGE	Used on coating the insides of natural gas pipes.		
SPECIAL PROPERTIES	Can be applied straight on blast-cleaned steel surface. The coating fulfils the requirements of the American Standard API 5L2 (RP 5L2).		
TECHNICAL DATA			
Mixing ratio	Base (Comp. A): Hardener (Comp B): TEKNOPOX HARDENER 7580		4 parts by volume 1 part by volume
Pot life, +23 °C	1 h		
Solids	86 ±2% by volume		
Total mass of solids	abt. 1400 g/l		
Volatile organic compound (VOC)	abt. 120 g/l		
Recommended film thickness and theoretical spreading rate	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m²/l)
	65	75	13,2
As many of the paint's properties will change if too thick coats are applied, it is not recommended that 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 - forced drying, 60°C Overcoatable	after 60 min after 2 h		
Thinner, clean up	TEKNOSOLV 44994		
Finish	TEKNOPOX 3296-06 gloss		
Colours	Reddish brown		
SAFETY MARKINGS	See Material Safety Data Sheet.		

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**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. 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 (ISO 8501-1).

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 the 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 shall be above +10°C and the relative air humidity below 80%.

**Application**

Apply preferably by two-component spray as only this method provides the recommended film thickness in a single operation. Use airless spray nozzle 0.017 - 0.021". Brush can be used for touching up and painting small areas.

Wash the painting equipment with TEKNOSOLV 44994 immediately after use.

**ADDITIONAL  
INFORMATION**

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

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The information of this data sheet is normative and based on laboratory tests and practical experience. Teknos guarantees that the product quality conforms to our quality system. Teknos accepts, however, no liability for the actual application work, as this is to a great extent dependent on the conditions during handling and application. Teknos accepts no liability for any damage resulting from misapplication of the product. This product is intended for professional use only. This implies that the user possesses sufficient knowledge for using the product correctly with regard to technical and working safety aspects. The latest versions of Teknos data sheets, material safety data sheets and system sheets are on our home pages [www.teknos.com](http://www.teknos.com).

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