DATA SHEET 2279
2 17.05.2019

TEKNOPOX 3298-00
Epoxy Phenol Novolac Coating

PAINT TYPE
TEKNOPOX 3298-00 is an almost solvent-free epoxy coating based on epoxy phenol novolac resin.

USAGE
TEKNOPOX 3298-00 is designed for anticorrosion protection of inside surfaces of oil pipes.

SPECIAL PROPERTIES
TEKNOPOX 3298-00 has excellent adhesion to blast cleaned substrate and excellent wear resistance. It is resistant to many chemicals like hydrochloric acid, alkaline solutions, most solvents, crude oil and oil products. TEKNOPOX 3298-00 withstands well high pressure and rapid decompression.

TECHNICAL DATA

Mixing ratio
Base (Comp. A): 6 parts by volume
Hardener (Comp B): TEKNOPOX HARDENER 7575 1 part by volume

Pot life, +23 °C
15 min

Solids
96 ±2% by volume

Total mass of solids
abt. 1500 g/l

Volatile organic compound (VOC)
abt. 50 g/l

Recommended film thickness and theoretical spreading rate

Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m²/l)
400	416	2,4
500	520	1,9

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, +23°C / 50% RH (dry film 500 µm)
- **dust free (ISO 9117-3:2010)** after 2 h
- **touch dry (DIN 53150:1995)** after 3 h
- **fully cured** after 2 d

Overcoatable

	by itself	
surface temperature	min.	max.*
+10°C	after 3 h	after 2 d
+23°C	after 1 h	after 24 h

* 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
Not to be diluted.

Clean up
TEKNOSOLV 9530

Finish
Semigloss

Colours
TM 9375/14. Other shades by request.
NOTE! Sunlight and chemicals cause the colour and glossiness to change in time.

SAFETY MARKINGS
See Safety Data Sheet.

PTO

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).
The profile of the blast-cleaned surface must be at least coarse (reference comparator "G"). See standard ISO 8503-2 (G).

CONCRETE SURFACES: The concrete must be at least 4 weeks old, well-hardened and solid. The water content of the top layer must not exceed 4% by weight.
Smooth down any spatter and irregularities on the surfaces by grinding. Brush away loose cement, sand and dust. Wash oily and greasy surfaces with detergent or solvent. Remove dense laitance if present by etching with BETONI-PEITTAUSLIUOS Agent or by grinding or blast-cleaning.

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.

Prefabrication primer

All prefabrication primer coats must be completely removed regardless of the binder type. In practice this means that when the surface is viewed vertically from a distance of 1 meter and in normal lighting conditions the surface is of an evenly grey colour, i.e. the preparation grade is Sa 2½ (ISO 8501-1).

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. Mixing by machine is recommended, for example a slow-rotating hand-drill equipped with a mixer. 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%.
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

BY TWIN-FEED SPRAY: For demanding areas it is recommended that the application is done by a hot twin-feed spray, e.g. Graco Hydra-Cat, with turn-nozzle 0,018 - 0,026".

The ration of the dosage pump must be 6 : 1. The heating of the components shall be adjusted so that the temperature on the gun is +30 - +50°C. The pot life of the mixture is then 5 - 10 min. If necessary, the hoses must be heated. The film thickness is controlled by a wet film gauge. Check the feed pump consumption of the components to ensure the correct mixing ratio.
Directions given by the manufacturer of the twin-feed spray are to be followed when working.

The painting equipment must be cleaned immediately after use.

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.

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