



TEKNOPOX AQUA COMBI 0370

Epoxy Paint

PAINT TYPE	TEKNOPOX AQUA COMBI 0370 is a water-borne two-pack epoxy paint for metal surfaces.
USAGE	Used as a single layer paint or as a top coat in water-borne epoxy coating systems that will be exposed to weathering. It is suitable to use on steel, zinc and aluminium surfaces.
SPECIAL PROPERTIES	The paint is suited for use as single paint without a primer, especially in engineering and paint shops and in painting on site in corrosivity category C2. Suitable for drying at elevated temperatures +60-80°C.

TECHNICAL DATA

Mixing ratio	Base (Comp. A): Hardener (Comp B): TEKNOPOX AQUA HARDENER 0301	4 parts by volume 1 part by volume
Pot life, +23 °C	2 h	
Solids	45 ±2% by volume	
Total mass of solids	abt. 575 g/l	
Volatile organic compound (VOC)	abt. 58 g/l	
Recommended film thickness and theoretical spreading rate	Dry film (µm)	Wet film (µm)
	80	177
		Theoretical spreading rate (m ² /l)
		5,6

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 80 µm)

- dust free (ISO 9117-3:2010) after 1 h
- touch dry (DIN 53150:1995) after 3 h

Overcoatable, 50% RH (dry film 80 µm)

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

* 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	Water
Clean up	Water, possibly with an addition of TEKNOSOLV 1612 if the paint has started to dry.
Finish	0370-08: gloss
Colours	RAL-9003 and TM-5275/03 orange
SAFETY MARKINGS	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. 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.

ZINC SURFACES: Hot-dip-galvanized 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 according to standard ISO 12944-5 to paint hot-dip-galvanized objects that are subjected to immersion strain. Painting of hot-dip-galvanized objects that are subjected to immersion strain must be discussed separately with Teknos.

It is recommended that new zinc-coated thin-plate structures are treated with sweep blast-cleaning (SaS). Surfaces that have been weathered to matt can be treated also with PELTIPESU Cleaning Agent.

ALUMINIUM SURFACES: Treat the surfaces with PELTIPESU Cleaning Agent. Surfaces that are exposed to weathering are also roughened up with sweep blast-cleaning (AISaS) or sanding.

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.

THE READY MIXTURE MUST BE USED WITHIN THE POT LIFE, MIXTURES OLDER THAN THIS ARE UNFIT FOR USE.

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 70%.

Especially when applying with a spray the relative air humidity should be above 30% to avoid the onset of the drying process to be too fast.

Application

Before use stir the paint thoroughly.

Apply preferably by airless spray (nozzle size 0.011 - 0.015"), air-assisted low-pressure spray or conventional spray. The paint is sprayed in an even coat to the required film thickness. Special care should be taken when spraying edges, corners and welding joints. Small areas can also be painted with a brush, but in this case one additional coat has to be applied in order to achieve the required film thickness.

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.

MUST NOT FREEZE.

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.



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