

TEKNOPOX AQUA PRIMER 3

Epoxy Primer

PAINT TYPE TEKNOPOX AQUA PRIMER 3 is a water-borne, two-pack epoxy primer for metal surfaces. The paint contains effective, lead and chromate free anticorrosive pigments.

USAGE Used as a priming coat in abrasion and chemical resistant Painting Systems K1 and K16 on blast-cleaned steel.
The paint is suitable as anticorrosive paint on steel and aluminium, acid-proof steel, zinc-coated and thin-plate surfaces. It can be overcoated with all types of paints.

TECHNICAL DATA

Mixing ratio Base (Comp. A): 1 part by volume
Hardener (Comp B): TEKNOPOX AQUA HARDENER 0300 1 part by volume
or
Hardener (Comp B): TEKNOPOX AQUA HARDENER 0300-02

Pot life, +23 °C with TEKNOPOX AQUA HARDENER 0300 1½ h,
with TEKNOPOX AQUA HARDENER 0300-02 1 h

Solids 45 ±2% by volume
MIOX: 47 ±2% by volume

Total mass of solids abt. 680 g/l
MIOX: abt. 890 g/l

Volatile organic compound (VOC) abt. 40 g/l
MIOX: abt. 30 g/l

Recommended film thickness and theoretical spreading rate	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m ² /l)
		60	133
	80	178	5,6
	120	267	3,7
	MIOX:		
	60	127	7,8
	80	170	5,9
	120	255	3,9

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 60 µm)

- dust free (ISO 9117-3:2010) with TEKNOPOX AQUA HARDENER 0300 2 h,
with TEKNOPOX AQUA HARDENER 0300-02 50 min

- touch dry (DIN 53150:1995) with TEKNOPOX AQUA HARDENER 0300 10 h,
with TEKNOPOX AQUA HARDENER 0300-02 5 h

Overcoatable, 50% RH (dry film 60 µm)

surface temperature	by itself, with TEKNOPLAST 50, TEKNOPLAST HS 150 or with INERTA 50		with TEKNOPOX AQUA 0350, TEKNOPOX AQUA 0360 or with TEKNODUR AQUA- and TEKNODUR -series top coats	
	min.	max.*	min.	max.*
+15°C	after 1 d	after 6 months	after 2 d	after 1 month
+23°C	after 4 h	after 6 months	after 4 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, clean up Water

Finish Semi-matt

Colours Red and grey
Also available as MIOX-pigmented

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 (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 RENSA STEEL washing agent for galvanized surfaces.

ALUMINIUM SURFACES: Treat the surfaces with RENSA STEEL washing agent for galvanized surfaces. Surfaces that are exposed to weathering are also roughened up with sweep blast-cleaning (AlSaS) or sanding.

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

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

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 +15°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, since only this method provides the recommended film thickness in a single operation. Use airless spray nozzle 0.013 - 0.018". For MIOX -pigmented paints use spray nozzle 0,015 - 0,019" and filter 0,315 mm (50 mesh). The paint is sprayed evenly 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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