
TYPE	AQUA 2-K EPOXY PRIMER.
USE	Usable as corrosion protecting primer in connection with AIR DRYING TOPCOAT or 2-K TOPCOAT.
SPECIAL PROPERTIES	High impact resistance and good resistance to moisture, gasoline, oil and chemicals. Contains active corrosion pigments. Is covered by the epoxy/polyurethane regulations.

TECHNICAL DATA

Hardener	G 5977		
Mixing ratio	1000:190 by weight, 5.3:1 1000:250 by volume.4.0:1		
Potlife at 25 °C	2-4 hours		
Solids by volume	Without hardener:	42-44 %	
	With hardener:	40-44 %	
Volatile organic compound (VOC)	Approx. 40 g/l depending on colour		
Density	Without hardener:	1.40-1.48	
	With hardener:	1.30-1.38	
Recommended film thickness and theoretical spreading rate	Dry film (µm) 60-100	Wet film (µm) 150-250	Theoretical spreading rate (m ² /l) 5-6
Drying time at 20 °C / 60 % RH (80 µm dry film)			
- dust free	½-1 hour		
- surface dry (ISO 1517)	4 hours		
- overcoatable	After 8 hours with all air drying and 2-K systems.		
Drying time – stoving or forced drying 50 °C	De-aeration time: 10 min. Stoving time: 30 min.		
Thinner	Water.		
Cleaning	TEKNOCLEAN 90900-00 G5798.		
Gloss (60°)	10		
Colour range	Available in all RAL and NCS-S colours or at your request. Risk of whitening in strong sunlight.		
Storage	See page 2.		
HEALTH AND SAFETY	See Safety Data Sheet.		

DIRECTIONS FOR USE**Surface preparation**

The surface must be clean, dry and free from grease, oil, rust and iron scale.

Cold-rolled steel: Degreasing and phosphatising.

Hot-rolled steel: Abrasive blasting to preparation grade SA 2½ (ISO 8501-1:1988).

Galvanized steel: Degreasing.

Other surfaces: Aluminium: Degreasing.

Recommended primer

At non treated steel TEKNOCRYL AQUA PRIMER can be used as adhesion primer.

Application conditions

Application to follow right after the surface preparations. When coating the temperature of the ambient air, paint and surface must be above 10 °C and the relative humidity below 80 %. Additionally the temperature of the surface to be painted must be at least 3 °C above the dew point of the ambient air to avoid condensation.

Application data

<u>Equipment</u>	<u>Nozzle</u>	<u>Rotation viscosity</u> <u>R4/60, 20 °C</u>
Airmix	0.013"-0.017"	4000-4500
Airless	0.013"-0.017"	4000-4500

ADDITIONAL INFORMATION

The storage stability is shown on the label.
Store in a tightly closed container.

The product must be stored at temperatures between +5 °C and +25 °C.

Avoid any welding in the paint film.

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.
