DS 097

5 17.08.2017

TEKNOPOX PRIMER 7-00 MIOX

Fast curing epoxy primer

PAINT TYPE

TEKNOPOX PRIMER 7-00 MIOX is a fast curing two-pack epoxy primer containing anticorrosive pigments (zinc phosphate and micaceous iron oxide). The product cures also in low temperatures (above -10ºC).

USAGE

The paint is used as anticorrosive coating, primer or intermediate coat in painting systems suited for fast recoating with another layer or in automated painting systems.

SPECIAL PROPERTIES

The matt surface, hard, mechanically resistant and well attached to subjects. The surface is resistant to atmospheric conditions. Exposed to direct sun radiation, the surface may chalk or change the shade.

TECHNICAL DATA

Mixing ratio

Base (Comp. A):	100 parts by volume
Hardener (Comp. B): TEKNOPOX HARDENER 7377	14 parts by volume

Pot life; +23°C

3 h

Solids (ISO 3233)

65±1% by volume

Total mass of solids

abt. 1200 g/l

Volatile organic compounds (VOC)

abt. 320 g/l

Recommended film thickness and theoretical spreading rate

Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m^2/l)
80	123	8,1
100	154	6,5
150	230	4,3

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 at +23ºC / 50% RH for 100 µm dry film thickness

- **dust free** after 15 min
- **touch dry** after 45 min
- **fully cured** after 5 days

Overcoatable, 50% RH for 100 µm dry film thickness

temperature	by itself		by polyurethane top coats form Emapur, Teknodur 70 5-00 or Teknodur 0050 groups**	
	min.	max.	min.	max.
-5ºC	9 h	2 months*	9 h	1 month*
0ºC	5,5 h	2 months*	5,5 h	1 month*
+5ºC	3,5 h	2 months*	3,5 h	1 month*
+10ºC	1 h	2 months*	1 h	1 month*
+23ºC	45 min	2 months*	45 min	1 month*

*unlimited in internal conditions. A completely clean surface is mandatory to ensure the best intercoat adhesion. If the maximum overcoating interval has been exceeded, the surface must be roughened before overcoating. Increase in film thickness and rise in the relative humidity of the air in the drying space slow down the drying process and effect the overcoating properties.

**If some other top coats besides the ones mentioned above are used, please contact Teknos representative for overcoating recommendations.

Thinner

Not needed. IF needed (eg. rise in viscosity) use TEKNOSOLV 564 or TEKNOSOLV 9506.

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Clean up TEKNOSOLV 564 or TEKNOSOLV 9506

Finish Matt

Colours 810 – light grey 880 – dark grey

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 2˝ (standard ISO 8501-1). Roughening the surface of thin-plate improves the adhesion of the paint to the substrate.
OLD PAINTED SURFACES SUITABLE FOR OVERCOATING: The paint can be used on the old, well-adhered paint surfaces, which should be cleaned to minimum P St2 according to PN ISO 8501-2 with mechanically-manually de-rusting (wirebrushing or power tool cleaning). 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.
ZINC SURFACES: Hot-dip-galvanized steel and aluminium 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. It is recommended that new zinc-coated thin-plate structures are treated with sweep blast-cleaning (SaS). Surfaces that have been weathered to matt should be zinc corrosion products free (white rust free) and any contaminant-free. The surface for painting should be dry, dust-, grease- and salt-free.

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. 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

During the application and drying period the minimum temperature of the surface shall be above -5°C (frost- and ice-free surface), at least 3°C above the dew point of the ambient air. Minimum ambient air temperature -10°C. Maximum humidity 85%. Minimum paint temperature +15°C. Adequate ventilation during application and drying.

Application

Airless spray recommended (brush – only for small areas). For brush painting it is recommended to thin paint (abt. 3% of thinner) and to paint several times to achieve typical dry film thickness.
Airless spray application recommendation:

nozzle	0,013 - 0,017”
pressure	20 - 30 MPa

When preparing painting specification, depending on subject and type of construction, different dry film thickness than recommended can be assumed. During airless spray application typical dry film thickness range is between 80 and 300 µm. Different dry film thickness than recommended causes change in theoretical spreading rate, wet film thickness, weight of dry film thickness, drying time, overcoating time and ready for handling time.

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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