

Suitable corrosivity categories/durability ranges

C

| Paint system ISO 12944-5 | Low | Medium | High | Very high |
|--------------------------|-----|--------|------|-----------|
| C3.07 | X | X | X | X |
| C4.06 | X | X | X | |
| C5.02 | X | X | | |

TEC3.07 Very high
TEC4.06 High
TEC5.02 Medium

2-COMPONENT COMBI Paint systems 240 µm

1 1.8.2018

2-COMPONENT COMBI paint systems consist of different types of paint chemistries. These direct to metal two layer paint systems have excellent adhesion to steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints and fast curing polyaspartics have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

| Paint | | A1 | A2 | A3 | A4 | A5 | A6 |
|------------------------------------|-----|----------|----------|----------|-----------|----------|----------|
| TEKNOPLAST HS 150 | EP | 2x120 µm | | | | | |
| TEKNOMASTIC COMBI 80-500 | EP | | 2x120 µm | | | | |
| INERTA 271 | EP | | | 2x120 µm | | | |
| TEKNODUR COMBI 3430 -series | PUR | | | | 2x120 µm | | |
| TEKNODUR COMBI 340-811 | PUR | | | | | 2x120 µm | |
| TEKNODUR COMBI 3560 -series | PAS | | | | | | 2x120 µm |
| Total film thickness | | 240 µm | 240 µm | 240 µm | 240 µm | 240 µm | 240 µm |
| Paint system VOC, g/m ² | | 103 | 59 | 63 | 138 - 180 | 94 | 16 - 144 |

| Example of Teknos paint system code | Example of paint system structure |
|-------------------------------------|--|
| TEC3.07/VH/A1 | ISO 12944-5/C3.07-EP (EP240/2-FeSa 2½). |
| TEC4.06/H/A4 | ISO 12944-5/C4.06-PUR (PUR240/2-FeSa 2½) |
| TEC5.02/M/A6 | ISO 12944-5/C5.02-PAS (PAS240/2-FeSa 2½) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

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.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

For more detailed information about of the above-mentioned products please see individual product data sheets.