

**Suitable corrosivity categories/durability ranges**

**C**

Paint system ISO 12944-5	Low	Medium	High	Very high
<b>C3.07</b>	<b>X</b>	<b>X</b>	<b>X</b>	<b>X</b>
<b>C4.06</b>	<b>X</b>	<b>X</b>	<b>X</b>	
<b>C5.02</b>	<b>X</b>	<b>X</b>		

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

**TEKNOMASTIC 80 PRIMER**  
**Paint systems 240 µm**

1 1.8.2018

TEKNOMASTIC 80 PRIMER paint systems consist of an epoxy primer with good adhesion to the substrate and high corrosion protection properties.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing polyaspartic top coat as option.

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		EP-top coat		PUR-top coat				PAS-top coat
		E1	E2	E3	E4	E5	E6	E7
TEKNOMASTIC 80 PRIMER	<b>EP</b>	1x160 µm	2x100 µm	2x100 µm	1x160 µm	1x160 µm	1x160 µm	1x160 µm
TEKNOPLAST HS 150	<b>EP</b>	1x80 µm						
TEKNOPLAST 50 / 90	<b>EP</b>		1x40 µm					
TEKNODUR 0050 / 0090	<b>PUR</b>			1x40 µm				
TEKNODUR 3410-series	<b>PUR</b>				1x80 µm			
TEKNODUR COMBI 3430-series	<b>PUR</b>					1x80 µm		
TEKNODUR COMBI 340-811	<b>PUR</b>						1x80 µm	
TEKNODUR COMBI 3560-series	<b>PAS</b>							1x80 µm
Total film thickness		240 µm	240 µm	240 µm	240 µm	240 µm	240 µm	240 µm
Paint system VOC, g/m <sup>2</sup>		73	81	79 / 85	81 - 90	85 - 99	70	44 - 87

Example of Teknos paint system code	Example of paint system structure
TEC3.07/VH/E1	ISO 12944-5/C3.07-EP (EP240/2-FeSa 2½).
TEC4.06/H/E3	ISO 12944-5/C4.06-EP/PUR (EPPUR240/3-FeSa 2½).
TEC5.02/M/E7	ISO 12944-5/C5.02-EP/PAS (EPPAS240/2-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.