

TECHNICAL DATASHEET

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Product name: **TEKNOCOAT AQUA PRIMER 221-104**
Item Number: **E110101-1**

Description & Intended use:

This product is recommend for the industrial lacquering of wood-based substrates. Water borne pigmented primer to applied in roller machines. This product improves the adhesion between the board and the following direct printed PDL- build up.

The Product is a specially designed primer for production lines with line speed > 40m/min. Vacuum and spray application of TEKNOCOAT AQUA PRIMER 221-104 is possible.

Characteristics:

Viscosity: 50 ± 10 sec. DIN 6mm/20°C*

Density at 20°C: 1,6 ± 0,2 kg/l

Solid Content: 60 - 70 by weight %, fast test halogen dryer (160°C, 1g; Internal test standard No. 26)

Pigments: Contains no lead-, cadmium- or chromate pigments

VOC: see Safety Data Sheet

Classification: No migration of hazardous materials such as heavy metals.

Roller application:

Preparation: Stire well before use

Hardener: None

Thinner: If required, adjust viscosity with water

Viscosity: As delivered

Temperature: The best application-temperature is 20 – 35°C.

Film Weight: 2 x 15 - 30g/m² (wet) with intermediate drying per roller application.

*Determined on day of product release.

Application technology advice, technical data or recommendations are carried out to the best of our ability, albeit non-binding exluding warranty and limitation on liability. This data sheet will be rendered invalid as soon as replaced by a revised version. Please request the latest version.

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Product name: **TEKNOCOAT AQUA PRIMER 221-104**

Item Number: **E110101-1**

Application: Roller coater, with a shore hardness of preferable 40 – 50 shore (Isobutylen/Isopren-Copolymer or EPDM-Prepolymer).

Drying: 10 – 15s at 130°C jet air dryer, with airspeed of 25 – 30 m/s and a fresh air proportion of 15%. Sufficient drying should be checked by preliminary tests.

Vacuum and spray-application:

Vacuum and spray application is possible after adjusting the viscosity to processing conditions. We recommend adding maximum 40% of water. The quantity of water is determined to the required consistency. For application and processing proposals please ask our representative.

Substrate: This product was especially developed for the direct printing and lacquering process of wood-based substrates. Please consult our technical staff prior to other application.

Storage: The product should be stored between 5°C and 30°C. At a temperature of $23 \pm 2^\circ\text{C}$ the product has a shelf life of up to 12 month, from produce date, in its original sealed trading unit. Higher temperatures reduce the shelf life. Protect from sunlight and frost.

Cleaning: Clean equipment with water directly after use.

Health & Safety: See Safety Data Sheet.