

BASIC CAMOUFLAGE COATING SYSTEMS

K122

3 19.12.2011

Powder coating systems for basic camouflage painting on thin-plate surfaces and other objects, which are chemically prepared or mechanically cleansed before powder coating. The same quality and durability of camouflage coating is achieved by both preparation methods.

The coating is done either as single colour painting (AN11, AN22, AN33 or AN44) or as patterned coating (PNS), in which case the pattern application is done according to the instructions over the powder coating with solvent-borne camouflage paint.

To be used outdoors in corrosivity categories C4 and C5.

CHEMICALLY PREPARED SURFACES:

Teknos Coating System Symbol	K122a
Marking of the system:	Nm30-PE180/2-PNS
The coating system structure:	PE180/2-Fe/Al/Zn
INFRALIT PE 8317-10 AN100 Polyester Powder	1 x 80 µm
INFRALIT PE 8431-10 AN11/AN22/AN33/AN44 Polyester Powder	1 x 100 µm
Total film thickness	180 µm
Coating system VOC, g/m ²	0
INERTA 70 CAMOUFLAGE PAINT AN11/AN22/AN33/AN44 (pattern application over powder coating)	1 x 40 µm
Total film thickness	220 µm
Coating system VOC, g/m ²	50

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. The surfaces are prepared according to the different materials as follows:

Steel surfaces: Zinc phosphating. Other preparations, such as iron phosphating and newer chemical pre-treatments are acceptable, if the produced corrosion protection has been tested and documented.

Aluminium surfaces: Chromating. Other preparations, such as zinc or iron phosphating and newer chemical pre-treatments are acceptable, if the produced corrosion protection has been tested and documented.

Zinc and similar surfaces: Chromating or zinc phosphating. Other preparations, such as iron phosphating and newer chemical pre-treatments are acceptable, if the produced corrosion protection has been tested and documented.

MECHANICALLY CLEANSSED SURFACES:

Teknos Coating System Symbol	K122b	K122c
Marking of the system:	Nm30-PE180/2-PNS	Nm30-PE180/2-PNS
The coating system structure:	PE180/2-FeSa 2½	PE180/2-AISaS/ZnSaS
INFRALIT PE 8316-05 Zinc Polyester Powder	1 x 80 µm	—
INFRALIT PE 8317-10 AN100 Polyester Powder	—	1 x 80 µm
INFRALIT PE 8431-10 AN11/AN22/AN33/AN44 Polyester Powder	1 x 100 µm	1 x 100 µm
Total film thickness	180 µm	180 µm
Coating system VOC, g/m ²	0	0
INERTA 70 CAMOUFLAGE PAINT AN11/AN22/AN33/AN44 (pattern application over powder coating)	1 x 40 µm	1 x 40 µm
Total film thickness	220 µm	220 µm
Coating system VOC, g/m ²	50	50

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, see EN ISO 12944, section 4. 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 2½ (standard ISO 8501-1). Roughening the surface of thin plate improves the adhesion of the paint to the substrate.
Aluminium surfaces: The surfaces are sweep blast-cleaned (SaS).
Zinc and similar surfaces: The surfaces are sweep blast-cleaned (SaS).

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.

Instructive information for surface preparation can be found in standards EN ISO 12944-4 and ISO 8501-2.

Measuring the film thickness

The measuring point must be noticed when measuring the film thickness of PNS patterned surfaces, because the minimum film thickness depends on the number of paint coats on the measuring point.

Usage Protecting steel, aluminium and zinc surfaces in weather strain.

Teknos symbol	Typical use
CHEMICALLY PREPARED SURFACES:	
K122a	Steel, aluminium and zinc surfaces outdoors in corrosivity category C4.
MECHANICALLY CLEANSED SURFACES :	
K122b	Steel surfaces outdoors in corrosivity category C5.
K122c	Aluminium and zinc surfaces outdoors in corrosivity category C4.

Technical Data

Paint	INFRALIT PE 8431-10	INFRALIT PE 8316-05	INFRALIT PE 8317-10	INERTA 70 CAMOUFLAGE PAINT
Product code	DN26080020/ DN27220020/ DN90330020/ DN70440020	DZN8000020	DN25700020	1770211.../ 1770222.../ 1770233.../ 1770244...
Data sheet no.	1221	1052	1051	278
Paint type	polyester powder	polyester powder	polyester powder	polyurethane paint
Paint description	camouflage powder	zinc enriched powder priming coat	camouflage green powder priming coat	polyurethane camouflage paint
Colours	AN11/AN22/AN33/ AN44	grey	AN100	AN11/ AN22/AN33/AN44
Finish (G60°)	max. 1.5 (G60°) max. 5.0 (G85°)	limit values 50-80	limit values 3-11	Max. 1 (EN ISO 2813:1999, 60°)
Volume solids %	100	100	100	40 ±2
Volatile Organic Compounds (VOC)	0	0	0	abt. 500 g/l
Recommended film thickness, µm	80-120	60-120	60-100	dry film: 40
Theoretical spreading rate	6-10 m ² /kg	abt. 6 m ² /kg	6-10 m ² /kg	10 m ² /l
Curing time/Drying time	15 min / 210°C	10 min / 180°C	10 min / 180°C	Dust free, +23°C/50% RH: after 1 h. Overcoatable, +23°C: after 6 h.