

**Suitable corrosivity categories/durability ranges**

**C**

| Teknos paint system code | Low | Medium | High | Very high |
|--------------------------|-----|--------|------|-----------|
| P243a-C3/M               | X   | X      |      |           |
| P243b-C4/M               | X   | X      |      |           |
| P243c-C4/H               | X   | X      | X    |           |
| P243d-C4/H               | X   | X      | X    |           |
| P243e-C5/H               | X   | X      | X    |           |
| P243f-C5/H               | X   | X      | X    |           |
| P243g-C5/H               | X   | X      | X    |           |

**P243a-C3 Medium**  
**P243b-C4 Medium**  
**P243c-C4 High**  
**P243d-C4 High**  
**P243e-C5 High**  
**P243f -C5 High**  
**P243g-C5 High**

**EPOXY, POLYESTER & EPOXY-POLYESTER  
 CHEMICALLY PRE-TREATED CARBON STEEL  
 Paint systems**

2 29.05.2019

Teknos INFRALIT Powder Coating systems have been designed to fulfill the test methods and testing times defined for specific corrosivity category in ISO 12944-6, even though powder coatings are not covered by the standard.

Please consult TEKNOS representative for choosing the most suitable product.

| Paint                                          |       | P243a        | P243b         | P243c         | P243d         | P243e         | P243f         | P243g         |
|------------------------------------------------|-------|--------------|---------------|---------------|---------------|---------------|---------------|---------------|
| Corrosion category                             |       | C3/M         | C4/M          | C4/H          | C4/H          | C5/H          | C5/H          | C5/H          |
| INFRALIT EP/PE 8087-30                         | EP/PE | -            | -             | -             | 80 µm         | -             | -             |               |
| INFRALIT EP 8024                               | EP    | -            | -             | -             | -             | 120 µm        | -             |               |
| INFRALIT EP/PE 8086-05                         | EP/PE | -            | -             | -             | -             | -             | 80 µm         |               |
| INFRALIT PE 8350-15                            | PE    | 80 µm        | 100 µm        | 2x80 µm       | 80 µm         | -             | 100 µm        | 2x80 µm       |
| <b>Total dry film thickness</b>                |       | <b>80 µm</b> | <b>100 µm</b> | <b>160 µm</b> | <b>160 µm</b> | <b>120 µm</b> | <b>180 µm</b> | <b>160 µm</b> |
| <b>Paint system VOC*, g/m<sup>2</sup></b>      |       | <b>0</b>     | <b>0</b>      | <b>0</b>      | <b>0</b>      | <b>0</b>      | <b>0</b>      | <b>0</b>      |
| <b>Suitable chemical pre-treatment methods</b> |       |              |               |               |               |               |               |               |
| Zinc phosphating                               |       | X            | X             | X             | X             | X             | X             | X             |
| Thin film technology** (TFT)                   |       | X            | X             | X             | X             | X             | X             |               |
| Iron phosphating                               |       | X            |               |               |               |               |               |               |

\*Teknos powder coating products are solvent-free. However, they might contain some volatile organic compounds as residuals from additives, though the quantities are very low.

\*\*Thin film technology is explained in detail in the brochure Powder Coating as a Corrosion Protection Method.

| Example of paint system structure                            |
|--------------------------------------------------------------|
| P243a-C3/M – PE 8350-15 80/1 – Zn-phosph or TFT or Fe-phosph |

These Teknos painting systems have been tested 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:** Chemical pre-treatment should be made according to instructions given by the pre-treatment chemical supplier. The pre-treatment should cover all areas of the target substrate.

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

**Suitable corrosivity categories/durability ranges**

**C**

| Teknos paint system code | Low | Medium | High | Very high |
|--------------------------|-----|--------|------|-----------|
| P241-C4/M                | X   | X      |      |           |

**P241-C4 Medium**

**INFRALIT EP 8025-00  
Paint system 120 µm**

2 29.05.2019

INFRALIT EP 8025-00 paint system consists of a single layer of the epoxy paint.

The paint system gives excellent corrosion protection properties. The epoxy product is designed for heavy industrial use where UV resistance is not needed.

Teknos INFRALIT Powder Coating systems have been designed to fulfill the test methods and testing times defined for specific corrosivity category in ISO 12944-6, even though powder coatings are not covered by the standard.

Please consult TEKNOS representative for choosing the most suitable product.

| Paint                               |    | P241     |
|-------------------------------------|----|----------|
| INFRALIT EP 8025-00                 | EP | 1x120 µm |
| Total dry film thickness            |    | 120 µm   |
| Paint system VOC*, g/m <sup>2</sup> |    | 0        |

\*Teknos powder coating products are solvent-free. However, they might contain some volatile organic compounds as residuals from additives, though the quantities are very low.

| Example of paint system structure      |
|----------------------------------------|
| P241-C4/M – EP 8025-00 120/1 - FeSa 2½ |

These Teknos painting systems have been tested 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 the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**
**C**

| Teknos paint system code | Low | Medium | High | Very high |
|--------------------------|-----|--------|------|-----------|
| P219a-C5/H               | X   | X      | X    |           |
| P219f-C5/H               | X   | X      | X    |           |

**P219a-C5 High**  
**P219f -C5 High**

## INFRALIT EP/PE 8086-05 Paint systems 160 µm

2 29.05.2019

INFRALIT EP/PE 8086-05 paint systems consist of two different paints where the primer is a zinc epoxy-polyester paint containing 75-50 % zinc by weight in the dry film.

Paint systems, containing INFRALIT EP/PE 8086-05 primer, give excellent corrosion protection properties. Topcoats for these corrosivity categories can be chosen from epoxy or polyester chemistry.

The epoxy topcoat is designed for heavy industrial use where UV resistance is not needed. Where outdoor durability and UV resistance is expected, it is recommended to use the polyester topcoat.

Teknos INFRALIT Powder Coating systems have been designed to fulfill the test methods and testing times defined for specific corrosivity category in ISO 12944-6, even though powder coatings are not covered by the standard.

Please consult TEKNOS representative for choosing the most suitable product.

|                                     |       | EP-<br>topcoat | PE-<br>topcoat |
|-------------------------------------|-------|----------------|----------------|
| Paint                               |       | P219a          | P219f          |
| INFRALIT EP/PE 8086-05              | EP/PE | 1x60 µm        | 1x60 µm        |
| INFRALIT EP 8026-00                 | EP    | 1X100 µm       | -              |
| INFRALIT PE 8350-15                 | PE    | -              | 1X100 µm       |
| Total dry film thickness            |       | 160 µm         | 160 µm         |
| Paint system VOC*, g/m <sup>2</sup> |       | 0              | 0              |

\*Teknos powder coating products are solvent-free. However, they might contain some volatile organic compounds as residuals from additives, though the quantities are very low.

| Example of paint system structure                          |
|------------------------------------------------------------|
| P219a-C5/H - EP/PE 8086-05 60/1 EP 8026-00 100/1 - FeSa 2½ |

These Teknos painting systems have been tested 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 the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**
**C**

| Teknos paint system code | Low | Medium | High | Very high |
|--------------------------|-----|--------|------|-----------|
| P218b-C3/M               | X   | X      |      |           |
| P218d-C4/M               | X   | X      |      |           |

**P218b-C3 Medium**  
**P218d-C4 Medium**

## INFRALIT PE 8350-15 Paint systems 80 & 100 µm

2 29.05.2019

INFRALIT PE 8350-15 paint systems consist of two different film thicknesses of the same product where the corrosion protection is better as the film gets thicker.

Paint systems, containing INFRALIT PE 8350-15 product give good corrosion and weathering protection properties.

The polyester paint series has excellent protection against UV light and weather stress. The product has also the Qualicoat and GSB approvals for architectural class 1 coating.

Teknos INFRALIT Powder Coating systems have been designed to fulfill the test methods and testing times defined for specific corrosivity category in ISO 12944-6, even though powder coatings are not covered by the standard.

Please consult TEKNOS representative for choosing the most suitable product.

| Paint                               |           | P218b   | P218d    |
|-------------------------------------|-----------|---------|----------|
| INFRALIT PE 8350-15                 | <b>PE</b> | 1x80 µm | 1x100 µm |
| Total dry film thickness            |           | 80 µm   | 100 µm   |
| Paint system VOC*, g/m <sup>2</sup> |           | 0       | 0        |

\*Teknos powder coating products are solvent-free. However, they might contain some volatile organic compounds as residuals from additives, though the quantities are very low.

| Example of paint system structure     |
|---------------------------------------|
| P218b-C3/M – PE8350-15 80/1 - FeSa 2½ |

These Teknos painting systems have been tested 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 the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**Im**

| Teknos paint system code | Low | Medium | High | Very high |
|--------------------------|-----|--------|------|-----------|
| P234c-Im3/VH             | X   | X      | X    | X         |

**P234c-Im3 Very High**

**INFRALIT EP 8024-00  
Paint system 480 µm**

2 29.05.2019

INFRALIT EP 8024-00 paint system consists of one thick layer of the epoxy paint.

The paint system gives excellent corrosion protection properties. The epoxy product is designed for heavy industrial use in immersed conditions.

Teknos INFRALIT Powder Coating systems have been designed to fulfill the test methods and testing times defined for specific corrosivity category in ISO 12944-6, even though powder coatings are not covered by the standard.

Please consult TEKNOS representative for choosing the most suitable product.

| Paint                                |           | P234c     |
|--------------------------------------|-----------|-----------|
| INFRALIT EP 8024-00                  | <b>EP</b> | 1x480 µm* |
| Total dry film thickness             |           | 480 µm    |
| Paint system VOC**, g/m <sup>2</sup> |           | 0         |

\*Alternatively 2x240 µm coating layers

\*\*Teknos powder coating products are solvent-free. However, they might contain some volatile organic compounds as residuals from additives, though the quantities are very low.

| Example of paint system structure            |
|----------------------------------------------|
| P234c-Im3/VH – EP 8024-00 480/1(2) - FeSa 2½ |

These Teknos painting systems have been tested 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 the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**
**G**

| Teknos paint system code | Low | Medium | High | Very high |
|--------------------------|-----|--------|------|-----------|
| P229i-C5/VH              | Zn  | Zn     | Zn   | Zn        |
| P229j-C5/M               | Zn  | Zn     |      |           |

**P229i-C5 Very High**  
**P229j-C5 Medium**

## INFRALIT EP/PE 8087-30 & PE 8350-15 HOT-DIP GALVANIZED STEEL Paint systems 140 µm

2 29.05.2019

INFRALIT EP/PE 8087-30 / PE 8350-15 paint systems for galvanized steel consist of diverse types of paint chemistries.

Epoxy-polyester paints have by their nature good mechanical and corrosion protection properties. Polyester paints have good gloss and colour retention properties outdoors. Polyester series 8350-15 has also Qualicoat/GSB approvals for class 1 architectural quality product.

Teknos INFRALIT Powder Coating systems have been designed to fulfill the test methods and testing times defined for specific corrosivity category in ISO 12944-6, even though powder coatings are not covered by the standard.

Please consult TEKNOS representative for choosing the most suitable product.

| Paint                               |              | P229i  | P229j    |
|-------------------------------------|--------------|--------|----------|
| INFRALIT EP/PE 8087-30              | <b>EP/PE</b> | 60 µm  | -        |
| INFRALIT PE 8350-15                 | <b>PE</b>    | 80 µm  | 60+80 µm |
| Total dry film thickness            |              | 140 µm | 140 µm   |
| Paint system VOC*, g/m <sup>2</sup> |              | 0      | 0        |

\*Teknos powder coating products are solvent-free. However, they might contain some volatile organic compounds as residuals from additives, though the quantities are very low.

| Example of paint system structure                           |
|-------------------------------------------------------------|
| P229i-C5/VH - EP/PE 8087-30 60/1 + PE 8350-15 80/1 - Zn*SaS |

\*Other recommended galvanizing method is aluzinc. Electro galvanization is not recommended.

These Teknos painting systems have been tested 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:** Hot-dip galvanized steel 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.

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

**Suitable corrosivity categories / offshore environments**
**CX**

|                                 |             |
|---------------------------------|-------------|
| <b>Teknos paint system code</b> | <b>High</b> |
| <b>P220a-CX</b>                 | <b>X</b>    |

**P220a-CX**

## OFFSHORE PAINT SYSTEM

### INFRALIT PE 8316-05

### Paint system 230 µm

2 29.05.2019

INFRALIT PE 8316-05 paint systems consist of two different paints where the primer is a zinc polyester paint containing 75-50 % zinc by weight in the dry film. Topcoat is a Qualicoat/GSB approved architectural quality polyester.

Paint systems, containing INFRALIT PE 8316-05 primer, give excellent corrosion protection properties.

The polyester topcoat gives the system excellent UV and weathering resistance properties. Series 8350-15 has also Qualicoat/GSB approvals for class 1 architectural quality product.

Teknos INFRALIT Powder Coating systems have been designed to fulfill the test methods and testing times defined for specific corrosivity category in ISO 12944-9, even though powder coatings are not covered by the standard.

Please consult TEKNOS representative for choosing the most suitable product.

| Paint                                |           | <b>P220a</b> |
|--------------------------------------|-----------|--------------|
| INFRALIT PE 8316-05                  | <b>PE</b> | 1x80 µm      |
| INFRALIT PE 8350-15                  | <b>PE</b> | 1x150 µm*    |
| Total dry film thickness             |           | 230 µm       |
| Paint system VOC**, g/m <sup>2</sup> |           | 0            |

\*Alternatively 2\*75 µm coating layers

\*\*Teknos powder coating products are solvent-free. However, they might contain some volatile organic compounds as residuals from additives, though the quantities are very low.

| <b>Example of paint system structure</b>                          |
|-------------------------------------------------------------------|
| P220a-CX - PE 8316-05 80/1 PE 8350-15 150/1 - FeSa 2½ + Zn-phosph |

These Teknos painting systems have been tested 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) followed by zinc phosphating. The surface profile must be at least medium (G) as defined in standard ISO 8503-1.

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

# 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 <sup>2</sup>                                                     | 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 <sup>2</sup>                                                     | 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 <sup>2</sup>                                                     | 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 <sup>2</sup>                                                     | 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                                                             |
|-----------------------------------------|-------------------------------------------------------------------------|
| <b>CHEMICALLY PREPARED SURFACES:</b>    |                                                                         |
| K122a                                   | Steel, aluminium and zinc surfaces outdoors in corrosivity category C4. |
| <b>MECHANICALLY CLEANSED SURFACES :</b> |                                                                         |
| K122b                                   | Steel surfaces outdoors in corrosivity category C5.                     |
| K122c                                   | Aluminium and zinc surfaces outdoors in corrosivity category C4.        |

### Technical Data

| Paint                            | INFRALIT<br>PE 8431-10                                  | INFRALIT<br>PE 8316-05               | INFRALIT<br>PE 8317-10                  | INERTA 70<br>CAMOUFLAGE PAINT                                                |
|----------------------------------|---------------------------------------------------------|--------------------------------------|-----------------------------------------|------------------------------------------------------------------------------|
| Product code                     | DN26080020/<br>DN27220020/<br>DN90330020/<br>DN70440020 | DZN8000020                           | DN25700020                              | 1770211.../<br>1770222.../<br>1770233.../<br>1770244...                      |
| Data sheet no.                   | 1221                                                    | 1052                                 | 1051                                    | 278                                                                          |
| Paint type                       | polyester powder                                        | polyester powder                     | polyester powder                        | polyurethane paint                                                           |
| Paint description                | camouflage powder                                       | zinc enriched<br>powder priming coat | camouflage green<br>powder priming coat | polyurethane<br>camouflage paint                                             |
| Colours                          | AN11/AN22/AN33/<br>AN44                                 | grey                                 | AN100                                   | AN11/<br>AN22/AN33/AN44                                                      |
| Finish (G60°)                    | max. 1.5 (G60°)<br>max. 5.0 (G85°)                      | limit values 50-80                   | limit values 3-11                       | Max. 1 (EN ISO<br>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 m²/kg                                              | abt. 6 m²/kg                         | 6-10 m²/kg                              | 10 m²/l                                                                      |
| Curing time/Drying time          | 15 min / 210°C                                          | 10 min / 180°C                       | 10 min / 180°C                          | Dust free, +23°C/50%<br>RH: after 1 h.<br>Overcoatable, +23°C:<br>after 6 h. |

# TEKNOZINC SS 1K / INFRALIT SI 8009-02 ZINC SILICATE PAINT / SILICONE POWDER SYSTEM, INFRALIT SI 8009-05 / SI 8009-02 SILICONE POWDER SYSTEM

# P242

3 30.11.2017

TEKNOZINC SS 1K is a moisture curing zinc dust paint with ethyl binder.  
 INFRALIT SI 8009-02 is a silicone powder that will cure at elevated temperatures (200-220 °C).  
 INFRALIT SI 8009-05 is a zinc silicone powder that will cure at elevated temperatures (200-220 °C).  
 The combination of zinc dust paint and silicone powder effectively protects the surface from corrosion and resists high temperatures up to +600°C  
 INFRALIT SI 8009-05 zinc silicone primer is recommended to be cured completely. If powder is not cured completely the adhesion between primer and top coat may be diminished.

| Teknos Coating System Symbol                                                | P242a                           | P242b                          |
|-----------------------------------------------------------------------------|---------------------------------|--------------------------------|
| EN ISO 12944-5 (2007)<br>corrosivity category / durability range            | C4/M                            | C4/H                           |
| The coating system structure:                                               | ESIZn(R)70/1-SI60/1<br>FeSa 2 ½ | SIzN(R)70/1-SI70/1<br>FeSa 2 ½ |
| TEKNOZINC SS 1K Zinc Silicate paint                                         | 1 x 70 µm                       | -                              |
| INFRALIT SI 8009-05 Zinc silicone Powder                                    | -                               | 1 x 70 µm                      |
| INFRALIT SI 8009-02 Silicone Powder                                         | 1 x 60 µm                       | 1 x 70 µm                      |
| Total film thickness                                                        | 130 µm                          | 140 µm                         |
| Coating system VOC, g/m <sup>2</sup><br>TEKNOZINC SS 1K Zinc Silicate paint | 53                              | -                              |

Example of coating system marking: P242a – TEKNOZINC SS 1K 70/1 SI 8009-02 60/1 – FeSa 2½

## USAGE

| Teknos symbol | Typical use                                                               |
|---------------|---------------------------------------------------------------------------|
| P242a         | Metal surfaces subjected to high temperatures in corrosivity category C4. |
| P242b         | Metal surfaces subjected to high temperatures in corrosivity category C4. |

**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:

**Hot-dip-galvanized surfaces:** Blast-clean to grade Sa 2½.

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

The profile of the substrate has to be rough enough to ensure good adhesion.

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.

**Technical Data**

|                                                                                                 |                                                    |                                                                               |                                                                               |
|-------------------------------------------------------------------------------------------------|----------------------------------------------------|-------------------------------------------------------------------------------|-------------------------------------------------------------------------------|
| Paint                                                                                           | TEKNOZINC SS 1K                                    | INFRALIT SI 8009-05                                                           | INFRALIT SI 8009-02                                                           |
| Data Sheet No.                                                                                  | 1861                                               | 2225                                                                          | 1528                                                                          |
| Paint type                                                                                      | zinc rich ethyl silicate paint                     | zinc silicone powder                                                          | silicone powder                                                               |
| Colours                                                                                         | grey                                               | grey                                                                          | black                                                                         |
| Finish                                                                                          | matt                                               | matt                                                                          | matt                                                                          |
| Volyme solids %                                                                                 | 60 ±2                                              | 100                                                                           | 100                                                                           |
| Recommended film thickness<br>- wet μm<br>- dry μm                                              | 133<br>70 – 80                                     | 50 – 80                                                                       | max. 70                                                                       |
| Theoretical spreading rate                                                                      | 7,5 m <sup>2</sup> /l                              | 15–30 m <sup>2</sup> /kg                                                      | 15–30 m <sup>2</sup> /kg                                                      |
| Drying time, +23°C / 50 % RH<br>- dust free, (ISO 9117-3:2010)<br>- touch dry, (DIN 53150:1995) | (dry film 60 μm)<br>after ¼ h<br>after ½ h         | 30 min/200 °C (metal temperature)<br>See detailed information from data sheet | 30 min/200 °C (metal temperature)<br>See detailed information from data sheet |
| Overcoatble, 50 % RH                                                                            | with INFRALIT SI 8009-02                           | with INFRALIT SI 8009-02                                                      | -                                                                             |
| <b>+5°C</b>                                                                                     | after 7 d<br>(RH 90 % or wetting of surfaces)      | max. after 4 h                                                                |                                                                               |
| <b>+23°C</b>                                                                                    | after 6 h<br>(RH over 80 % or wetting of surfaces) | max. after 4 h                                                                |                                                                               |