KORRO AQUA 2741

Prefabrication primer

KORRO AQUA 2741 is a 1-pack prefabrication primer based on acrylate dispersion.

As a temporary protection on blast-cleaned steel.

KORRO AQUA 2741 can be topcoated by many 1-pack and 2-pack paints, such as water-borne acrylate, epoxy and polyurethane paints, solvent-borne epoxy and polyurethane paints, and xylene-dilutable alkyd paints.

The paint has received approval for welding by Det Norske Veritas (Certificate no. TAK00002HC).

TECHNICAL DATA

Certificates, approvals and classification	Det Norske Veritas
Recommended substrate	Steel, Aluminium, Zinc
Binder	Acrylate
Solids	37 ±2% by volume
Total mass of solids	Approx. 650 g/l
Volatile organic compound (VOC)	Approx. 35 g/l (DIRECTIVE 2010/75/EU) The VOC value provided is the average value for factory produced products, and consequently it will be subject to variations between individual products covered by this Technical Data Sheet.
Theoretical spreading rate	The typical nominal film thickness 20 µm is equivalent to a wet film thickness of 53 µm on a smooth surface. The theoretical spreading rate is then 19 m²/l, see standard EN 10238.
Practical spreading rate	In practice, the spreading rate on surfaces prepared by blast-cleaning has been found to be between 10 - 14 m²/l.
Colours	Red. Other colours by agreement.
Gloss (60°)	Matt
Thinner	Water.
Storage	The storage stability is shown on the label. Store in a cool place and in tightly closed containers. Do not transport or store at temperatures below 0°C. Must not freeze.

DIRECTION FOR USE

Surface preparation	Remove from the surfaces any contaminants that might be detrimental to surface preparation and application. Remove also water-soluble salts by using appropriate methods. 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). Additional instructive information for surface preparation can be found in standards EN ISO 12944-4 and ISO 8501-2.
Application method	Airless spraying
Application	Stir thoroughly before use. Apply as evenly as possible. The best result is achieved by an automatic airless spray. Suitable airless nozzle size 0.015 - 0.021".
Application conditions	The surface to be treated must be dry. During the application and drying period the temperature of the ambient air, the surface and the product shall be above +15°C and the relative air humidity below 70%. Additionally, the temperature of the surface to be treated and the product must be at least +3°C above the dew point of the ambient air. Especially when applying with a spray the relative air humidity should be above 30% to avoid the onset of the drying process to be too fast. Surface temperature, film thickness, drying temperature and ventilation affect the drying of the paint. The paint is dry when all water has evaporated from the paint film. It is essential that all painted surfaces have sufficient ventilation. If the painted surface will be exposed to weathering, moisture or low temperatures (below +10°C) thick paint films are to be avoided and the last coat must be allowed to dry for at least 24 hours (at +23°C) before exposure. Low temperatures and insufficient ventilation slow down the drying process.

Drying time	+23 °C / 50% RH (dry film 20 µm)
- dust free	1 - 3 min (ISO 9117-3:2010)
- touch dry	5 min (ISO 9117-5:2012)

Overcoatable

surface temperature	by 1-pack water-borne paints*		by 2-pack water-borne paints and by 1-and 2-pack solvent-borne paints*	
	min.	max.	min.	max.
+15 °C	6 h	-	12 h	-
+23 °C	3 h	-	6 h	-

* See 'Top coating and suitable top coats'.

Increase in film thickness and rise in the relative humidity of the air in the drying space usually slow down the drying process.

Top coating and suitable top coats	KORRO AQUA 2741 can be topcoated by paints of the following series: TEKNOCRYL AQUA, TEKNODUR AQUA, TEKNOPOX AQUA, TEKNOLAC, TEKNOPLAST and TEKNODUR.
Cleaning	Water. Cleaning of the equipment: When painting equipment used for application of solvent-borne paints is used for water-borne paints the equipment must be cleaned carefully: 1. Wash with solvent. 2. Wash with washing solvent for water-borne paints, e.g. TEKNOSOLV 6060. 3. Rinse with water. When shifting from water-borne to solvent-borne paints act in reverse order.

HEALTH AND SAFETY

Safety and precaution measures	See safety data sheet.

Teknos Group Oy Takkatie 3, P.O.Box 107 FI-00371 Helsinki, Finland Tel. +358 9 506 091