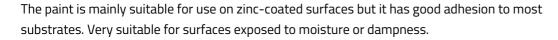


TEKNOCRYL PRIMER 25-11

Primer

TEKNOCRYL PRIMER 25-11 is a one-pack fast drying acrylic primer.





Very good adhesion to most metal surfaces. Good anticorrosive properties and also very good water and alkali resistance.

TECHNICAL DATA

Recommended substrate	Aluminium, Steel, Zinc			
Binder	Acrylic			
Solids	Approx. 48% by volume			
Total mass of solids	Approx. 736 g/l			
Volatile organic compound (VOC)	Approx. 460 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	Dry film (μm)	Wet film (µm)	Theoretical spreading rate (m²/l)	
	60	125	8.0	
	As many of the paint's properties will change if too thick coats are applied, it is			
	not recommended that the product is applied to a film thickness that is more			
	than double of the thickest recommended film.			
Practical spreading rate	The values depend on the application technique, surface conditions, overspray,			
	etc.			
Colours	Grey.			
Gloss (60°)	Matt			
Thinner	TEKNOSOLV 1639			
Storage	The storage stability is shown on the label. Must be stored tightly closed and kept cool.			



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 $2\frac{1}{2}$ (standard ISO 8501-1). Roughening the surface of thin-plate improves the adhesion of the paint to the substrate.

ZINC 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. It is not recommended according to standard ISO 12944-5 to paint hot-dip-galvanized objects that are subjected to immersion strain. Painting of hot-dip-galvanized objects that are subjected to immersion strain must be discussed separately with Teknos.

ALUMINIUM SURFACES: Treat the surfaces with RENSA STEEL washing agent. Surfaces that are exposed to weathering are also roughened up with sweep blast-cleaning (AlSaS) or sanding.

OLD PAINTED SURFACES SUITABLE FOR OVERCOATING: Any impurities that might be detrimental to the application of paint (e.g. grease and salts) are removed. The surfaces must be dry and clean. Old, painted surfaces that have exceeded the maximum overcoating time are to be roughened as well. Damaged parts are prepared in accordance with the requirements of the substrate and the maintenance coating.

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.

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

Prefabrication primer: KORRO PVB, KORRO E epoxy, KORRO SE zinc epoxy and KORRO SS zinc silicate prefabrication primers can be used, when required.

Airless spraying

Application method



Application	Stir thoroughly before use. Apply preferably by airless spray as only this method provides the recommended film thickness in a single operation. Suitable airless nozzle size 0.015". Brush can be used for touching up and painting small areas.			
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 paint shall be above 0°C and the relative air humidity below 80%. 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.			
Drying time	+20°C / 60% RH			
- dry to handle	30 min			
- overcoatable	1 h			
- forced drying	80°C / 20 min			
Overcoatable	surface temperature	by itself, GRANUWEX, GRANUWEX COMBI		
		min.	max.	
	0°C	6 h	-	
	+23°C	3 h	-	
	Increase in film thickness and rise in the relative humidity of the air in the drying			
	space usually slow down the drying process.			
Cleaning	TEKNOSOLV 1639			

HEALTH AND SAFETY

Safety and precaution measures See safety data sheet.

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

The above information is normative and based on laboratory tests and practical experiences. The information is noncommittal, and we cannot accept liability for the results obtained under working conditions beyond our control, and consequently the buyer or the user is not released from the obligation to test the suitability of our products for specific means and application methods under the actual application conditions. Our liability covers only damage caused directly by defects in the products supplied by Teknos. This product is intended for professional use only. This implies that the user possesses sufficient knowledge for using the product correctly with regard to technical and working safety aspects. The latest versions of Teknos' Technical Data Sheets and Safety Data Sheets are available from our homepage www.teknos.com. All trademarks displayed on this document are the exclusive property of Teknos Group or its affiliated companies.