

TEKNODUR 3510-23

Two-component topcoat.

Two-component reaction drying topcoat for synthetics and MDF.

Resistant to weak acids, bases, and solvents. Re-coating must be carried out within max. 36 hours, as otherwise poor adhesion between the layers may be the result. Application of silk screen-printing must be carried out within 24 hours to obtain sufficient adhesion. For internal use if an abrasion resistant and robust surface is required.



TECHNICAL DATA

Recommended substrate	MDF, Plastic		
Solids	Approx. 42% by volume		
Total mass of solids	Approx. 769 g/l		
Volatile organic compound (VOC)	Approx. 507 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)
	30	60	15
Colours	Available in colours according to RAL, NCS S or other colour cards.		
Tinting system	Teknotint		
Gloss (60°)	Approx. 30.		
Hardener	Comp. B: TEKNODUR HARDENER 7340-00		
Mixing ratio (A:B)	4,2:1 parts by volume		
Pot life, +23 °C	3h		
Thinner	Standard thinner: TEKNOSOLV 6220-00. Fast thinner: TEKNOSOLV 7120-00.		
Storage	The storage stability is shown on the label. Store in a tightly closed container.		

DIRECTION FOR USE

Priming	Max. adhesion is achieved by using one of the following primers: SYNTETICS: TEKNOSEAL 1120, TEKNODUR FILLER 3310. MDF: TEKNODUR FILLER 3310.
Application method	Conventional spraying

Application

MIXING OF THE COMPONENTS:

To achieve a satisfactory result, it is important that the hardener is mixed correctly. Inadequate stirring or incorrect mixing ratio results in imperfect curing and impaired film properties. Within the first 15 minutes following the addition of hardener, the viscosity increases. Final adjustment of the spraying viscosity must be made after this time.

Equipment	Thinner	Suggested viscosity DIN-cup 4 mm +20°C
Conventional spraying	TEKNOSOLV 6220-00 (standard)	20-25 s
	TEKNOSOLV 7120-00 (fast)	20-25 s

Application conditions

The surface to be treated must be dry. During the application and drying period the temperature of the ambient air shall be above +10°C and the relative air humidity below 80%.

Adhesion and compatibility to plastic types should be tested before application as variation may occur, dependent upon the type of plastic.

Drying time

- dust free

+23°C / 50% RH
Approx. 15 min. (ISO 1517)

- touch dry

Approx. 1 h (ISO 3678)

- forced drying

+80°C / 50% RH
- through dry: 20 min.

Drying at +80°C of TEKNODUR 3510 matt versions results in a somewhat higher gloss than drying at +23°C.

Overcoatable

Surface temperature	by it self	
	min.	max.
+23°C	1 h	36 h

Cleaning

TEKNOSOLV 6220-00

HEALTH AND SAFETY

Safety and precaution measures

See safety data sheet.

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