

TEKNODUR 3572-09

Polyurethane paint

TEKNODUR 3572-09 is a two-pack polyurethane paint where the hardener used is an aliphatic polyisocyanate resin.



Is used as a primer on composite surfaces where TEKNODUR 3572-02 is used as topcoat.

The paint produces a film with good mechanical and weather resistance. Because the paint is fast curing it is suitable for use in two pack line painting where the demand for productivity is high.



TECHNICAL DATA

Fields of application	Wind Turbine Generator Blades (WTG)									
Recommended substrate	Composite material, Filler, GRP (glass reinforced polyester)									
Solids	75 ±2 volume-%									
Total mass of solids	Approx. 1400 g/l									
Volatile organic compound (VOC)	Approx. 220 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	<table border="1"><thead><tr><th>Dry film (µm)</th><th>Wet film (µm)</th><th>Theoretical spreading rate (m²/l)</th></tr></thead><tbody><tr><td>80</td><td>106</td><td>9.4</td></tr><tr><td>120</td><td>160</td><td>6.3</td></tr></tbody></table> <p>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.</p>	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m ² /l)	80	106	9.4	120	160	6.3
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Practical spreading rate	The values depend on the application technique, surface conditions, overspray, etc.									
Colours	By agreement.									
Gloss (60°)	Gloss									
Hardener	Comp. B: TEKNODUR HARDENER 7227-00									
Mixing ratio (A:B)	2,5:1 parts by volume									
Pot life, +23 °C	15 min.									
Thinner	Standard thinners: TEKNOSOLV 1129-11, TEKNOSOLV 7140-00 or TEKNOSOLV 9526-00.									

Storage

The hardener reacts with air humidity. Store in a cool place and in tightly closed containers. The storage stability is limited. Use opened hardener within two weeks.

DIRECTION FOR USE

Surface preparation

Remove from the surfaces any contaminants that might be detrimental to surface preparation and application. 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.

Application method

Twin-feed spraying
 Suitable airless nozzle size 0.013 - 0.017".

Application

Inadequate stirring or incorrect mixing ratio results in imperfect curing and impaired film properties.

Application conditions

The surface to be treated must be dry and the relative air humidity below 80%. During the application and drying period the temperature of the ambient air and the surface shall be at least above +5 °C, and the temperature of the product above +15 °C during mixing and spraying.

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

+23 °C / 50% RH (dry film 120 µm)

- dust free

40 minutes (ISO 1517:1973)

- touch dry

50 minutes (DIN 53150:1995)

- dry to handle

1 hour (ISO 9117:1990)

Overcoatable

Dry film 120 µm	by itself or with TEKNODUR 3572-02	
	min.	max.
Surface temperature		
+5 °C	8 hours	14 days
+23 °C	1 hour	7 days

Cleaning

TEKNOSOLV 6220-00

HEALTH AND SAFETY

Safety and precaution measures

See safety data sheet.

The hardener of the product and the ready mixture contain isocyanates. In poorly ventilated areas and especially when using spray application we recommend the use of a fresh air mask. In short or temporary work, a mask with combined filter A2-P2 can be used. In this case eyes and face are to be protected.

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