

# TEKNODUR AQUA 3393-23

## Polyurethane topcoat

TEKNODUR AQUA 3393-23 is a water-borne two-component polyurethane topcoat where the hardener used is an aliphatic isocyanate resin.

Used in 1-layer and 2-layer systems directly on various composite materials and certain plastics.

The use of TEKNODUR AQUA 3394-03 is recommended where the topcoat is required to have excellent gloss and colour retention.



## TECHNICAL DATA

<b>Fields of application</b>	Exterior doors, Windows		
<b>Recommended substrate</b>	Composite material, Plastic		
<b>Solids</b>	Base 1: Approx. 35% by volume Base 2: Approx. 34% by volume Base 3: Approx. 29% by volume NCS S0502-Y: Approx. 36% by volume		
<b>Volatile organic compound (VOC)</b>	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.		
<b>Theoretical spreading rate</b>	<b>Dry film (µm)</b>	<b>Wet film (µm)</b>	<b>Theoretical spreading rate (m<sup>2</sup>/l)</b>
	57	150	Approx. 7
	Used as a 2-layer system approx. 100 µm of both TEKNODUR AQUA 3393 and TEKNODUR AQUA 3394 must be applied.		
<b>Practical spreading rate</b>	The values depend on the application technique, surface conditions, overspray, etc.		
<b>Colours</b>	By agreement.		
<b>Tinting system</b>	Teknocolour		
<b>Gloss (60°)</b>	25-30		
<b>Hardener</b>	Comp. B: HARDENER 7323-03		
<b>Mixing ratio (A:B)</b>	9:1 parts by volume		
<b>Pot life, +23 °C</b>	3h		
<b>Thinner</b>	Water. The components are not to be thinned separately.		

## Storage

The storage stability is shown on the label. Store indoors in a cool and dry place and in a tightly closed can.

The hardener reacts with air humidity and therefore the opened can is to be kept carefully closed, and it is recommended to be used within 14 d of opening.

## DIRECTION FOR USE

### Surface preparation

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

The surfaces are prepared according to the different materials as follows:

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

Airless spraying, Air-assisted airless spraying, Conventional spraying  
Nozzle size 0.011 - 0.013".

### Application

MIXING OF THE COMPONENTS:

Slowly add the hardener in one go during mechanically stirring. The stirring time is at least 5 min. Inadequate stirring or incorrect mixing ratio results in imperfect curing and impaired film properties. Dosage may also be done through a 2-K mixing system.

THE READY MIXTURE MUST BE USED WITHIN THE POT LIFE, MIXTURES OLDER THAN THIS ARE UNFIT FOR USE.

### Application conditions

The surface to be treated has to be dry. During the application and drying period, the temperature of the ambient air, the surface and the paint shall be above +18°C and the relative air humidity above 50% and below 70%.

Surface temperature, film thickness, drying temperature and ventilation affect the drying of the paint.

Drying time	+23 °C / 50% RH (dry film 40 µm)		
- dust free	30 min. (ISO 1517:1973)		
- touch dry	2 hours (DIN 53150:1995)		
Overcoatable	Low temperatures and insufficient ventilation slow down the drying process.		
	Surface temperature	byt itself or TEKNODUR AQUA 3394	
		min.	max*
	+10 °C	6 h	14 days
	+23 °C	1 h	14 days
	* Maximum overcoating interval without roughening.		
Increase in film thickness and rise in the relative humidity of the air in the drying space usually slow down the drying process.			

<b>Cleaning</b>	Clean painting equipment used for application carefully: 1. Wash with solvent, e.g., TEKNOSOLV 7030 after base (Comp. A) and the mixed product. TEKNOSOLV 6220 may be used after hardener (Comp. B). 2. Wash with washing solvent for water-borne paints after base (Comp. A) and the mixed product. 3. Rinse with water after base (Comp. A) and the mixed product.  Water, TEKNOSOLV 7030-00.
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## HEALTH AND SAFETY

<b>Safety and precaution measures</b>	The hardener can must be opened with caution, as pressure may develop in the can during storage.  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. See safety data sheet.
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