

# TEKNOLAC COMBI 50

## Alkyd paint

TEKNOLAC COMBI 50 is a quick-drying, anticorrosive pigmented, semigloss alkyd paint.



Intended for use on interior and exterior surfaces in alkyd coating systems. Can also be used in mild environmental stress classes as a single coat on steel and aluminium surfaces. The paint is very quick-drying and is therefore suitable for use in engineering and paint shops.

## TECHNICAL DATA

<b>Recommended substrate</b>	Steel		
<b>Binder</b>	Alkyd		
<b>Solids</b>	45 ±2% by volume (ISO 3233:1988)		
<b>Total mass of solids</b>	Approx. 610 g/l		
<b>Volatile organic compound (VOC)</b>	Approx. 520 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>
	40	88	11.2
	80	177	5.6
	100	222	4.5
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.			
<b>Practical spreading rate</b>	The values depend on the application technique, surface conditions, overspray, etc.		
<b>Colours</b>	Standard colours by agreement.		
<b>Tinting system</b>	Teknomix; Teknotint		
<b>Gloss (60°)</b>	Semi-gloss		
<b>Thinner</b>	TEKNOSOLV 9502, TEKNOSOLV 1639.		
<b>Storage</b>	Must be stored tightly closed and kept cool and dry.		

## 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). Roughening the surface of thin-plate improves the adhesion of the paint to the substrate.

**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 Prefabrication Primer and KORRO E Epoxy Prefabrication Primer can be used, when required.

### Application method

Airless spraying, Conventional spraying, Electrostatic spraying, Brush

### Application

Stir thoroughly before use. Suitable airless nozzle size 0.013 - 0.015".

When painting with bright red or yellow colours on surfaces that will be subjected to specific rubbing by clothing (seats, banisters etc.), it is recommended to get in touch with Teknos's Technical Service.

### 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 +5°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.

**Thinning**

For application by conventional spray the paint is thinned by about 10% with TEKNOSOLV 9502 or TEKNOSOLV 1639.

**Drying time**

+23 °C / 50% RH (dry film 40 µm)

**- dust free**

15 min (ISO 9117-3:2010)

**- touch dry**

1 h (ISO 9117-5:2012)

**Overcoatable**

surface temperature	by itself	
	min.	max.
+5 °C	3 h	-
+23 °C	1 h	-

Overcoating on mechanically damaged surfaces is recommended to be done within 8 h or after 2 d of painting.

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 9502 or TEKNOSOLV 1639.

**HEALTH AND SAFETY****Safety and precaution measures**

See safety data sheet.

NOTE! Because of the danger of spontaneous combustion, any waste from the product, spray mist and soiled rags etc. are to be kept in a fire-proof place in air-tight containers. Immersion in water is also recommended.

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

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