

TEKNOLAC PRIMER 0168-91 HB

High build alkyd primer

TEKNOLAC PRIMER 0168-91 is an air-drying alkyd-based primer with high solids content. It contains active anticorrosive pigments.

Use: Painting of steel constructions in indoor and outdoor use.

The paint dries quickly and has very good anticorrosive properties. The high solids content combined with good application properties makes it possible to achieve high film thicknesses in a single operation.



TECHNICAL DATA

Fields of application	Steel constructions									
Recommended substrate	Steel									
Binder	Alkyd									
Solids	abt. 50% by volume									
Total mass of solids	Approx. 940 g/l									
Volatile organic compound (VOC)	Approx. 470 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>40</td><td>80</td><td>12.5</td></tr><tr><td>80</td><td>160</td><td>6.2</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)	40	80	12.5	80	160	6.2
Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m ² /l)								
40	80	12.5								
80	160	6.2								
Practical spreading rate	The values depend on the application technique, surface conditions, overspray, etc.									
Colours	Grey (RAL 7032 / D205), red-brown.									
Gloss (60°)	Full-matt									
Thinner	TEKNOSOLV 9502, TEKNOSOLV 1639.									
Storage	The storage stability is shown on the label. Store in a cool place and in tightly closed containers.									

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.

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. 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 and KORRO SS Zinc Silicate Prefabrication primers can be used, when required.

Application method

Airless spraying

Application

Stir thoroughly before use.

Suitable airless nozzle size 0.013 - 0.021". Spray evenly to the specified film thickness. Special care should be taken when spraying edges, corners and welding joints. Small areas can also be painted with a brush, but in this case one additional coat has to be applied in order to achieve the specified film thickness.

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%.

Drying time	+23 °C / 50% RH		
- touch dry	40 µm: 20 min 80 µm: 40 min		
- forced drying	80 °C / 15 min		
Overcoatable	surface temperature	by itself, the TEKNOLAC series, the TEKNOSYNT series or the TEKNOLAC COMBI series	
		min.	max.
	+5 °C	6 h	-
	+23 °C	2 h	-

The values given for drying times and overcoatability may vary depending on film thickness and drying conditions.

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.

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