TEKNOPLAST PRIMER 7-01

Epoxy primer

TEKNOPLAST PRIMER 7-01 is a two-pack solvent-borne epoxy primer with low solvent content.

Used as a priming coat in abrasion and chemical resistant Epoxy Coating Systems. Can also be used for priming zinc, aluminium, thin-plate and acid-proof steel surfaces and as an intermediate coat over zinc epoxy and zinc silicate primers.

The paint is quickly overcoatable and is therefore suited to a fast painting tempo. It is also suitable for application by twin-feed spray. The paint film withstands heavy abrasion, oils, grease, solvents and chemical splashing.

When painting at temperatures below +10°C TEKNOPLAST WINTER HARDENER 7212 is to be used.

The paint comes up to the specifications of Swedish Standard SSG 1021 paint type GA.

TECHNICAL DATA

Certificates, approvals and classification	SSG 1021-GA
Fields of application	Steel constructions
Recommended substrate	Steel, Aluminium, Zinc
Binder	Epoxy
Solids	66 ±2% by volume (ISO 3233:1988)
Total mass of solids	Approx. 1100 g/l
Volatile organic compound (VOC)	Approx. 320 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><tr><th>Dry film (µm)</th><th>Wet film (µm)</th><th>Theoretical spreading rate (m^2/l)</th></tr><tr><td>80</td><td>121</td><td>8.2</td></tr><tr><td>120</td><td>181</td><td>5.5</td></tr></table> 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.
Practical spreading rate	The values depend on the application technique, surface conditions, overspray, etc.
Colours	Light grey, light yellow and RAL-5015
Gloss (60°)	Semi-matt

Hardener	Comp. B: TEKNOPLAST HARDENER
Mixing ratio (A:B)	4:1 parts by volume
Pot life, +23°C	3 h
Thinner	TEKNOSOLV 9506
Storage	The storage stability is shown on the label. Must be stored tightly closed and kept cool.

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. ZINC SURFACES: Hot-dip-galvanized steel structures that are exposed to atmospheric corrosion can be painted if the surfaces are sweep blast-cleaned (SaS) till matt all over. Suitable cleaning agents are, e.g. aluminium oxide and natural sand. It is not recommended according to standard ISO 12944-5 to paint hot-dip-galvanized objects that are subjected to immersion strain. Painting of hot-dip-galvanized objects that are subjected to immersion strain must be discussed separately with Teknos. It is recommended that new zinc-coated thin-plate structures are treated with sweep blast-cleaning (SaS). Thin-plate surfaces that have been weathered to matt can be treated also with RENSA STEEL washing agent for galvanized surfaces. ALUMINIUM SURFACES: Treat the surfaces with RENSA STEEL washing agent for galvanized surfaces. 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. 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 E Epoxy, KORRO SE Zinc Epoxy and KORRO SS Zinc Silicate Prefabrication Primers can be used, when required.
Application method	Airless spraying

Application

Take into consideration the pot life of the mixture when estimating the amount to be mixed at a time. Before application the base and hardener are mixed in right proportion. Stir thoroughly down to the bottom of the vessel. Inadequate stirring or incorrect mixing ratio results in imperfect curing and impaired film properties.

Stir thoroughly before use.

Apply preferably by airless spray as only this method provides the recommended film thickness in a single operation. Suitable airless nozzle size 0.013 - 0.019". Brush or roller can be used for touching up and painting small areas.

When twin-feed spray is used for application, the mixing ratio of the dosage pump must be 4:1. The feed pump pressure and the consumption of components is to be checked during application to ensure of the correct mixing ratio. The components cannot be thinned if twin-feed spray with fixed ratio is used.

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 +10°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.
When using TEKNOPLAST WINTER HARDENER 7212 the temperature of the ambient air and the surface to be painted shall be over -5°C. The temperature of the paint during the mixing and application is to be above +15°C.

Thinning

If needed, thin the paint with TEKNOSOLV 9506.

Drying time

+23°C / 50% RH (dry film 80 µm)

- dust free

1 h (ISO 9117-3:2010)

- touch dry

4 h (ISO 9117-5:2012)

Overcoatable

surface temperature	by itself		with TEKNOPLAST top coats		with TEKNODUR top coats or TEKNODUR AQUA top coats	
	min.	max. *	min.	max. *	min.	max. *
+10 °C	4 h	6 months	8 h	6 months	12 h	7 d
+23 °C	1 h	6 months	2 h	6 months	2 h	3 d

* 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.

Polyester putty is not recommended to be used on top of TEKNOPLAST Primer 7-01 epoxy paint.

Cleaning

TEKNOSOLV 9506 or TEKNOSOLV 9530.

HEALTH AND SAFETY

Safety and precaution measures See safety data sheet.

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