

TEKNOPOX PRIMER 9-00

Epoxy primer

Two-pack epoxy primer.

Used as an anticorrosive paint on blast-cleaned steel surfaces as well as on zinc coated and aluminium surfaces in objects where good resistance to abrasion, water, oil and chemicals is required.

Paint is fast drying, has good application properties and levelling is also good. Will cure even at +0 °C temperature.



TECHNICAL DATA

Recommended substrate	Aluminium, Steel, Zinc																				
Binder	Epoxy																				
Solids	62 ±2% by volume																				
Total mass of solids	Approx. 1030 g/l																				
Volatile organic compound (VOC)	Approx. 350 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 (m²/l)</th></tr><tr><td>60</td><td>97</td><td>10.3</td></tr><tr><td>80</td><td>129</td><td>7.8</td></tr><tr><td>100</td><td>161</td><td>6.2</td></tr><tr><td>120</td><td>193</td><td>5.2</td></tr><tr><td>150</td><td>242</td><td>3.9</td></tr></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 (m²/l)	60	97	10.3	80	129	7.8	100	161	6.2	120	193	5.2	150	242	3.9
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Practical spreading rate	The values depend on the application technique, surface conditions, overspray, etc.																				
Colours	White, light grey ~ RAL-7035, Buff ~ RAL-1014																				
Gloss (60°)	Semi-matt																				
Hardener	Comp. B: TEKNOPOX HARDENER 7219																				
Mixing ratio (A:B)	7:1 parts by volume																				
Pot life, +23°C	3 h																				
Thinner	TEKNOSOLV 9506																				
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.

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). Surfaces that have been weathered to matt can be treated also with RENSA STEEL washing agent.

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.

Prefabrication primer: KORRO E Epoxy Prefabrication Primer can be used, when required. It is recommended that before top coating the surface is cleaned to quality grade FeX05, X = prefabrication primer (SFS 8145).

Additional instructive information for surface preparation can be found in standards EN ISO 12944-4 and ISO 8501-2.

Application method

Application

Airless spraying

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 - 0.017"

Brush can be used for touching up and painting small areas.

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 paint shall be above 0 °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

If needed, thin the paint with TEKNOSOLV 9506.

Drying time

+23 °C / 50% RH (dry film 60 µm)

- dust free

10 min (ISO 9117-3:2010)

- touch dry

45 min (ISO 9117-5:2012)

Overcoatable

surface temp.	by itself and with TEKNOMASTIC COMBI 80-500		with TEKNODUR 0050, TEKNODUR COMBI 340-811 and TEKNODUR COMBI 3430 polyurethane paints		with TEKNODUR COMBI 3560-78		with TEKNODUR 100 9-12	
	min.	max. *	min.	max. *	min.	max.*	min.	max. *
+10 °C	1 h	2 months	1 h	1 month	1 h	2 months	1 h	14 d
+23 °C	45 min	2 months	45 min	1 month	45 min	2 months	45 min	14 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.

Cleaning

TEKNOSOLV 9506

HEALTH AND SAFETY

Safety and precaution measures

See safety data sheet.

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