TEKNOSYNT COMBI 50

Alkyd paint



TEKNOSYNT COMBI 50 is a thixotropic urethane/alkyd based paint pigmented with anticorrosive pigments.

Use: Either alone (in 1 or 2 coats) or as a topcoat in alkyd coating systems on steel in environments with moderate corrosivity. When painting with bright red or yellow colours on surfaces that will be subjected to specific rubbing by clothing (seating, banisters etc.), it is recommended to get in touch with Teknos's Technical Service.

Being quick-drying, TEKNOSYNT COMBI 50 is well suited for use in engineering and paint shops. The anticorrosive pigments of the paint do not contain lead or chromates.

TECHNICAL DATA

Recommended substrate	Steel
Binder	Alkyd
Solids	50 ±2% by volume
Total mass of solids	Approx. 750 g/l
Volatile organic compound (VOC)	Approx. 400 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>40</td><td>80</td><td>12.5</td></tr><tr><td>80</td><td>160</td><td>6.2</td></tr><tr><td>100</td><td>200</td><td>5.0</td></tr><tr><td></td><td></td><td>(1-layer painting)</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.
Tinting system	Teknomix
Gloss (60°)	Semi-matt
Thinner	TEKNOSOLV 9507 or TEKNOSOLV 1621.
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 2 (ISO 8501-1).

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

Application method

Airless spraying

Application

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 0.015 - 0.018".

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 (dry film 40 µm)

- dust free

1 h (ISO 9117-3:2010

- touch dry

3 h (ISO 9117-5:2012)

Overcoatable

surface temperature	by itself	
	min.	max.
+5 °C	18 h	-
+23 °C	6 h	-

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 9507 or TEKNOSOLV 1621.

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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