

**TEKNOPOX AQUA 0350**  
**Epoxy Paint**

<b>PAINT TYPE</b>	TEKNOPOX AQUA 0350 is a semigloss water-borne two-pack epoxy paint for metal surfaces.
<b>USAGE</b>	Used as a top coat in water-borne epoxy coating systems that will be exposed to weathering.
<b>SPECIAL PROPERTIES</b>	The paint is especially suited for use in engineering and paint shops.

**TECHNICAL DATA**

<b>Mixing ratio</b>	Base (Comp. A): Hardener (Comp B): TEKNOPOX AQUA HARDENER 0300 or Hardener (Comp B): TEKNOPOX AQUA HARDENER 0300-02	1 part by volume 1 part by volume
<b>Pot life, +23 °C</b>	with TEKNOPOX AQUA HARDENER 0300 1½ h, with TEKNOPOX AQUA HARDENER 0300-02 1 h	
<b>Solids</b>	0350-05:45 ±2 % by volume 0350-09: 43 ±2% by volume	
<b>Total mass of solids</b>	0350-05: abt. 650 g/l 0350-09: abt. 610 g/l	
<b>Volatile organic compound (VOC)</b>	abt. 20 g/l	
<b>Recommended film thickness and theoretical spreading rate</b>	Dry film (µm)	Wet film (µm)
		Theoretical spreading rate (m <sup>2</sup> /l)
	0350-05: 40	88
	0350-05: 60	133
	0350-09: 40	93
	0350-09: 60	139
		11,4
		7,5
		10,8
		7,2

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.

<b>Drying time, +23°C / 50% RH (dry film 60 µm)</b>	
- dust free (ISO 9117-3:2010)	with TEKNOPOX AQUA HARDENER 0300 1 h, with TEKNOPOX AQUA HARDENER 0300-02 40 min
- touch dry (DIN 53150:1995)	with TEKNOPOX AQUA HARDENER 0300 10 h, with TEKNOPOX AQUA HARDENER 0300-02 5 h

**Overcoatable, 50% RH (dry film 60 µm)**

surface temperature	by itself, with INERTA 50, TEKNOPLAST HS 150, TEKNOPLAST 50 or with TEKNODUR-series top coats	
	min.	max.*
<b>+15°C</b>	after 24 h	after 1 month
<b>+23°C</b>	after 4 h	after 1 month

\* 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.

<b>Thinner, clean up</b>	Water
<b>Finish</b>	TEKNOPOX AQUA 0350-05: semigloss TEKNOPOX AQUA 0350-09: gloss
<b>Colours</b>	The paint is included in the Teknomix tinting system.
<b>SAFETY MARKINGS</b>	See Safety Data Sheet.

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**DIRECTION FOR USE****Surface preparation**

Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods. The surfaces are prepared according to the different materials as follows:

**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. 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.

**Mixing of the components**

Take into consideration the pot life of the mixture when estimating the amount to be mixed at a time. Before painting 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.

THE READY MIXTURE MUST BE USED WITHIN THE POT LIFE, MIXTURES OLDER THAN THIS ARE UNFIT FOR USE.

**Application conditions**

The surface to be painted must be dry. During the application and drying period the temperature of the ambient air, the surface and the paint shall be above +15°C and the relative air humidity below 70%.

Additionally the temperature of the surface to be painted and the paint must be at least 3°C above the dew point of the ambient air.

Especially when applying with a spray the relative air humidity should be above 30% to avoid the onset of the drying process to be too fast.

**Application**

Before use stir the paint thoroughly.

Apply preferably by airless spray (nozzle size 0.011 - 0.015"), air-assisted low-pressure spray or conventional spray. The paint is sprayed in an even coat to the required 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 required film thickness.

**ADDITIONAL INFORMATION**

The storage stability is shown on the label. Store in a cool place and in tightly closed containers.

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

MUST NOT FREEZE.

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The information of this data sheet is normative and based on laboratory tests and practical experience. Teknos guarantees that the product quality conforms to our quality system. Teknos accepts, however, no liability for the actual application work, as this is to a great extent dependent on the conditions during handling and application. Teknos accepts no liability for any damage resulting from misapplication of the product. This product is intended for professional use only. This implies that the user possesses sufficient knowledge for using the product correctly with regard to technical and working safety aspects. The latest versions of Teknos data sheets, material safety data sheets and system sheets are on our home pages [www.teknos.com](http://www.teknos.com).

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