

**TEKNODUR COMBI 0550**
Polyurethane Paint

PAINT TYPE	TEKNODUR COMBI 0550 is a two pack polyurethane paint with anticorrosive pigmentation. The hardener is TEKNODUR HARDENER 0500, which is an aliphatic isocyanate resin.
USAGE	Used as a protection of steel as one layer paint (Coating Systems K2) and as top coat on epoxy primers, such as TEKNOPLAST PRIMER 3 and 5, and INERTA PRIMER 5.
SPECIAL PROPERTIES	The paint produces a semigloss or gloss film with good mechanical and weather resistance. The product can be used as a top coat on TEKNOLAC PRIMER -type Alkyd Primers. Also suitable for painting aluminium surfaces.

TECHNICAL DATA

Mixing ratio	Base 9.5 volume parts, TEKNODUR HARDENER 0500 0.6 volume parts. There is also available a hardener TEKNODUR HARDENER 5100 that is specially developed for twin-feed spraying equipment and which is used in the mixing ratio: TEKNODUR COMBI 0550 base 10 volume parts, TEKNODUR HARDENER 5100 1 volume part.		
Pot life, +23 °C	6 h		
Solids	50 ±2% by volume (ISO 3233:1988)		
Total mass of solids	TEKNODUR COMBI 0550-03: abt. 670 g/l TEKNODUR COMBI 0550-05: abt. 670 g/l TEKNODUR COMBI 0550-09: abt. 570 g/l		
Volatile organic compound (VOC)	TEKNODUR COMBI 0550-03: abt. 440 g/l TEKNODUR COMBI 0550-05: abt. 440 g/l TEKNODUR COMBI 0550-09: abt. 500 g/l		
Recommended film thickness and theoretical spreading rate	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m ² /l)
	40	80	12,5
	80	160	6,2
	100	200	5,0

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.

Drying time at +23°C / 50% RH (dry film 40 µm)

- dust free (ISO 9117-3:2010) after 1 h
- touch dry (ISO 9117-5:2012) after 3 h

Overcoatable, 50% RH (dry film 40 µm)

surface temperature	by itself	
	min.	max.
+5°C	after 48 h	-
+23°C	after 24 h	-

Increase in film thickness and rise in the relative humidity of the air in the drying space usually slow down the drying process.

Thinner	TEKNOSOLV 1640 or TEKNOSOLV 9521
Clean up	TEKNOCLEAN 6496
Finish	TEKNODUR COMBI 0550-03: semi-matt TEKNODUR COMBI 0550-05: semigloss TEKNODUR COMBI 0550-09: gloss
Colours	By agreement. The paint is included in the Teknomix tinting system.

SAFETY MARKINGS See Safety Data Sheet.

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:

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.

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.

Application

Before use stir the paint thoroughly.

The paint is thinned when required 10 - 20% with TEKNOSOLV 1640 or TEKNOSOLV 9521.

Apply the paint with conventional spray or airless spray. Airless spray nozzle 0.011 - 0.017".

Application conditions

The surface to be painted has to be dry. During the application and drying period the temperature of the ambient air, the surface and the paint shall be above +5°C and the relative air humidity below 80%. 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.

ADDITIONAL INFORMATION

The storage stability is shown on the label. Store indoors in a cool and dry place and in a tightly closed can. The hardener reacts with air humidity and therefore the opened can is to be kept carefully closed, and it is recommended to be used within 14 d of opening.

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

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.



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