

TEKNOSYNT COMBI 1277

alkyd-based single coat paint

PAINT TYPE	TEKNOSYNT COMBI 1277 is an air-drying, alkyd-based single coat paint. Contains active anticorrosive pigments.
USAGE	Intended for single coat painting, but can also be used as top coat in systems including a primer, e.g. TEKNOLAC PRIMER 0168. Used for painting on steel when efficient anticorrosive protection combined with attractive finish is desired.
SPECIAL PROPERTIES	The paint has good weathering properties, short drying time and high abrasion resistance. Can be applied in film thickness up to 100 µm dry film without any risk of runnings.

TECHNICAL DATA

Solids	abt. 50 % by volume		
Total mass of solids	abt. 780 g/l		
Volatile organic compound (VOC)	abt. 400 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, relative humidity 50%	
- touch dry, +23 °C	40 µm: efter 4 h 80 µm: efter 4,5 h
- forced drying	60-80°C / 30 min

- overcoatable

by itself	
+5°C	+23°C
min: before 6 h or only after at least 2 d	min: before 4 h or only after at least 24 h
max. -	max. -

The values given for drying times and overcoatability may vary depending on film thickness and drying conditions.

Thinner, clean up	TEKNOSOLV 1621
Finish	Gloss
Colours	The paint is included in the Teknomix tinting system. Standard colours by agreement.

SAFETY MARKINGS

See Material Safety Data Sheet.

NOTE! Because of the danger of self-ignition, any waste from the product, spray mist and soiled rags etc. are to be kept in a fire-proof place in air-tight containers, alternatively the waste is to be burned. Immersion in water is also recommended. (See Material Safety Data Sheet, paragraph 7.1.)

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.

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 PVB Prefabrication Primer and KORRO E Epoxy Prefabrication Primer can be used, when required.

Application

Before use stir the paint thoroughly.

Apply preferably by airless spray or airless spray equipped with air-assisted pistol (nozzle 0.013 - 0.018"). The paint is sprayed evenly to the specified 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 specified film thickness.

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%.

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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