

TEKNORAN COMBI 1485

single coat paint based on oxirane ester

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| PAINT TYPE | TEKNORAN COMBI 1485 is a 2-pack, isocyanate-free single coat paint with high solids content and based on oxirane ester. Contains active anticorrosive pigments. | | |
| USAGE | Product coating on steel surfaces within the engineering industry. The solvent emissions of the paint are low due to the high volume solids content. The paint dries both in elevated and in room temperatures. Welding of the painted surface is to be avoided. | | |
| TECHNICAL DATA | | | |
| Mixing ratio | Base (Comp. A): Hardener (Comp. B): TEKNORAN HARDENER 1475 / 1475-51 | 2 parts by volume 1 part by volume | |
| Pot life, +23 °C | 4 h | | |
| Solids | 68 ±2% by volume | | |
| Total mass of solids | abt. 1300 g/l | | |
| Volatile organic compound (VOC) | abt. 280 g/l | | |
| Recommended film thickness and theoretical spreading rate | Dry film (µm) | Wet film (µm) | Theoretical spreading rate (m ² /l) |
| | 80 | 117 | 8,5 |
| | 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, +23°C / 50% RH (dry film 80 µm) | | | |
| - dust free (ISO 9117-3:2010) | after 1 h | | |
| - touch dry (DIN 53150:1995) | after 4 h | | |
| - forced drying | 80°C / 30 min | | |
| Overcoatable, 50% RH (dry film 80 µm) | | | |
| | by itself | | |
| surface temperature | min. | max. | |
| +10°C | after 24 h | - | |
| +23°C | after 2 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, clean up | Standard thinners: TEKNOSOLV 9511 and TEKNOSOLV 6622. Other thinners suitable for the product: see page 2. | | |
| Finish | TEKNORAN HARDENER 1475: gloss TEKNORAN HARDENER 1475-51: semigloss | | |
| Colours | TEKNORAN COMBI 1485 is delivered in desired colours. | | |
| 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. When using chemical pretreatment the suitability of the treatment is to be checked from the paint manufacturer.

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 for galvanized surfaces.

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.

Prefabrication primer

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

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

Apply preferably by airless spray as only this method provides the recommended film thickness in a single operation. Use airless spray nozzle 0.011 - 0.013". Brush can be used for touching up and painting small areas.

Standard thinners: TEKNOSOLV 9511 and TEKNOSOLV 6622.

Slow thinner: TEKNOSOLV 1640. Used e.g. when painting large surfaces and when the temperature is above room temperature.

Fast thinner for electrostatic spraying: TEKNOSOLV 1639.

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%.

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.

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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