

**TEKNOLAC COMBI 50**
alkyd paint

PAINT TYPE	TEKNOLAC COMBI 50 is a quick-drying, anticorrosive pigmented, semigloss alkyd paint.
USAGE	Intended for use on interior and exterior surfaces in Alkyd Coating Systems K10. Can also be used in mild environmental stress classes as a single coat on steel and aluminium surfaces.
SPECIAL PROPERTIES	The paint is very quick-drying and is therefore suitable for use in engineering and paint shops.

TECHNICAL DATA

Solids 45 ±2% by volume (ISO 3233:1988)

Total mass of solids abt. 610 g/l

Volatile organic compound (VOC) abt. 520 g/l

Recommended film thickness and theoretical spreading rate	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m ² /l)
	40	88	11,2
80	177	5,6	
100	222	4,5	

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 at +23°C / 50% RH (dry film 40 µm)

- dust free (ISO 9117-3:2010) after 15 min

- touch dry (ISO 9117-5:2012) after 1 h

Overcoatable, 50% RH (dry film 40 µm)

surface temperature	by itself	
	min.	max.
+5°C	after 3 h	-
+23°C	after 1 h	-

Overcoating on mechanically damaged surfaces is recommended to be done within 8 h or after 2 d of painting.

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 TEKNOSOLV 9502, TEKNOSOLV 1639

Finish Semigloss

Colours The paint is included in Teknotint and Teknomix tinting systems. Standard colours by agreement.

SAFETY MARKINGS See Safety Data Sheet.

PTO

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. Immersion in water is also recommended.

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.

Prefabrication primer

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

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.

Application

Before use stir the paint thoroughly.

For application by conventional spray the paint is thinned by about 10% with TEKNOSOLV 9502 or TEKNOSOLV 1639.

Apply by brush, conventional spray, airless spray or electrostatic spray. Use airless spray nozzle 0.013 - 0.015".

When painting with bright red or yellow colours on surfaces that will be subjected to specific rubbing by clothing (seats, banisters etc.), it is recommended to get in touch with Teknos's Technical Service.

ADDITIONAL INFORMATION

Must be stored tightly closed and kept cool and dry.

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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