

TEKNOPLAST PRIMER 2

Epoxy Primer

PAINT TYPE	TEKNOPLAST PRIMER 2 is a two-pack epoxy primer pigmented with aluminium.
USAGE	Used as primer for blast-cleaned surfaces on paper machines in abrasion and chemical resistant epoxy and polyurethane coating systems. Can also be used for priming zinc, aluminium, thin-plate and acid-proof steel surfaces and as an intermediate coat over zinc epoxy and zinc silicate primers.
SPECIAL PROPERTIES	The paint is quickly overcoatable and is therefore suited to a fast painting tempo. The paint can also be applied by twin-feed spray. The paint film withstands heavy abrasion, oils, grease, solvents and chemicals. The paint comes up to the specifications of Swedish Standard SSG 1021-GA.

TECHNICAL DATA

Mixing ratio	Base (Comp. A): Hardener (Comp B): TEKNOPLAST HARDENER	4 parts by volume 1 part by volume	
Pot life, +23 °C	4 h		
Solids	53 ±2% by volume		
Total mass of solids	abt. 880 g/l		
Volatile organic compound (VOC)	abt. 440 g/l		
Recommended film thickness and theoretical spreading rate	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m ² /l)
	50	94	10,6
	60	115	8,8
	80	150	6,6
	100	190	5,3

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 50 µm)

- dust free (ISO 9117-3:2010)	after 1 h
- touch dry (ISO 9117-5:2012)	after 3 h
- fully cured	after 7 days

Overcoatable, 50% RH (dry film 50 µm)

surface temperature	by itself, INERTA MASTIC, TEKNOPLAST 50 or INERTA 50		by top coats of the TEKNODUR series	
	min.	max.*	min.	max.*
+10°C	after 6 h	after 6 months	after 12 h	after 7 days
+23°C	after 2 h	after 6 months	after 4 h	after 3 days

* 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.

Thinner	TEKNOSOLV 9506
Clean up	TEKNOSOLV 9506 or TEKNOPLAST 9530
Finish	Semi-matt
Colours	Red, yellow and grey
SAFETY MARKINGS	See Safety Data Sheet.

PTO

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.

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 E Epoxy, KORRO SE Zinc Epoxy and KORRO SS Zinc Silicate Prefabrication Primers 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 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 +10°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.

If needed, thin the paint with TEKNOSOLV 9506.

Apply preferably by airless spray as only this method provides the recommended film thickness in a single operation. Use airless spray nozzle 0.013 - 0.019". Brush can be used for touching up and painting small areas.

When twin-feed spray is used for application, the ratio of the dosage pump must be 4:1. The feed pump pressure and the consumption of components is to be checked during application to ensure the correct mixing ratio. The components cannot be thinned if twin-feed spray is used.

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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