

TEKNOZINC 3480 SE

Zinc Rich Epoxy Paint

PAINT TYPE	TEKNOZINC 3480 SE is a two-pack solvent-borne zinc rich epoxy paint with a high solids content.
USAGE	TEKNOZINC 3480 SE is used as a primer in polyurethane and epoxy painting systems.
SPECIAL PROPERTIES	Protects efficiently from underfilm corrosion and resists weathering even without any top coat. The paint comes up to the specifications of standard EN-ISO 12944-5. The zinc content of the paint is at least 80% by weight in the dry paint film.

TECHNICAL DATA

Mixing ratio	Base (Comp. A): Hardener (Comp. B): TEKNOZINC HARDENER 7511	5 parts by volume 1 part by volume
Pot life, +23 °C	3 h	
Solids	66 ±2% by volume (ISO 3233:1988)	
Total mass of solids	abt. 2400 g/l	
Volatile organic compound (VOC)	abt. 300 g/l	
Recommended film thickness and theoretical spreading rate	Dry film (µm)	Wet film (µm)
	80	121
		Theoretical spreading rate (m ² /l)
		8,2

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 10 min
 - touch dry (ISO 9117-5:2012) after 15 min
 - fully cured after 7 d

Overcoatable, 50% RH (dry film 80 µm)

	by itself, with TEKNOPOX AQUA PRIMER 3, TEKNOPLAST HS 150, TEKNOPLAST PRIMER 3, TEKNOPLAST PRIMER 5, TEKNOPLAST PRIMER 7 or with INERTA 51 MIOX	
surface temperature	min.	max.*
+10°C	after 6 h	after 2 months
+23°C	after 2 h	after 2 months

* 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, clean up	TEKNOSOLV 9506
Finish	Matt
Colours	Bluish grey
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 (ISO 8501-1).

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 SE Zinc Epoxy Prefabrication Primer and KORRO SS Zinc Silicate 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 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

Stir the paint frequently in the course of work, about every half an hour, in order to prevent sedimentation of the zinc dust.

Apply by brush or airless spray. Use airless spray nozzle 0.018 - 0.021" (turn-nozzle).

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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