

TYPE	2-component epoxy primer.
USE	Primer for epoxy polyurethane systems.
SPECIAL PROPERTIES	Provides good adhesion to steel, aluminium and zinc-coated surfaces. Good resistance against mechanical damage, solvents, chemicals and oils. The thixotropic nature of the product provides good security against sags if applied to high film builds. The paint contains zinc phosphate.

TECHNICAL DATA

Hardener	For this type use INERTA HARDENER 7200.														
Mixing ratio	4 parts by volume of base for 1 part by volume of hardener. 7 parts by weight of base for 1 part by weight of hardener.														
Pot life, +23 °C	Approx. 8 hours														
Solids	Approx. 70 weight-% Approx. 48 volume-%														
Density	1.4 g/cm ³														
Volatile organic compound (VOC)	See safety data sheet														
Recommended film thickness and theoretical spreading rate	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m ² /kg) (m ² /l)												
	80	170	4.7 6.3												
	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 at +23 °C / 50 % RH (80 µm dry)															
- surface dry (ISO 1517:1973)	Approx. 1 hour														
- touch dry (DIN 53150:1995))	Approx. 3 hours														
- overcoatable	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th colspan="3">By itself</th> </tr> <tr> <th></th> <th>+10 °C</th> <th>+23 °C</th> </tr> </thead> <tbody> <tr> <td>min.</td> <td>12 hours</td> <td>4 hours</td> </tr> <tr> <td>max.</td> <td>6 months</td> <td>6 months</td> </tr> </tbody> </table>			By itself				+10 °C	+23 °C	min.	12 hours	4 hours	max.	6 months	6 months
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	The stated drying times are indicative, as the product dries differently depending on film thickness and drying conditions.														
Cleaning	TEKNOSOLV 9506-00 or TEKNOSOLV 6720.														
Gloss	Matt.														
Colour range	Grey and RAL 7032. Further colours per agreement.														
Storage	See page 2.														

HEALTH AND SAFETY See Safety Data Sheet.

INSTRUCTION FOR USE

Surface preparation 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 to paint galvanized objects that are subjected to immersion strain. It is recommended that new zinc-coated thin-plate structures are treated with sweep blast-cleaning (SaS).

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 surface must be clean and dry. Old, painted surfaces that have exceeded the maximum overcoating time are to be roughened as well.

Mixing of the components Take into consideration the pot life of the mixture when estimating the amount to be mixed at a time. The base and hardener are mixed together and stirred thoroughly before application 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. When coating and curing the temperature of the air, paint and surface must 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.

Spraying conditions Conventional-, high-pressure-, and airless spraying. Brush.

<u>Equipment</u>	<u>Thinner</u>	<u>Suggested viscosity</u> <u>DIN-cup 4 mm 20 °C</u>
Air spraying	TEKNOSOLV 9506-00 or TEKNOSOLV 6720-00	20-40 s
Airless (Nozzle: 0.013-0.018")	TEKNOSOLV 9506-00 or TEKNOSOLV 6720	Undiluted or up to approx. 5 % thinner.

ADDITIONAL INFORMATION The storage stability is shown on the label.
Store in a tightly closed container.

Additional instructive information for surface preparation can be found in standards EN ISO 12944-4 and ISO 8501-2.

The above information is normative and based on laboratory tests and practical experiences. The information is noncommittal, and we cannot accept liability for the results obtained under working conditions beyond our control, and consequently the buyer or the user is not released from the obligation to test the suitability of our products for specific means and application methods under the actual application conditions. Our liability covers only damage caused directly by defects in the products supplied by Teknos. The latest versions of Teknos' Technical Data Sheets and Safety Data Sheets are available from our homepage www.teknos.com.