

	www.teknos.com		
PRODUCT NAME 02 17.05.2017	TEKNOSILOX STRUCTURE 3352 Two component Ultra High Solid Polysiloxane Topcoat		
PRODUCT DESCRIPTION	TEKNOSILOX STRUCTURE 3352 is a low-solvent Polysiloxane coating		
INTENDED USE	TEKNOSILOX STRUCTURE 3352 is mainly used as a topcoat for primed steel constructions, tanks and bridges, where a long durability time of the coating system is required.		
SPECIAL CHARACTERISTICS OF THE COATING	Excellent weather-fastness, structured/textured surface easy achievable by using common applications techniques Results in a surface which is resistant against acids, chemical spills and splashes, humidity and moisture. Outstanding corrosion resistance, high abrasion resistance.		
TECHNICAL DATA			
Mixing ratio	Base (component A): Hardener (component B): TEKNOSILOX HARDENER 7471	5 by vol. 1 by vol.	7 by weight 1 by weight
Potlife at 23°C	4 h		
Solid content	97 ± 2 by weight.-% 95 ± 2 by volume.-%		
Density (ready-made system)	1,3 g/m ³		
Volatile organic compound (VOC)	approx. 40 g/l (during the curing reaction, small amounts of alcohol are produced)		
Recommended film thickness and theoretical spreading rate	dry film (µm)	wet film (µm)	Theoretical spreading rate (m ² /kg)
	80	90	9,2
	120	135	6,1
	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 application technique, surface conditions, overspray, etc.		
Drying time, +23°C / 50 % RH (dry film thickness 80 µm)			
- dust dry (ISO 1517:1973)	approx. 2 h		
- touch dry (DIN 53150:1995)	approx. 4 h		
- through dry (ISO 9117:1990)	24 h (forced drying possible after 2 h RT; 60°C 1 h)		
Overcoatable, 50 % RH (dry film thickness 80 µm)			
	with itself		
	Surface temperature	min.	max.
	+ 5°C	12 h	-
	+ 23°C	4 h	-
	The given values of drying time and overcoatability can change due to film thickness and drying conditions.		
Diluent / thinner	TEKNOSOLV 6750		
Cleaning of equipment	TEKNOSOLV 6750		
Gloss	glossy		
Colorshades	on enquiry		
SAFETY MARKINGS	See Material safety data sheet		

DIRECTION FOR USE	
Surface preparation	<p>Remove from the surface any contaminants that might be detrimental to surface preparation and coating. Remove also water-soluble salts by using appropriate methods. The surface should be prepared as follows:</p> <p>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.</p> <p>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.</p> <p>It is recommended that new zinc-coated thin-plate structures are treated with sweep blast-cleaning (SaS).</p> <p>OLD PAINTED SURFACES SUITABLE FOR OVERCOATING: Any impurities that might be detrimental to the application of paint (e.g. grease and salts) are to be removed. The surface 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.</p>
Suitable Primers	TEKNOZINC 90 SE, 90 SS, 3233,3231, INERTA-Series. To make the right choice, please contact our technical department.
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 must be at least above +5°C and below +45°C. The relative humidity may not exceed 90%. The temperature of the surface and the paint must be at least 3°C above the dew point of the ambient air.
Application	<p>Before use stir the paint thoroughly.</p> <p>According to the required structure effect, the paint can either be applied by conventional spray (spray gun nozzle 1,8 - 2,5 mm), using pressure feeding container or by Airless / Aircoat (0,011 to 0,015 inch nozzle).</p> <p>If requested, the paint can be diluted with maximum 5%.</p>
ADDITIONAL INFORMATION	<p>The storage stability is shown on the label. The hardener reacts with air humidity. Store in a cool place and in a tightly closed can.</p> <p>You can find instructions about the surface preparation in the norms EN ISO 12944-4 and ISO 8501-2.</p>

The information on 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 version of Teknos data sheets, material safety data sheets and system sheets are on our homepage www.teknos.com.