

**TEKNODUR PRIMER 3411**
Polyurethane Primer

PAINT TYPE	TEKNODUR PRIMER 3411 is a low solvent content two-pack polyurethane primer, cured with aliphatic isocyanate resin.
USAGE	TEKNODUR PRIMER 3411 is a high quality, multipurpose primer for steel, zinc and aluminium surfaces.
SPECIAL PROPERTIES	TEKNODUR PRIMER 3411 has a high mass of solid content. It forms a dense and even paint film. It is suitable to use as a primer even for demanding top coating.

TECHNICAL DATA

Mixing ratio	Base (Comp. A): Hardener (Comp B): TEKNODUR HARDENER 7231	8 parts by volume 1 part by volume
Pot life, +23 °C	1½ h	
Solids	56 ±2% by volume	
Total mass of solids	abt. 1095 g/l	
Volatile organic compound (VOC)	abt. 400 g/l	
Recommended film thickness and theoretical spreading rate	Dry film (µm)	Wet film (µm) Theoretical spreading rate (m ² /l)
	60	107 9,3
	100	178 5,6

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 60 µm)
- dust free (ISO 9117-3:2010) after 20 min
- touch dry (ISO 9117-5:2012) after 4 h
- forced drying 60°C / 1 h

Overcoatable, 50% RH (dry film 60 µm)

surface temperature	by it self or with TEKNODUR- or TEKNODUR COMBI-series Top Coats	
	min.	max.
+5°C	after 20 h	-
+23°C	after 4 h	-

Increase in film thickness and rise in the relative humidity of the air in the drying space usually slow down the drying process.

Thinner	Standard thinners: TEKNOSOLV 9521 and TEKNOSOLV 9526 (non-aromatic).
Clean up	TEKNOCLEAN 6496
Finish	Semi-matt
Colours	By agreement.
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 (standard ISO 8501-1). Roughening the surface of thin-plate improves the adhesion of the paint to the substrate.

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.

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.

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.

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 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 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.

When the paint is used as a primer surfacer it is diluted (for conventional spraying) by 10 - 20% with TEKNOSOLV 9521 or TEKNOSOLV 9526. Depending on the film thickness wanted the paint is sprayed in 1 - 2 coats. The dry film thickness will then be 40 - 100 µm. When the paint has dried it can be sanded (dry sanding P280/P320, wet sanding P600/P800).

Apply the paint by conventional or airless spray (nozzle 0.013 - 0.018") or by brush.

The hardener of the paint and the ready paint mixture contain isocyanates. In poorly ventilated areas and especially when using spray application we recommend the use of a fresh air mask. In short or temporary work a mask with combined filter A2-P2 can be used. In this case eyes and face are to be protected.

The hardener can must be opened with caution, as pressure may develop in the can during storage.

ADDITIONAL INFORMATION

The storage stability is shown on the label. Store in a cool place and in tightly closed containers.

The hardener reacts with air humidity. Store indoors in a cool and dry place in a tightly closed can. The storage stability is limited.

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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