

TEKNODUR COMBI 3560-93

01 Dark Grey B D028; 01 Black B S037

High-solid Polyaspartic based Polyurethane Paint

PAINT TYPE	TEKNODUR COMBI 3560-93 is a two pack high-solid polyaspartic based polyurethane paint where the hardener used is an aliphatic isocyanate resin.
USAGE	Used in weather resistant polyurethane system. As an anticorrosive pigmented the paint is suitable to use as one-layer paint on metal surfaces.
SPECIAL PROPERTIES	The paint produces a film with good mechanical and weather resistance. Because the paint is fast curing it is suitable for use in two pack line painting where the demand for productivity is high.

TECHNICAL DATA

Mixing ratio	Base (Comp. A): Hardener (Comp B): TEKNODUR HARDENER 7227	3 parts by volume 1 part by volume
Pot life, +23 °C	60 min	
Solids	70 ±2% by volume	
Total mass of solids	abt. 1160 g/l	
Volatile organic compound (VOC)	abt. 280 g/l	
Recommended film thickness and theoretical spreading rate	Dry film (µm)	Wet film (µm)
	120	171
		Theoretical spreading rate (m ² /l)
		5,8

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 120 µm)

- dust free (ISO 9117-3:2010)	after 1.5 h
- touch dry (ISO 9117-5:2012)	after 4.5 h
- through-dry (ISO 9117-1:2009)	after 7 h

Overcoatable, 50% RH (dry film 120 µm)

surface temperature	by itself	
	min.	max.*
+5°C	after 8 h	after 24 h
+23°C	after 1 h	after 8 h

* Maximum overcoating interval without roughening.

Thinner	Standard thinner: TEKNOSOLV 9526
Clean up	TEKNOCLEAN 6496
Finish	Semigloss
Colours	Atlas Copco 01 Dark Grey B D028, Atlas Copco 01 Black B S037
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). The profile of the blast-cleaned surface should be coarse (reference comparator "G") ISO 8503-2 (G). The surface of thin-plate can be prepared e.g. by phosphating.

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 or cleaned using alcohol (isopropanol) or emulsifying wash. Damaged parts are prepared in accordance with the requirements of the substrate and the maintenance coating.

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.

ALUMINIUM SURFACES: Treat the surfaces with an alkaline cleaning agent (RENSA STEEL). Surfaces that are exposed to weathering are also roughened up with sweep blast-cleaning (AlSaS) or sanding.

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.

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 must be stirred until it is homogeneous before mixing the components. 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

Suitable primers are TEKNOPLAST PRIMER 5, TEKNODUR PRIMER 3411, TEKNOCRYL AQUA PRIMER 2788 or TEKNOCRYL AQUA COMBI 2780.

Before use stir the paint thoroughly.

When needed thin the paint 0 - 5 % with TEKNOSOLV 9526, TEKNOSOLV 9521 or with fast thinner TEKNOSOLV 1129.

Do not use universal diluents or thinners, since they may contain alcohol which will react with the hardener.

Apply by conventional spray or airless spray. Use airless spray nozzle size 0.013 - 0.017".

Before use clean the spray gun and paint vessels with the paint's own thinner.

It is recommended for the application to use 2-pack spraying equipment.

Application conditions

The surface to be painted must be dry and the relative air humidity below 80%. During the application and drying period the temperature of the ambient air and the surface shall be at least above -5°C, and the temperature of the paint above +15°C during mixing and spraying. The temperature of the surface and paint must be at least 3°C above the dew point of the ambient air.

To remove solvents from the paint film and to ensure enough moisture to be available for efficient curing of the paint film, adequate air flow over the painted surface is required during spraying and initial curing of the paint.

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.

ADDITIONAL INFORMATION

Curing of the paint film is induced and accelerated by moisture. To ensure efficient curing of the paint film, good air flow over the painted surface is recommended during spraying and initial drying.

Oven curing of painted objects is not recommended. Recommended temperature range for spraying and drying is 18-28°C.

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

Use opened hardener within two weeks.

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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