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<b>PRODUCT NAME</b> 04      27.04.2022	<b>TEKNODUR COMBI STRUCTURE 3614</b> <b>2C-Polyurethane Topcoat and Single Layer</b>		
<b>PRODUCT DESCRIPTION</b>	TEKNODUR COMBI STRUCTURE 3614 is a two-pack high solid polyurethane top-or single coat. The hardener is an aliphatic isocyanate resin.		
<b>INTENDED USE</b>	Topcoat or single layer coating (with an appropriate pre-treatment of the steel surface).		
<b>SPECIAL CHARACTERISTICS OF THE COATING</b>	Low solvent content. Good drying properties. Good adhesion to sandblasted steel as well as cold rolled steel. When used as a single layer coating, this material builds up an effective corrosion protection, because it contains anti-corrosive pigments. The structure can be achieved without any problems with standard application procedures.		
<b>TECHNICAL DATA</b>			
<b>Mixing ratio</b>	TEKNODUR COMBI STRUCTURE 3614 (Comp. A): TEKNODUR HARDENER 7235 (Comp. B): or TEKNODUR HARDENER 7255 (Comp. B):	12 by weight 1 by weight	8 by vol. 1 by vol.
<b>Potlife at 20°C</b>	8 h		
<b>Solid content</b>	75 ± 2 by weight.-% 59 ± 2 by volume.-%		
<b>Density (ready-made system)</b>	1.49 ± 0.05 g/cm <sup>3</sup>		
<b>Volatile organic compound (VOC)</b>	approx. 358 - 359 g/l		
<b>Recommended film thickness and theoretical spreading rate</b>	dry film (µm)	wet film (µm)	Theoretical spreading rate (m <sup>2</sup> /kg)
	60	100	6.6
	80	135	4.9
	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.		
<b>Practical spreading rate</b>	The values depend on application technique, surface conditions, overspray, etc.		
<b>Drying time, +23°C / 50 % RH (dry film thickness 60 µm)</b>			
- dust dry (ISO 1517:1973)	approx. 60 min		
- touch dry (DIN 53150:1995)	approx. 3 h		
<b>Overcoatable, 50 % RH (dry film thickness 60 µm)</b>			
	with itself		
	Surface temperature	min.	max.
	+23°C	after 2 h	-
	The given values of drying time and overcoatability can change due to film thickness and drying conditions.		
<b>Diluent / thinner and cleaning of equipment</b>	TEKNOSOLV 6740		
<b>Gloss</b>	silk-gloss		
<b>Colorshades</b>	RAL 1032 and RAL 7016		
<b>SAFETY MARKINGS</b>	See Material safety data sheet		

<b>DIRECTION FOR USE</b>	
<b>Surface preparation</b>	<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><b>STEEL SURFACES:</b> 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><b>ZINC SURFACES:</b> Hot-dip-galvanized steel structures that are exposed to atmospheric corrosion can be painted if the surfaces are sweep blasted (SaS) till matt all over. Suitable blasting 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). Surfaces that have been weathered to matt can be treated also with PELTIPESU Cleaning Agent.</p> <p><b>OLD PAINTED SURFACES SUITABLE FOR OVERCOATING:</b> 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 over coating time are to be roughened as well.</p> <p>The place and the time of the preparation are to be chosen so that the prepared surface will not get dirty or damp before subsequent treatment.</p>
<b>Mixing of the components</b>	<p>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.</p>
<b>Application conditions</b>	<p>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 must be at least 3°C above the dew point of the ambient air.</p>
<b>Application</b>	<p>Before use stir the paint thoroughly.</p> <p>Apply the paint with brush, conventional spray or airless spray. Airless spray nozzle 0.013- 0.017.</p> <p>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 both eyes and face are to be protected.</p> <p>The hardener can must be opened with caution, as pressure may develop in the can during storage.</p> <p>Before use clean the spray gun and paint vessels with the paint's own thinner.</p>
<b>ADDITIONAL INFORMATION</b>	<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. It is recommended to use it in the space of 14 days. 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 regarding 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](http://www.teknos.com).