

**TEKNOLAC EFFECT 164**
air-drying hammer varnish

PAINT TYPE	TEKNOLAC EFFECT 164 is an air-drying alkyd paint of hammer finish type.
USAGE	The paint is used as top coat on steel surfaces. Can be used as ad single coat paint on steel surfaces indoors. On surfaces to be places outdoors or when better protection against corrosion is required, TEKNOLAC PRIMER 0168 can be used as primer.
SPECIAL PROPERTIES	he hammer finish pattern of the paint hides the irregularities of the surface and gives the surface, e.g. machine parts an elegant finish.

TECHNICAL DATA

Solids	38 ±2% by volume		
Total mass of solids	abt. 460 g/l		
Volatile organic compound (VOC)	abt. 540 g/l		
Recommended film thickness and theoretical spreading rate	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m ² /l)
	40	105	9,5

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 (dry film 40 µm)

- dust free after 15 min
- touch dry (ISO 9117-5:2012) after 30 min

Overcoatable, 50% RH (dry film 40 µm)

surface temperature	by itself	
	min.	max.
+5°C	after 6 h at the latest or only after at least 2 weeks	-
+23°C	after 4 h at the latest or only after at least 7 d	-

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

Thinner, clean up	TEKNOSOLV 9514 or TEKNOSOLV 1614
Finish	Gloss
Colours	Certain colours are delivered from stock. Can be adjusted individually for customers by agreement.
SAFETY MARKINGS	See Safety Data Sheet.

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NOTE! Because of the danger of self-ignition, any waste from the product, spray mist and soiled rags etc. are to be kept in a fire-proof place in air-tight containers. Immersion in water is also recommended.

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.

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.

Application

Before use stir the paint thoroughly.

The paint is applied by conventional spray (with or without pressure chamber). For application by conventional spray the paint is diluted by about 10% with TEKNOSOLV 9514 or TEKNOSOLV 1614.

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.

ADDITIONAL INFORMATION

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

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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