

**TEKNOCRYL AQUA 390**  
**Acrylate Top Coat****PAINT TYPE** TEKNOCRYL AQUA 390 is a quick-drying, gloss top coat based on acrylate dispersion.**USAGE** Used as a top coat for structural steel that will be exposed to atmospheric corrosion in epoxy acrylate systems K41 and acrylate systems K42.**TECHNICAL DATA****Solids** 40 ±2% by volume**Total mass of solids** abt. 460 g/l**Volatile organic compound (VOC)** abt. 55 g/l

<b>Recommended film thickness and theoretical spreading rate</b>	Dry film (µm)		Wet film (µm)	Theoretical spreading rate (m <sup>2</sup> /l)
	40	60	100	150
				10,0
				6,7

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 (ISO 9117-3:2010) after 30 min

- touch dry (ISO 9117-5:2012) after 40 min

**Overcoatable, 50% RH (dry film 40 µm)**

surface temperature	by itself	
	min.	max.
<b>+15°C</b>	after 8 h	-
<b>+23°C</b>	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, clean up** Water**Finish** Gloss**Colours** By agreement.  
The paint is included in the Teknomix tinting system.

---

**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:

**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 conditions and drying**

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 shall be above +15°C and the relative air humidity below 70%. 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.

Especially when applying with a spray the relative air humidity should be above 30% to avoid the onset of the drying process to be too fast.

Surface temperature, film thickness, drying temperature and ventilation affect the drying of the paint. The paint is dry when all water has evaporated from the paint film. It is essential that all painted surfaces have sufficient ventilation. If the painted surface will be exposed to weathering, moisture or low temperatures (below +10°C) thick paint films are to be avoided and the last coat must be allowed to dry for at least 24 hours (at +23°C) before exposure.

Low temperatures and insufficient ventilation slow down the drying process.

**Application**

Before use stir the paint thoroughly.

Apply by airless or conventional spray. Use airless spray nozzle 0.011 - 0.015". The paint is sprayed evenly to the required film thickness. Small areas can also be painted with brush.

**Cleaning of the equipment**

When painting equipment used for application of solvent-borne paints is used for water-borne paints the equipment must be cleaned carefully:

1. Wash with solvent.
2. Wash with washing solvent for water-borne paints, e.g. TEKNOSOLV 6060.
3. Rinse with water.

When shifting from water-borne to solvent-borne paints act in reverse order.

**ADDITIONAL INFORMATION**

The storage stability is shown on the label. Store in a cool place and in tightly closed containers. Do not transport or store the paint in temperatures below 0°C.

Additional instructive information for surface preparation can be found in standards EN ISO 12944-4 and ISO 8501-2.

MUST NOT FREEZE.

---

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](http://www.teknos.com).

---



EN\_817\_Tuoteseloste.pdf