

PAINT TYPE	TEKNOPOX PRIMER 87-00 MIOX is a MIO pigmented, thixotropic, high solid, epoxy primer, cured in temperatures above -10°C.
USAGE	The paint is used for priming of steel constructions operating in sea, coastal and industrial environment; for priming steel and cast iron constructions exposed to destructive mechanical factors.
SPECIAL PROPERTIES	The semi-matt, hard coating, with good adhesion to surfaces and resistant to mechanical factors. The coating resistant to atmospheric conditions. Exposed to direct sun radiation, the surface may chalk or change the shade.

TECHNICAL DATA

Mixing ratio	Base (Comp. A): Hardener (Comp. B): TEKNOPOX HARDENER 7377	100 parts by volume 23 parts by volume
Pot life; +23°C	1,5 h	
Solids	80±2% by volume	
Total mass of solids	abt. 1450 g/l	
Volatile organic compounds (VOC)	less than 250 g/l	
Recommended film thickness and theoretical spreading rate	Dry film (µm)	Wet film (µm) Theoretical spreading rate (m ² /l)
	100	125 8,0
	150	190 5,3

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 for 100 µm DFT	
- dust free	after 45 min
- touch dry	after 2 h
- fully cured	after 5 days

Overcoatable, 50% RH for 100 µm DFT

surface temperature	by itself		by polyurethane top coats form Emapur group or Teknodur 70 5-00 , Teknodur 0050**	
	min.	max.	min.	max.
-5°C	24 h	1 month*	24 h	1 month*
0°C	12 h	1 month*	12 h	1 month*
+5°C	7 h	1 month*	7 h	1 month*
+10°C	3 h	1 month*	3 h	1 month*
+23°C	2 h	1 month*	2 h	1 month*

*unlimited in internal conditions. A completely clean surface is mandatory to ensure the best intercoat adhesion. If the maximum overcoating interval has been exceeded, the surface must be roughened before overcoating. Increase in film thickness and rise in the relative humidity of the air in the drying space slow down the drying process and effect the overcoating properties.

**If some other top coats besides the ones mentioned above are used, please contact Teknos representative for overcoating recommendations.

Thinner	If needed (eg. thickening of product, application in lower temperature, application in lower dry film thickness) use TEKNOSOLV 9506 or TEKNOSOLV 564 up to 15%.
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Clean up	TEKNOSOLV 9506 or TEKNOSOLV 564
Finish	Semi-matt
Colours	250 – red oxide 820 – ash grey

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) for submerged areas or at least St 3 for external surfaces. For internal surfaces at least St 2 is recommended. Porous surfaces should be primed with thinned TEKNOPOX PRIMER 87-00 MIOX paint. Roughening the surface of thin-plate improves the adhesion of the paint to the substrate. Coating gets the highest mechanical and chemical resistance by applying directly to sandblast cleaned steel surfaces (cleanliness at least Sa 2 ½). Dry, salt-, grease- and dust-free surface.

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. Mixing by machine is recommended, for example a slow-rotating hand-drill equipped with a mixer. Inadequate stirring or incorrect mixing ratio results in imperfect curing and impaired film properties.

Application conditions

During the application and drying period the minimum temperature of the surface shall be above -5°C (frost- and ice-free surface), at least 3°C above the dew point of the ambient air. Minimum ambient air temperature -10°C. Maximum humidity 85%. Minimum paint temperature +15°C. Adequate ventilation during application and drying.

Application

Airless spray recommended (brush – only for small areas). For brush painting it is recommended to thin paint (abt. 3% of thinner) and to paint several times to achieve typical dry film thickness.

Airless spray application recommendation:

nozzle	0,019 - 0,023"
pressure	20 - 25 MPa

When preparing painting specification, depending on subject and type of construction, different dry film thickness than recommended can be assumed. During airless spray application typical dry film thickness range is between 70 and 300 µm. Different dry film thickness than recommended causes change in theoretical spreading rate, wet film thickness, weight of dry film thickness, drying time, overcoating time and ready for handling time.

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 version of Teknos data sheets, safety data sheets and system sheets are on our home pages www.teknos.com.