

TEKNOLAC AQUA COMBI 330

9-00

water-borne single coat paint

PAINT TYPE	TEKNOLAC AQUA COMBI 330 9-00 is a water-borne, acrylate modified alkyd-based single coat paint. Contains active anticorrosive pigments.
USAGE	Intended for single coat painting on blast-cleaned steel surfaces both in- and outdoors. When even better anticorrosive properties are needed, the paint can be used together with primer TEKNOLAC AQUA PRIMER 2964.
SPECIAL PROPERTIES	The paint has good gloss and colour retention and a very good adhesion to primed products. Can be applied as thick films without risk of runnings.

TECHNICAL DATA

Solids 39 ±2% by volume

Total mass of solids abt. 650 g/l

Volatile organic compound (VOC) abt. 43 g/l

Recommended film thickness and theoretical spreading rate	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m ² /l)
	80	205	4,9
	120	307	3,2

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 +20°C, the relative air humidity 60%

- dust free after 2 h
- dry to handle after 6 h
- fit for service after 24 h

Overcoatable, 50% RH (dry film 80 µm)

surface temperature	by itself	
	min.	max.
+5°C	after 8 h	-
+23°C	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 The paint is included in the Teknocolour tinting system.

SAFETY MARKINGS See Safety Data Sheet.

PTO

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.

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.

Apply preferably by airless spray or airless spray equipped with air-assisted pistol (nozzle 0.013 - 0.018"). The paint is sprayed evenly to the specified film thickness. Special care should be taken when spraying edges, corners and welding joints. Small areas can also be painted with a brush, but in this case one additional coat has to be applied in order to achieve the specified film thickness.

Application conditions

The surface must be dry. The temperature of the ambient air, the surface and the paint shall be above +15°C and the relative air humidity 35-50%. Low relative humidity increases the risk of dry spray, and the levelling may also be poorer. 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.

The spray booth

For selection of suitable additives for the water curtain booth contact the supplier of these chemicals. Different types of water-borne paints often demand different additives, and therefore this must be determined for each case separately.

The drying process

In a water-borne paint the water and the film forming agents must have totally evaporated from the paint film before it is subjected to moisture and cold. Painted objects are by normal ventilation conditions to be kept indoors at a temperature of min. +20°C for a minimum of 40 hours.

The relative air humidity must not exceed 60% and the drying temperature must not be below +15°C. High air humidity increases the time of evaporation for the water in the paint and thus prolongs the drying time. This can be prevented by increasing the temperature and/or the ventilation. Increased temperature results in a higher saturation point of the water vapour in the air, and the increased ventilation removes the water vapour more quickly. These measures shorten the drying time considerably.

ADDITIONAL INFORMATION

Do not transport or store the paint in temperatures below +5°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.



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