

# System specification



	Layer 1 First coat	Enhancing Grain	Layer 2 Topcoat
Product	TEKNODUR 3393-23 (opaque colour) 9:1 Mix 7323 by volume	Patina (black)	TEKNODUR 3394-03 Clear 9:1 Mix 7323 by volume
Recommended application method	Air assisted airless spray	Gravity cup gun and / or brush & cloth	Air assisted airless spray
Application temperature	Minimum 10°C		
Wet film thickness (μ)	130-170	N/A	100
Dry film thickness (μ)	50-65	N/A	40
Overcoat time 23°C, 50% RH	Minimum 1 hour	0.5 hours	N/A
Action when dry	N/A		
Equipment cleaner	Water		

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Technical library

## Product Overview

A fully factory-applied coating system for GRP doors, designed for application using automatic or manual air-assisted airless spray (unless otherwise stated).

## Application Guidelines

- Conditions: Apply at temperatures between 15°C and 25°C with humidity below 70%. Low temperatures and high humidity may inhibit curing. Ensure the surface temperature is at least 3°C above the dew point to avoid moisture condensation.
- Surface Preparation: The surface must be clean, dry, and free from dust, grease, and contaminants. All traces of silicone release agents must be removed using V1530. Lightly denib using a Scotch-Brite pad or equivalent to ensure proper adhesion.
- If maximum overcoating time is exceeded (see td sheet), intermediate sanding is required.
- Mixing Ratio: Mix 9 parts TEKNODUR 3393 & 3394 with 1 part 7323-23 hardener by volume. Stir thoroughly. For application by pressure pot or gravity fed cup gun, dilute the mixed material with 10% clean fresh water.
- TEKNODUR 3393 & 3394 Pot Life (+23°C) - 2 – 3 hours
- During the enhancing grain procedure, application by gravity cup gun needs to suit door detail, intricate design is often better suited to brush and cloth method. Best results can be achieved by regularly removing excess patina from the brush , by wiping off into a dry cloth can assist.

## Drying and curing

- Touch Dry: 30 minutes
- Flash-Off Time: Allow 15 minutes before force drying with conventional or infrared equipment. Please consult Teknos for specific drying recommendations.

## Finish options

TEKNODUR 3393 is supplied in standard or bespoke colours. Teknodur 3393 & 3394 are supplied at a 25-30% gloss level.

## Important Notes

- Most colours achieve excellent coverage in a single coat. For optimal opacity with certain shades, a second coat may be applied.
- The 4 standard patina effect colour systems are :- Golden Oak, Irish Oak, Mahogany and Rosewood, please contact Teknos and ask for further details.
- For full technical / application guidelines please reference the products technical data sheet via our Technical Library QR code or contact Teknos directly.

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