

System specification



Product Overview

A fully factory-applied 2K Solvent 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 10 parts ALPOCRYL LE 5393 with 1 part UNIPUR 279 hardener by volume. Stir thoroughly, then dilute with 20% V0950 thinner.
- Mixing Ratio: Mix 4 parts ALPOCRYL LE 5454 with 1 part UNIPUR 279 hardener by volume. Stir thoroughly, then dilute with 20% V0950 thinner.
- ALPOCRYL 5393 & 5454 Pot Life (+23°C) is 6 – 8 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

ALPOCRYL 5393 is supplied in standard or bespoke colours. ALPOCRYL 5393 is supplied at 40% gloss level. ALPOCRYL 5454 is supplied at 15% 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.

	Layer 1 First coat	Enhancing Grain	Layer 2 Topcoat
Product	ALPOCRYL LE 5393-40 10:1 Mix UNIPUR 279 by volume	Patina (black)	ALPOCRYL LE 5454-15 Clear 4:1 Mix UNIPUR 279 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)	100-125	N/A	100-125
Dry film thickness (μ)	48-60	N/A	48-60
Overcoat time 23°C, 50% RH	2-48 hours	0.5 hours	2-48 hours
Action when dry	N/A		
Equipment Cleaner	Thinners Verdunner 0950-98	Water	Thinners Verdunner 0950-98

Disclaimer: The information provided above is based on laboratory testing and practical experience and is intended as a general guide. It is non-binding, and Teknos cannot accept liability for results obtained under conditions beyond our control. Therefore, it is the responsibility of the buyer or end user to test the product's suitability for specific purposes and application methods under actual working conditions. Teknos' liability is limited solely to direct damage caused by defects in the products we supply. This product is intended for professional use only, which presumes that the user has adequate knowledge of its correct handling, including both technical application and workplace safety. For the most up-to-date Technical Data Sheets (TDS) and Safety Data Sheets (SDS), please visit www.teknos.com. All trademarks shown in this document are the exclusive property of Teknos Group or its affiliated companies.



Technical library

Contact us:

UK: T: 01869 208 005 E: sales@teknos.co.uk
Ireland: T: 02879 301 472 E: sales.ni@teknos.co.uk