FORMER P-SYSTEMS
ACCORDING TO ISO 12944: 2007

Go straight to the page you require, by clicking on the name of paint system that you want to see.

INFRALIT PE 8350-00
POLYESTER POWDER SYSTEM

P214

3 21.4.2008

Polyester powder that cures at elevated temperatures (180 - 220°C).

The powder has GSB and Qualicoat material licences. The validity of the licences presupposes curing conditions of not less than 15 min / 190°C, but also 10 min / 180°C (metal temperature) is enough for the powder to cure.

Teknos Coating System Symbol	**P214a**
EN ISO 12944-5 (2007) corrosivity category / durability range	C2/L
The coating system structure:	PE60/1-FeFo
INFRALIT PE 8350-00 polyester powder	1 x 60 µm
Total film thickness	60 µm

The coating system marking: P214a – PE8350-00 60/1 – FeFo

USAGE

Teknos symbol	**Typical use**
P214a	Metal surfaces exposed to sunlight and atmospheric corrosion in corrosivity category C2.

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, see EN ISO 12944, section 4. The surfaces are prepared according to the different materials as follows:

Steel surfaces: Iron phosphating or zinc phosphating.

Aluminium surfaces: Chromating.

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.

PTO

Technical Data

Paint	INFRALIT PE 8350-00
Data Sheet No.	979
Paint Type	polyester powder
Colours	by agreement
Finish	65 - 85
Volume solids %	100
Recommended film thickness µm	60 - 100
Theoretical spreading rate m²/kg	6 - 10
Curing time	15 min / 190 °C (metal temperature). See additional information in Data Sheet

INFRALIT PE 8350-00
POLYESTER POWDER SYSTEMS

P218

3 16.6.2015

Polyester powder that cures at elevated temperatures (180 - 220°C).

The powder has GSB and Qualicoat material licences.

Teknos Coating System Symbol	**P218b**	**P218d**
EN ISO 12944-5 (2007) corrosivity category / durability range	C3/M	C4/M
The coating system structure:	PE80/1-FeSa 2½	PE120/1-FeSa 2½
INFRALIT PE 8350-00 polyester powder	1 x 80 µm	1 x 120 µm
Total film thickness	80 µm	120 µm

Example of the coating system marking: P218b – PE8350-00 80/1 – FeSa 2½

USAGE

Teknos symbol	**Typical use**
P218b	Metal surfaces exposed to sunlight and atmospheric corrosion in corrosivity category C3.
P218d	Metal surfaces exposed to sunlight and atmospheric corrosion in corrosivity category C4.

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, see EN ISO 12944, section 4. The surfaces are prepared according to the different materials as follows:

Hot-rolled surfaces: Blast-clean to grade Sa 2½.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

The profile of the substrate has to be rough enough to ensure good adhesion.

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.

PTO

Technical Data

Paint	INFRALIT PE 8350-00
Data Sheet No.	979
Paint Type	polyester powder
Colours	by agreement
Finish	65 - 85
Volume solids %	100
Recommended film thickness µm	60 - 100
Theoretical spreading rate m^2/kg	6 - 10
Curing time	15 min / 190 °C (metal temperature). See additional information in Data Sheet

INFRALIT EP/PE 8086-05 / EP 8026-00 EPOXY POWDER SYSTEMS, INFRALIT EP/PE 8086-05 / PE 8350 ZINC EPOXY POLYESTER AND POLYESTER POWDER SYSTEM

P219

4 4.9.2017

INFRALIT EP/PE 8086-05 is an epoxy powder, which cures at elevated temperatures (180–200°C).
INFRALIT PE 8350 is a polyester powder, which cures at elevated temperatures (180–220°C).
Zinc epoxy polyester is a primer that has excellent anti-corrosive properties. Polyester powder forms a durable paint film that is resistant to chemical and mechanical stress.

Teknos Coating System Symbol	**P219a**	**P219c**	**P219f**
SFS-EN ISO 12944-5 (2007) corrosivity category / durability range	C3/H	C5-M/H C5-I/H	C5-M/H C5-I/H
The coating system structure:	EP/PEZn60/1 EP100/1- FeSa 2½	EP/PEZn60/1 EP180/1(2)- FeSa 2½	EP/PEZn60/1 PE100/1- FeSa 2½
INFRALIT EP/PE 8086-05 Zinc epoxy polyester powder*	1 x 60 µm	1 x 60 µm	1 x 60 µm
INFRALIT EP 8026-00 Epoxy powder	1 x 100 µm	1 x 180 µm or 2 x 90 µm	–
INFRALIT PE 8350 Polyester powder	–	–	1 x 100 µm
Total film thickness	160 µm	240 µm	160 µm

Example of the coating system marking: P219a – EP/PE 8086-05 60/1 EP 8026-00 100/1 – FeSa 2½.

*Alternatively, also INFRALIT PE 8316-05 and EP 8026-05 zinc rich powders may be used.

Usage

Teknos symbol	**Typical use**
P219a	Steel constructions that are protected from sunlight in corrosivity category C3.
P219c	Steel constructions that are protected from sunlight in corrosivity category C5.
P219f	Metal surfaces exposed to sunlight and atmospheric corrosion in corrosivity category C5.

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, see EN ISO 12944, section 4. The surfaces are prepared according to the different materials as follows:

Hot-dip-galvanized surfaces: Blast-clean to grade Sa 2½.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

The profile of the substrate has to be rough enough to ensure good adhesion.

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.

PTO

Technical Data

Paint	INFRALIT EP/PE 8086-05	INFRALIT EP 8026-00	INFRALIT PE 8350
Data sheet No.	2066	1042	979
Paint type	zinc epoxy polyester powder	epoxy powder	polyester powder
Colours	dark grey	by agreement	by agreement
Finish	semigloss	semigloss	65–85
Volume solids %	100	100	100
Recommended film thickness µm	abt. 60 µm above the peaks of the surface profile	40–150	60–100
Theoretical spreading rate m²/kg	abt. 6	4–15	6–10
Curing time	10 min / 180°C (metal temperature)	10 min / 180°C (metal temperature)	15 min /190°C , (metal temperature). See additional information in Data Sheet.

	L	M	H
C2	O	O	O
C3	O	O	O
C4	O	O	O
C5	O	O	

NORSOK M-501 -approved INFRALIT PE 8316-05 / PE 8350 POLYESTER POWDER SYSTEM

P220

4 18.5.2011

A coating system for coating of steel surfaces that are exposed to so-called ”offshore” environment. The coating system is tested and approved according to ISO 20340 test requirements.
INFRALIT PE 8316-05 Zinc Polyester Powder and INFRALIT PE 8350 Polyester Powder are polyester powders that will cure at elevated temperatures (180–220°C).
The zinc epoxy polyester powder has excellent anti-corrosive properties.
The polyester powder will form a durable paint film that is resistant to chemical and mechanical stress.

Teknos coating system symbol	**P220**
SFS-EN ISO 12944-5 (2007) corrosivity category/durability range	C5-M/H C5-I/H
The coating system structure:	PE 80/1 PE150/1 FeSa 2½ +Zn-fosf.
INFRALIT PE 8316-05 Zink Polyester Powder	1 x 80 µm
INFRALIT PE 8350 Polyester Powder	1 x 150 µm
Total film thickness	230 µm

Example of the coating system marking: P220 – PE 8316-05 80/1 PE 8350 150-1 – FeSa 2½

Usage

Teknos symbol	**Typical use**
P220	Protection of steel surfaces outdoor under very stressful circumstances, corrosivity category C5.

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, see SFS-EN ISO 12944, section 4.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1), then zinc phosphating.

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 (SFS-EN ISO 12944, section 4).

PTO

Maintenance Maintenance painting is performed according to the following coating system (K77a):

TEKNOZINC 3485 SE	1 x 60 µm
INERTA MASTIC MIOX	2 x 110 µm
TEKNOCRYL 2K 2540	1 x 40 µm

Touch-up: Surfaces with rust grades Ri 1 to Ri 3 can be repaired by touching up. Remove flaking paint and rust from damaged areas by scraping and blast cleaning. Extend the preparation over the edges of damages into the intact coating. Touch up the prepared patches with the paints of the system to the original film thickness.
NOTE! TEKNOZINC 3485 SE is to be applied only on bare steel, not over an old paint coat.

Technical Data

Paint	INFRALIT PE 8316-05	INFRALIT PE 8350
Data sheet No.	1052	979
Paint type	Zinc Polyester Powder	Polyester Powder
colours	dark grey	by agreement
Gloss	semigloss	65–85
Total mass of solids %	100	100
Recommended film thickness µm	80	150
Theoretical spreading rate m²/kg	n. 5	4–7
Curing time	10 min / 200 °C , 15 min /190 °C , (metal temperature)	15 min /190 °C , (metal temperature). See additional information in Data Sheet.

INFRALIT EP 8026-00 / PE 8350-00 EPOXY / POLYESTER POWDER SYSTEMS

P229

2 21.4.2008

INFRALIT EP 8026-00 is an epoxy powder that will cure at elevated temperatures (180 - 220°C).
INFRALIT PE 8350-00 is a polyester powder that will cure at elevated temperatures (180 - 220°C).

Teknos Coating System Symbol	**P229g**	**P229h**
EN ISO 12944-5 (2007) corrosivity category / durability range	C4/M	C4/H
The coating system structure:	EP60/1 PE60/1-ZnSaS	PE120/2 ZnSaS
INFRALIT EP 8026-00 Epoxy Powder	1 x 60 µm	–
INFRALIT PE 8350-00 Polyester Powder	1 x 60 µm	2 x 60 µm
Total film thickness	120 µm	120 µm

Example of the coating system marking: P229g – EP 8026-00 60/1 PE 8350-00 60/1 – ZnSaS

USAGE

Teknos symbol	**Typical use**
P229g	Metal surfaces exposed to sunlight and atmospheric corrosion in corrosivity category C4.
P229h	Metal surfaces exposed to sunlight and atmospheric corrosion in corrosivity category C4.

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, see EN ISO 12944, section 4. The surfaces are prepared according to the different materials as follows:

Zinc surfaces: Hot-dip-galvanized steel structures that are exposed to atmospheric corrosion can be painted if the surfaces are sweep blast-cleaned (SaS) till matt all over. Suitable cleaning agents are, e.g. aluminium oxide and natural sand. It is not recommended to paint galvanized objects that are subjected to immersion strain.

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.

PTO

Technical Data

Paint	INFRALIT EP 8026-00	INFRALIT PE 8350-00
Data Sheet No.	1042	979
Paint Type	epoxy powder	polyester powder
Colours	by agreement	by agreement
Finish	semigloss	65 - 85
Volume solids %	100	100
Recommended film thickness µm	40 - 150	60 - 100
Theoretical spreading rate m²/kg	4 - 15	6 - 10
Curing time	10 min / 180°C (metal temperature)	15 min / 190°C (metal temperature). See additional information in Data Sheet

INFRALIT EP 8024-00
EPOXY POWDER SYSTEM

P234

2 21.4.2008

Epoxy Powder that will cure at elevated temperatures (150 - 220°C).
When cured, the epoxy powder will form an extremely durable paint film that is resistant to chemical and mechanical stress. It is also possible to apply thicker than normal paint films.

Teknos Coating System Symbol	**P234c**
EN ISO 12944-5 (2007) corrosivity category / durability range	Im 1-3/H
The coating system structure:	EP480/1(2)-FeSa 2½
INFRALIT EP 8024-00 Epoxy Powder	1 x 480 µm or 2 x 240 µm
Total film thickness	480 µm

The coating system marking: P234c - EP 8024-00 480/1(2) - FeSa 2½

USAGE

Teknos symbol	**Typical use**
P234c	Steel constructions that are protected from sunlight in corrosivity category Im 1. Exposure to sunlight will cause chalking of the paint film.

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, see EN ISO 12944, section 4. The surfaces are prepared according to the different materials as follows:

Hot-dip-galvanized surfaces: Blast-clean to grade Sa 2½.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

The profile of the substrate has to be rough enough to ensure good adhesion.

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.

PTO

Technical Data

Paint	INFRALIT EP 8024-00
Data Sheet No.	1077
Paint Type	epoxy powder
Colours	by agreement
Finish	gloss
Volume solids %	100
Recommended film thickness µm	200 - 400
Theoretical spreading rate m²/kg	1.3 – 1.8
Curing time	10 min / 180 °C (metal temperature)

INFRALIT EP 8040-00 / INFRALIT PE EPOXY / POLYESTER POWDER SYSTEMS

P240

1 9.2.2015

Coating system for galvanized surfaces.

INFRALIT EP 8040-00 is an epoxy powder coating with excellent mechanical properties, i.e. good abrasion and impact resistance and elasticity. The film will not be scratched easily and withstands action by acids, alkalis, greases and solvents. The anticorrosive properties are also good. The powder can be used for base coating in systems where powder coating is used as top coat.

INFRALIT PE is a polyester powder coating. Polyester powder coatings form a mechanically and chemically resistant paint film which withstands well stress by sunlight.

Teknos Coating System Symbol	**P240a**	**P240b**	**P240c**
SFS-EN ISO 12944-5 (2007) corrosivity category / durability range	C4/M	C5-I/M	C5-M/M
The coating system structure:	EP60/1 PE80/1-ZnSaS or Zn-fosf or chromating	EP80/1 PE100/1-ZnSaS or Zn-fosf or chromating	EP80/1 PE100/1-ZnSaS or chromating
INFRALIT EP 8040-00 Epoxy Powder	1 x 60 µm	1 x 80 µm	1 x 80 µm
INFRALIT PE Polyester Powder	1 x 80 µm	1 x 100 µm	1 x 100 µm
Total film thickness	140 µm	180 µm	180 µm

Example of the coating system marking: P240a – EP 8040-00 60/1 PE 8350-00 60/1 – ZnSaS

USAGE

Teknos symbol	**Typical use**
P240a	Metal surfaces exposed to sunlight and atmospheric corrosion in corrosivity category C4.
P240b	Metal surfaces exposed to sunlight and atmospheric corrosion in corrosivity category C5.

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, see EN ISO 12944, section 4. The surfaces are prepared according to the different materials as follows:

Zinc surfaces: Hot-dip-galvanized steel structures that are exposed to atmospheric corrosion can be painted if the surfaces are sweep blast-cleaned (SaS) till matt all over. Suitable cleaning agents are, e.g. aluminium oxide and natural sand. Also zinc phosphating or chromating can be used as preparation. It is not recommended to paint galvanized objects that are subjected to immersion strain.

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.

PTO

Technical Data

Paint	INFRALIT EP 8040-00	INFRALIT PE
Data sheet No.	1611	
Paint type	epoxy powder	polyester powder
Colours	by agreement	by agreement
Finish	10–30 by agreement	by agreement
Volume solids %	100	100
Recommended film thickness µm	60–150	60–100
Theoretical spreading rate m^2/kg	4–15	6–10
Curing time	10 min / 200 °C (metal temperature)	See data sheet

INFRALIT EP 8025
EPOXY POWDER SYSTEM

P241

1 21.10.2016

Epoxy Powder that will cure at elevated temperatures (180 - 200°C).
When cured, the epoxy powder will form an extremely durable paint film that is resistant to chemical and mechanical stress. It is also possible to apply thicker than normal paint films.

Teknos Coating System Symbol	**P241**
EN ISO 12944-5 (2007) corrosivity category / durability range	C4/M
The coating system structure:	EP120/1-FeSa 2½
INFRALIT EP 8025 Epoxy Powder	1 x 120 µm
Total film thickness	120 µm

The coating system marking: P241 - EP 8025 120/1 - FeSa 2½

USAGE

Teknos symbol	**Typical use**
P241	Steel constructions that are protected from sunlight in corrosivity category C4/M. Exposure to sunlight will cause chalking of the paint film.

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, see EN ISO 12944, section 4. The surfaces are prepared according to the different materials as follows:

Hot-dip-galvanized surfaces: Blast-clean to grade Sa 2½.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

The profile of the substrate has to be rough enough to ensure good adhesion.

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.

PTO

Technical Data

Paint	INFRALIT EP 8025
Data Sheet No.	1042
Paint Type	epoxy powder
Colours	by agreement
Finish	gloss / semigloss
Volume solids %	100
Recommended film thickness µm	100 – 140
Theoretical spreading rate m²/kg	1.3 – 1.8
Curing time	10 min / 180 °C (metal temperature)

TEKNOZINC SS 1K / INFRALIT SI 8009-02 ZINC SILICATE PAINT / SILICONE POWDER SYSTEM, INFRALIT SI 8009-05 / SI 8009-02 SILICONE POWDER SYSTEM

P242

3 30.11.2017

TEKNOZINC SS 1K is a moisture curing zinc dust paint with ethyl binder.
INFRALIT SI 8009-02 is a silicone powder that will cure at elevated temperatures (200-220 °C).
INFRALIT SI 8009-05 is a zinc silicone powder that will cure at elevated temperatures (200-220 °C).
The combination of zinc dust paint and silicone powder effectively protects the surface from corrosion and resists high temperatures up to +600°C
INFRALIT SI 8009-05 zinc silicone primer is recommended to be cured completely. If powder is not cured completely the adhesion between primer and top coat may be diminished.

Teknos Coating System Symbol	**P242a**	**P242b**
EN ISO 12944-5 (2007) corrosivity category / durability range	C4/M	C4/H
The coating system structure:	ESIZn(R)70/1-SI60/1 FeSa 2 ½	SIZn(R)70/1-SI70/1 FeSa 2 ½
TEKNOZINC SS 1K Zinc Silicate paint	1 x 70 µm	-
INFRALIT SI 8009-05 Zinc silicone Powder	-	1 x 70 µm
INFRALIT SI 8009-02 Silicone Powder	1 x 60 µm	1 x 70 µm
Total film thickness	130 µm	140 µm
Coating system VOC, g/m² TEKNOZINC SS 1K Zinc Silicate paint	53	-

Example of coating system marking: P242a – TEKNOZINC SS 1K 70/1 SI 8009-02 60/1 – FeSa 2½

USAGE

Teknos symbol	**Typical use**
P242a	Metal surfaces subjected to high temperatures in corrosivity category C4.
P242b	Metal surfaces subjected to high temperatures in corrosivity category C4.

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, see EN ISO 12944, section 4. The surfaces are prepared according to the different materials as follows:

Hot-dip-galvanized surfaces: Blast-clean to grade Sa 2½.

Steel surfaces: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1).

The profile of the substrate has to be rough enough to ensure good adhesion.

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.

PTO

Technical Data

Paint	TEKNOZINC SS 1K	INFRALIT SI 8009-05	INFRALIT SI 8009-02
Data Sheet No.	1861	2225	1528
Paint type	zinc rich ethyl silicate paint	zinc silicone powder	silicone powder
Colours	grey	grey	black
Finish	matt	matt	matt
Volyme solids %	60 ±2	100	100
Recommended film thickness - wet µm - dry µm	 133 70 – 80	 50 – 80	 max. 70
Theoretical spreading rate	7,5 m²/l	15–30 m²/kg	15–30 m²/kg
Drying time, +23°C / 50 % RH - dust free, (ISO 9117-3:2010) - touch dry, (DIN 53150:1995)	(dry film 60 µm) after ¼ h after ½ h	30 min/200 °C (metal temperature) See detailed information from data sheet	30 min/200 °C (metal temperature) See detailed information from data sheet
Overcoatble, 50 % RH	with INFRALIT SI 8009-02	with INFRALIT SI 8009-02	-
+5°C	after 7 d (RH 90 % or wetting of surfaces)	max. after 4 h	
+23°C	after 6 h (RH over 80 % or wetting of surfaces)	max. after 4 h	

BASIC CAMOUFLAGE COATING SYSTEMS K122

3 19.12.2011

Powder coating systems for basic camouflage painting on thin-plate surfaces and other objects, which are chemically prepared or mechanically cleansed before powder coating. The same quality and durability of camouflage coating is achieved by both preparation methods.
The coating is done either as single colour painting (AN11, AN22, AN33 or AN44) or as patterned coating (PNS), in which case the pattern application is done according to the instructions over the powder coating with solvent-borne camouflage paint.
To be used outdoors in corrosivity categories C4 and C5.

CHEMICALLY PREPARED SURFACES:

Teknos Coating System Symbol	**K122a**
Marking of the system:	Nm30-PE180/2-PNS
The coating system structure:	PE180/2-Fe/Al/Zn
INFRALIT PE 8317-10 AN100 Polyester Powder	1 x 80 µm
INFRALIT PE 8431-10 AN11/AN22/AN33/AN44 Polyester Powder	1 x 100 µm
Total film thickness	180 µm
Coating system VOC, g/m²	0
INERTA 70 CAMOUFLAGE PAINT AN11/AN22/AN33/AN44 (pattern application over powder coating)	1 x 40 µm
Total film thickness	220 µm
Coating system VOC, g/m²	50

Surface preparation Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. The surfaces are prepared according to the different materials as follows:
Steel surfaces: Zinc phosphating. Other preparations, such as iron phosphating and newer chemical pre-treatments are acceptable, if the produced corrosion protection has been tested and documented.
Aluminium surfaces: Chromating. Other preparations, such as zinc or iron phosphating and newer chemical pre-treatments are acceptable, if the produced corrosion protection has been tested and documented.
Zinc and similar surfaces: Chromating or zinc phosphating. Other preparations, such as iron phosphating and newer chemical pre-treatments are acceptable, if the produced corrosion protection has been tested and documented.

MECHANICALLY CLEANSED SURFACES:

Teknos Coating System Symbol	**K122b**	**K122c**
Marking of the system:	Nm30-PE180/2-PNS	Nm30-PE180/2-PNS
The coating system structure:	PE180/2-FeSa 2½	PE180/2-AlSaS/ ZnSaS
INFRALIT PE 8316-05 Zinc Polyester Powder	1 x 80 µm	—
INFRALIT PE 8317-10 AN100 Polyester Powder	—	1 x 80 µm
INFRALIT PE 8431-10 AN11/AN22/AN33/AN44 Polyester Powder	1 x 100 µm	1 x 100 µm
Total film thickness	180 µm	180 µm
Coating system VOC, g/m²	0	0
INERTA 70 CAMOUFLAGE PAINT AN11/AN22/AN33/AN44 (pattern application over powder coating)	1 x 40 µm	1 x 40 µm
Total film thickness	220 µm	220 µm
Coating system VOC, g/m²	50	50

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, see EN ISO 12944, section 4. 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.
Aluminium surfaces: The surfaces are sweep blast-cleaned (SaS).
Zinc and similar surfaces: The surfaces are sweep blast-cleaned (SaS).

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.

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

Measuring the film thickness

The measuring point must be noticed when measuring the film thickness of PNS patterned surfaces, because the minimum film thickness depends on the number of paint coats on the measuring point.

Usage Protecting steel, aluminium and zinc surfaces in weather strain.

Teknos symbol	**Typical use**
CHEMICALLY PREPARED SURFACES:	
K122a	Steel, aluminium and zinc surfaces outdoors in corrosivity category C4.
MECHANICALLY CLEANSED SURFACES :	
K122b	Steel surfaces outdoors in corrosivity category C5.
K122c	Aluminium and zinc surfaces outdoors in corrosivity category C4.

Technical Data

Paint	INFRALIT PE 8431-10	INFRALIT PE 8316-05	INFRALIT PE 8317-10	INERTA 70 CAMOUFLAGE PAINT
Product code	DN26080020/ DN27220020/ DN90330020/ DN70440020	DZN8000020	DN25700020	1770211.../ 1770222.../ 1770233../ 1770244...
Data sheet no.	1221	1052	1051	278
Paint type	polyester powder	polyester powder	polyester powder	polyurethane paint
Paint description	camouflage powder	zinc enriched powder priming coat	camouflage green powder priming coat	polyurethane camouflage paint
Colours	AN11/AN22/AN33/ AN44	grey	AN100	AN11/ AN22/AN33/AN44
Finish (G60°)	max. 1.5 (G60°) max. 5.0 (G85°)	limit values 50-80	limit values 3-11	Max. 1 (EN ISO 2813:1999, 60°)
Volume solids %	100	100	100	40 ±2
Volatile Organic Compounds (VOC)	0	0	0	abt. 500 g/l
Recommended film thickness, µm	80-120	60-120	60-100	dry film: 40
Theoretical spreading rate	6-10 m²/kg	abt. 6 m²/kg	6-10 m²/kg	10 m²/l
Curing time/Drying time	15 min / 210°C	10 min / 180°C	10 min / 180°C	Dust free, +23°C/50% RH: after 1 h. Overcoatable, +23°C: after 6 h.