

**TEKNODUR COMBI 340-811**  
**Polyurethane Paint**

<b>PAINT TYPE</b>	TEKNODUR COMBI 340-811 is a two pack anticorrosive pigmented polyurethane paint with low solvent content where the hardener used is an aliphatic isocyanate resin.
<b>USAGE</b>	TEKNODUR COMBI 340-811 is used so-called one layer paint. The paint can also be used as a top coat in Polyurethane Coating Systems. It is suitable to use on steel surfaces.
<b>SPECIAL PROPERTIES</b>	The paint produces a film with good mechanical and weather resistance. The use of TEKNODUR 0290 Polyurethane Varnish is recommended on objects when the topcoat is required to have excellent gloss and colour retention.

**TECHNICAL DATA**

<b>Mixing ratio</b>	Base (Comp. A): Hardener (Comp B): TEKNODUR HARDENER 7295	4 parts by volume 1 part by volume	
<b>Pot life, +23 °C</b>	1 h		
<b>Solids</b>	70 ±2% by volume (ISO 3233:1988)		
<b>Total mass of solids</b>	abt. 1050 g/l		
<b>Volatile organic compound (VOC)</b>	abt. 275 g/l		
<b>Recommended film thickness and theoretical spreading rate</b>	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m <sup>2</sup> /l)
	80	114	8,8
	100	142	7,0
	120	171	5,8

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, +23°C / 50% RH (dry film 80 µm)**

- dust free (ISO 9117-3:2010)	after 70 min
- touch dry (ISO 9117-5:2012)	after 8 h
- drying in elevated temperature, +60 °C	after 1 h

**Overcoatable, 50% RH (dry film 80 µm)**

surface temperature	by itself	
	min.	max.
<b>+5°C</b>	after 24 h	-
<b>+23°C</b>	after 7 h	-

Increase in film thickness and rise in the relative humidity of the air in the drying space usually slow down the drying process.

<b>Thinner</b>	TEKNOSOLV 1602 or TEKNOSOLV 9521
<b>Clean up</b>	TEKNOCLEAN 6496
<b>Finish</b>	Gloss
<b>Colours</b>	By agreement.
<b>SAFETY MARKINGS</b>	See Safety Data Sheet.

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**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.

**OLD PAINTED SURFACES SUITABLE FOR OVERCOATING:** Any impurities that might be detrimental to the application of paint (e.g. grease and salts) are removed. The surfaces must be dry and clean. Old, painted surfaces that have exceeded the maximum overcoating time are to be roughened as well. Damaged parts are prepared in accordance with the requirements of the substrate and the maintenance coating.

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.

**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. Inadequate stirring or incorrect mixing ratio results in imperfect curing and impaired film properties.

**Application**

Before use stir the paint thoroughly.

Dilute the paint 2 - 10% by volume with TEKNOSOLV 1602 or TEKNOSOLV 9521, when required. Universal diluents or thinners cannot be used, since they will react with the hardener.

Apply by conventional spray or airless spray. Use airless spray nozzle 0.011 - 0.015".

The hardener of the paint and the ready paint mixture contain isocyanates. In poorly ventilated areas and especially when using spray application we recommend the use of a fresh air mask. In short or temporary work a mask with combined filter A2-P2 can be used. In this case eyes and face are to be protected.

The hardener can must be opened with caution, as pressure may develop in the can during storage.

Before use clean the spray gun and paint vessels with the paint's own thinner.

**Application conditions**

The surface to be painted has to be dry. During the application and drying period the temperature of the ambient air, the surface and the paint shall be above +5°C and the relative air humidity below 80%. 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.

**ADDITIONAL INFORMATION**

The storage stability is shown on the label. The hardener reacts with air humidity. Store in a cool and dry place in a tightly closed can.

Use opened hardener within two weeks.

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

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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](http://www.teknos.com).

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