

	First Coat	Second Coat	Third Coat
Product	Isofill 1070-00	Alpocryl LE 5393	Alpocryl LE 5393
Recommended application method	Air assisted airless spray / Gravity Cup Gun	Air assisted airless spray / Gravity Cup Gun	Air assisted airless spray / Gravity Cup Gun
Application temperature	Minimum 10°C		
Wet film thickness (μ)	150-175	100-125	100-125
Pot life	2-3 hours	8 hours	8 hours
Overcoat time (23°C; 65% Rh)	4 hours	2 – Max 48 hours	2 – Max 48 hours
Equipment cleaner	V1300	V1300	V1300
Notes	Mix 10:1 with Unipur 279 Hardener add 10% thinner V1300	Mix 10:1 with Unipur 279 Hardener add 10% thinner V1300	Mix 10:1 with Unipur 279 Hardener add 10% thinner V1300

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Additional information on process control and application methods is given in Teknos' Factory Method Statements which are available from your service representative.

A spray applied two-pack solvent borne opaque coating system for interior Joinery.

Designed for application by automatic and manual air assisted airless spray unless otherwise stated.

Application Information:

Apply at temperatures between 10°C and 30°C, and humidity levels below 80%. Low temperature and high humidity may inhibit curing. The surface temperature must be at least 3°C above the dew point to prevent moisture condensation during the curing process.

The surface to be coated must be clean, dry and free from dust and grease. Timbers containing natural oils, such as: Teak, Iroko, Oak or Cedar should be thoroughly degreased immediately prior to coating, using Teknosolv 7012 or equivalent. Failure to do so may impede drying and adhesion.

Important Notes

1. The quality of the paint finish is a function of good surface preparation. Before painting surfaces should be sanded to a smooth level surface using 240 grit then 400 grit, and after mid coat, de nibbed with 400 grit. Care must be taken to remove all traces of dust before applying paint.
2. End grain of MDF should be sanded with 120 grit and then 240 grit prior to coating application.
3. Please refer to relevant products TDS for further information.