

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very<br>high |
|-----------------------------|-----|--------|------|--------------|
| C2.01                       | X   |        |      |              |

**TEC2.01 Low**

**TEKNOLAC PRIMER 0168-00  
Paint systems 80 µm**

1 1.8.2018

TEKNOLAC PRIMER 0168-00 paint systems consist of different kind of fast drying alkyd paints having very good corrosion protection properties. TEKNOLAC PRIMER 0168-00 contains efficient active anticorrosive pigments.

These paint systems are designed for corrosivity category C2 with durability class low.

| Paint                              |    | B1      | B2      |
|------------------------------------|----|---------|---------|
| TEKNOLAC PRIMER 0168-00            | AK | 1x40 µm | 1x40 µm |
| TEKNOLAC COMBI 50                  | AK | 1x40 µm |         |
| TEKNOLAC 0191                      | AK |         | 1x40 µm |
| Total film thickness               |    | 80 µm   | 80 µm   |
| Paint system VOC, g/m <sup>2</sup> |    | 85      | 82      |

| Example of Teknos paint system code | Example of paint system structure      |
|-------------------------------------|--|
| TEC2.01/L/B1                        | ISO 12944-5/C2.01-AK (AK80/2-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very<br>high |
|-----------------------------|-----|--------|------|--------------|
| C2.02                       | X   | X      |      |              |
| C3.01                       | X   |        |      |              |

**TEC2.02 Medium**  
**TEC3.01 Low**

## TEKNOLAC PRIMER 0168-00

### Paint systems 100 µm

1 1.8.2018

TEKNOLAC PRIMER 0168-00 paint systems consist of different kind of fast drying alkyd paints having very good corrosion protection properties. TEKNOLAC PRIMER 0168-00 contains efficient active anticorrosive pigments.

These paint systems are designed for corrosivity categories C2 - C3 with durability classes medium - low.

| Paint                              |    | B1      | B2      |
|------------------------------------|----|---------|---------|
| TEKNOLAC PRIMER 0168-00            | AK | 1x60 µm | 1x60 µm |
| TEKNOLAC COMBI 50                  | AK | 1x40 µm |         |
| TEKNOLAC 0191                      | AK |         | 1x40 µm |
| Total film thickness               |    | 100 µm  | 100 µm  |
| Paint system VOC, g/m <sup>2</sup> |    | 105     | 102     |

| Example of Teknos paint system code | Example of paint system structure       |
|-------------------------------------|---|
| TEC2.02/M/B1                        | ISO 12944-5/C2.02-AK (AK100/2-FeSa 2½). |
| TEC3.01/L/B2                        | ISO 12944-5/C3.01-AK (AK100/2-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very<br>high |
|-----------------------------|-----|--------|------|--------------|
| C2.03                       | X   | X      | X    |              |
| C3.02                       | X   | X      |      |              |
| C4.01                       | X   |        |      |              |

**TEC2.03 High**  
**TEC3.02 Medium**  
**TEC4.01 Low**

**TEKNOLAC PRIMER 0168-00**  
**Paint systems 160 µm**

1 1.8.2018

TEKNOLAC PRIMER 0168-00 paint systems consist of different kind of fast drying alkyd paints having very good corrosion protection properties. TEKNOLAC PRIMER 0168-00 contains efficient active anticorrosive pigments.

These paint systems are designed for corrosivity categories C2 – C4 with durability classes high - low.

| Paint                              |    | B1       | B2       |
|------------------------------------|----|----------|----------|
| TEKNOLAC PRIMER 0168-00            | AK | 1x100 µm | 1x100 µm |
| TEKNOLAC COMBI 50                  | AK | 1x60 µm  |          |
| TEKNOLAC 0191                      | AK |          | 1x60 µm  |
| Total film thickness               |    | 160 µm   | 160 µm   |
| Paint system VOC, g/m <sup>2</sup> |    | 167      | 163      |

| Example of Teknos paint system code | Example of paint system structure       |
|-------------------------------------|---|
| TEC2.03/H/B1                        | ISO 12944-5/C2.03-AK (AK160/2-FeSa 2½). |
| TEC3.02/M/B2                        | ISO 12944-5/C3.02-AK (AK160/2-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low | Medium | High | Very high |
|--------------------------|-----|--------|------|-----------|
| C2.04                    | X   | X      | X    | X         |
| C3.03                    | X   | X      | X    |           |
| C4.02                    | X   | X      |      |           |

**TEC2.04 Very high**  
**TEC3.03 High**  
**TEC4.02 Medium**

## TEKNOLAC PRIMER 0168-00 Paint systems 200 µm

1 1.8.2018

TEKNOLAC PRIMER 0168-00 paint systems consist of different kind of fast drying alkyd paints having very good corrosion protection properties. TEKNOLAC PRIMER 0168-00 contains efficient active anticorrosive pigments.

These paint systems are designed for corrosivity categories C2 – C4 with durability classes very high - low.

| Paint                              |    | B1      | B2      |
|------------------------------------|----|---------|---------|
| TEKNOLAC PRIMER 0168-00            | AK | 2x80 µm | 2x80 µm |
| TEKNOLAC COMBI 50                  | AK | 1x40 µm |         |
| TEKNOLAC 0191                      | AK |         | 1x40 µm |
| Total film thickness               |    | 200 µm  | 200 µm  |
| Paint system VOC, g/m <sup>2</sup> |    | 202     | 200     |

| Example of Teknos paint system code | Example of paint system structure       |
|-------------------------------------|---|
| TEC2.04/VH/B1                       | ISO 12944-5/C2.04-AK (AK200/3-FeSa 2½). |
| TEC3.03/H/B2                        | ISO 12944-5/C3.03-AK (AK200/3-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low      | Medium   | High     | Very<br>high |
|-----------------------------|----------|----------|----------|--------------|
| <b>C3.04</b>                | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>     |
| <b>C4.03</b>                | <b>X</b> | <b>X</b> | <b>X</b> |              |

**TEC3.04 Very high**  
**TEC4.03 High**

## TEKNOLAC PRIMER 0168-00 Paint systems 260 µm

1 1.8.2018

TEKNOLAC PRIMER 0168-00 paint systems consist of different kind of fast drying alkyd paints having very good corrosion protection properties. TEKNOLAC PRIMER 0168-00 contains efficient active anticorrosive pigments.

These paint systems are designed for corrosivity categories C3 – C4 with durability classes very high - high.

| Paint                              |           | B1       | B2      | B3      | B4      |
|------------------------------------|-----------|----------|---------|---------|---------|
| TEKNOLAC PRIMER 0168-00            | <b>AK</b> | 1x80 µm  | 3x70 µm | 1x60 µm | 1x60 µm |
| TEKNOLAC PRIMER 0168-00            | <b>AK</b> | 1x100 µm |         | 2x80 µm | 2x80 µm |
| TEKNOLAC COMBI 50                  | <b>AK</b> | 1x80 µm  |         | 1x40 µm |         |
| TEKNOLAC 0191                      | <b>AK</b> |          | 1x50 µm |         | 1x40 µm |
| Total film thickness               |           | 260 µm   | 260 µm  | 260 µm  | 260 µm  |
| Paint system VOC, g/m <sup>2</sup> |           | 268      | 258     | 261     | 258     |

| Example of Teknos paint system code | Example of paint system structure       |
|-------------------------------------|---|
| TEC3.04/VH/B1                       | ISO 12944-5/C3.04-AK (AK260/3-FeSa 2½). |
| TEC4.03/H/B3                        | ISO 12944-5/C4.03-AK (AK260/4-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low      | Medium   | High     | Very high |
|--------------------------|----------|----------|----------|-----------|
| <b>C2.05</b>             | <b>X</b> | <b>X</b> | <b>X</b> |           |
| <b>C3.05</b>             | <b>X</b> | <b>X</b> |          |           |
| <b>C4.04</b>             | <b>X</b> |          |          |           |

**TEC2.05 High**  
**TEC3.05 Medium**  
**TEC4.04 Low**

## 2-COMPONENT COMBI Paint systems 120 µm

1 1.8.2018

2-COMPONENT COMBI paint systems consist of different types of paint chemistries. These direct to metal one layer paint systems have excellent adhesion to steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints and fast curing polyaspartics have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C4 with durability classes high - low.

| Paint                              |            | A1       | A2       | A3       | A4       | A5       | A6       |
|------------------------------------|------------|----------|----------|----------|----------|----------|----------|
| TEKNOPLAST HS 150                  | <b>EP</b>  | 1x120 µm |          |          |          |          |          |
| TEKNOMASTIC COMBI 80-500           | <b>EP</b>  |          | 1x120 µm |          |          |          |          |
| INERTA 271                         | <b>EP</b>  |          |          | 1x120 µm |          |          |          |
| TEKNODUR COMBI 3430 -series        | <b>PUR</b> |          |          |          | 1x120 µm |          |          |
| TEKNODUR COMBI 340-811             | <b>PUR</b> |          |          |          |          | 1x120 µm |          |
| TEKNODUR COMBI 3560 -series        | <b>PAS</b> |          |          |          |          |          | 1x120 µm |
| Total film thickness               |            | 120 µm   | 120 µm   | 120 µm   | 120 µm   | 120 µm   | 120 µm   |
| Paint system VOC, g/m <sup>2</sup> |            | 51       | 29       | 32       | 69 - 90  | 47       | 8 - 72   |

| Example of Teknos paint system code | Example of paint system structure        |
|-------------------------------------|--|
| TEC2.05/H/A1                        | ISO 12944-5/C2.05-EP (EP120/1-FeSa 2½).  |
| TEC3.05/M/A4                        | ISO 12944-5/C3.05-PUR (PUR120/1-FeSa 2½) |
| TEC4.04/L/A6                        | ISO 12944-5/C4.04-PAS (PAS120/1-FeSa 2½) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low      | Medium   | High     | Very high |
|--------------------------|----------|----------|----------|-----------|
| <b>C2.06</b>             | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>  |
| <b>C3.06</b>             | <b>X</b> | <b>X</b> | <b>X</b> |           |
| <b>C4.05</b>             | <b>X</b> | <b>X</b> |          |           |
| <b>C5.01</b>             | <b>X</b> |          |          |           |

**TEC2.06 Very high**  
**TEC3.06 High**  
**TEC4.05 Medium**  
**TEC5.01 Low**

**2-COMPONENT COMBI  
Paint systems 180 µm**

1 1.8.2018

2-COMPONENT COMBI paint systems consist of different types of paint chemistries. These direct to metal two layer paint systems have excellent adhesion to steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints and fast curing polyaspartics have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C5 with durability classes very high - low.

| Paint                              |            | A1      | A2      | A3      | A4        | A5      | A6       |
|------------------------------------|------------|---------|---------|---------|-----------|---------|----------|
| TEKNOPLAST HS 150                  | <b>EP</b>  | 2x90 µm |         |         |           |         |          |
| TEKNOMASTIC COMBI 80-500           | <b>EP</b>  |         | 2x90 µm |         |           |         |          |
| INERTA 271                         | <b>EP</b>  |         |         | 2x90 µm |           |         |          |
| TEKNODUR COMBI 3430 -series        | <b>PUR</b> |         |         |         | 2x90 µm   |         |          |
| TEKNODUR COMBI 340-811             | <b>PUR</b> |         |         |         |           | 2x90 µm |          |
| TEKNODUR COMBI 3560 -series        | <b>PAS</b> |         |         |         |           |         | 2x90 µm  |
| Total film thickness               |            | 180 µm  | 180 µm  | 180 µm  | 180 µm    | 180 µm  | 180 µm   |
| Paint system VOC, g/m <sup>2</sup> |            | 77      | 44      | 47      | 103 - 135 | 71      | 12 - 108 |

| Example of Teknos paint system code | Example of paint system structure        |
|-------------------------------------|--|
| <b>TEC2.06/VH/A1</b>                | ISO 12944-5/C2.06-EP (EP180/2-FeSa 2½).  |
| <b>TEC3.06/H/A4</b>                 | ISO 12944-5/C3.06-PUR (PUR180/2-FeSa 2½) |
| <b>TEC4.05/M/A6</b>                 | ISO 12944-5/C4.05-PAS (PAS180/2-FeSa 2½) |
| <b>TEC5.01/L/A6</b>                 | ISO 12944-5/C5.01-PAS (PAS180/2-FeSa 2½) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low      | Medium   | High     | Very high |
|--------------------------|----------|----------|----------|-----------|
| <b>C3.07</b>             | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>  |
| <b>C4.06</b>             | <b>X</b> | <b>X</b> | <b>X</b> |           |
| <b>C5.02</b>             | <b>X</b> | <b>X</b> |          |           |

**TEC3.07 Very high**  
**TEC4.06 High**  
**TEC5.02 Medium**

## 2-COMPONENT COMBI Paint systems 240 µm

1 1.8.2018

2-COMPONENT COMBI paint systems consist of different types of paint chemistries. These direct to metal two layer paint systems have excellent adhesion to steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints and fast curing polyaspartics have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

| Paint                              |            | A1       | A2       | A3       | A4        | A5       | A6       |
|------------------------------------|------------|----------|----------|----------|-----------|----------|----------|
| TEKNOPLAST HS 150                  | <b>EP</b>  | 2x120 µm |          |          |           |          |          |
| TEKNOMASTIC COMBI 80-500           | <b>EP</b>  |          | 2x120 µm |          |           |          |          |
| INERTA 271                         | <b>EP</b>  |          |          | 2x120 µm |           |          |          |
| TEKNODUR COMBI 3430 -series        | <b>PUR</b> |          |          |          | 2x120 µm  |          |          |
| TEKNODUR COMBI 340-811             | <b>PUR</b> |          |          |          |           | 2x120 µm |          |
| TEKNODUR COMBI 3560 -series        | <b>PAS</b> |          |          |          |           |          | 2x120 µm |
| Total film thickness               |            | 240 µm   | 240 µm   | 240 µm   | 240 µm    | 240 µm   | 240 µm   |
| Paint system VOC, g/m <sup>2</sup> |            | 103      | 59       | 63       | 138 - 180 | 94       | 16 - 144 |

| Example of Teknos paint system code | Example of paint system structure        |
|-------------------------------------|--|
| TEC3.07/VH/A1                       | ISO 12944-5/C3.07-EP (EP240/2-FeSa 2½).  |
| TEC4.06/H/A4                        | ISO 12944-5/C4.06-PUR (PUR240/2-FeSa 2½) |
| TEC5.02/M/A6                        | ISO 12944-5/C5.02-PAS (PAS240/2-FeSa 2½) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.



**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low      | Medium   | High     | Very high |
|--------------------------|----------|----------|----------|-----------|
| <b>C4.07</b>             | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>  |
| <b>C5.03</b>             | <b>X</b> | <b>X</b> | <b>X</b> |           |

**TEC4.07 Very high**  
**TEC5.03 High**

## 2-COMPONENT COMBI Paint systems 300 µm

1 1.8.2018

2-COMPONENT COMBI paint systems consist of different types of paint chemistries. These direct to metal two layer paint systems have excellent adhesion to steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints and fast curing polyaspartics have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C4 – C5 with durability classes very high - high.

| Paint                              |            | A1       | A2       | A3       | A4       | A5        | A6       |
|------------------------------------|------------|----------|----------|----------|----------|-----------|----------|
| TEKNOPLAST HS 150                  | <b>EP</b>  | 2x150 µm |          |          |          |           |          |
| TEKNOMASTIC COMBI 80-500           | <b>EP</b>  |          | 2x150 µm |          |          |           |          |
| INERTA 271                         | <b>EP</b>  |          |          | 2x150 µm |          |           |          |
| TEKNODUR COMBI 340-811             | <b>PUR</b> |          |          |          | 3x100 µm |           |          |
| TEKNODUR COMBI 3430 -series        | <b>PUR</b> |          |          |          |          | 3x100 µm  |          |
| TEKNODUR COMBI 3560 -series        | <b>PAS</b> |          |          |          |          |           | 2x150 µm |
| Total film thickness               |            | 300 µm   | 300 µm   | 300 µm   | 300 µm   | 300 µm    | 300 µm   |
| Paint system VOC, g/m <sup>2</sup> |            | 129      | 73       | 79       | 118      | 172 - 225 | 20 - 180 |

| Example of Teknos paint system code | Example of paint system structure        |
|-------------------------------------|--|
| TEC4.07/VH/A1                       | ISO 12944-5/C4.07-EP (EP300/2-FeSa 2½).  |
| TEC5.03/H/A4                        | ISO 12944-5/C5.03-PUR (PUR300/3-FeSa 2½) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very high |
|-----------------------------|-----|--------|------|-----------|
| C5.04                       | X   | X      | X    | X         |

**TEC5.04 Very high**

## 2-COMPONENT COMBI Paint systems 360 µm

1 1.8.2018

2-COMPONENT COMBI paint systems consist of different types of paint chemistries. These direct to metal three layer paint systems have excellent adhesion to steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints and fast curing polyaspartics have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity category C5 with durability class very high.

| Paint                              |     | A1       | A2       | A3       | A4       | A5        | A6       |
|------------------------------------|-----|----------|----------|----------|----------|-----------|----------|
| TEKNOPLAST HS 150                  | EP  | 3x120 µm |          |          |          |           |          |
| TEKNOMASTIC COMBI 80-500           | EP  |          | 3x120 µm |          |          |           |          |
| INERTA 271                         | EP  |          |          | 3x120 µm |          |           |          |
| TEKNODUR COMBI 340-811             | PUR |          |          |          | 3x120 µm |           |          |
| TEKNODUR COMBI 3430 -series        | PUR |          |          |          |          | 3x120 µm  |          |
| TEKNODUR COMBI 3560 -series        | PAS |          |          |          |          |           | 3x120 µm |
| Total film thickness               |     | 360 µm   | 360 µm   | 360 µm   | 360 µm   | 360 µm    | 360 µm   |
| Paint system VOC, g/m <sup>2</sup> |     | 154      | 88       | 95       | 141      | 207 - 270 | 24 - 216 |

| Example of Teknos paint system code | Example of paint system structure       |
|-------------------------------------|---|
| TEC5.04/VH/A1                       | ISO 12944-5/C5.04-EP (EP360/3-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low | Medium | High | Very high |
|--------------------------|-----|--------|------|-----------|
| C2.07                    | X   | X      | X    |           |
| C3.08                    | X   | X      |      |           |
| C4.08                    | X   |        |      |           |

**TEC2.07 High**  
**TEC3.08 Medium**  
**TEC4.08 Low**

## ZINC RICH Paint systems 60 µm

1 1.8.2018

TEKNOZINC zinc rich paint systems consist of zinc rich paints, in which the zinc content is at least 80% by weight in a dry paint film.

Paints containing zinc give steel a very good protection against corrosion. Below mentioned zinc rich paint systems can be used in corrosivity categories C2 – C4 with durability classes high - low.

| Paint                              |     | A1      | A2      | A3      | A4      |
|------------------------------------|-----|---------|---------|---------|---------|
| TEKNOZINC 80 SE                    | EP  | 1x60 µm |         |         |         |
| TEKNOZINC 3480 SE                  | EP  |         | 1x60 µm |         |         |
| TEKNOZINC SS                       | ESI |         |         | 1x60 µm |         |
| TEKNOZINC SS 1K                    | ESI |         |         |         | 1x60 µm |
| Total film thickness               |     | 60 µm   | 60 µm   | 60 µm   | 60 µm   |
| Paint system VOC, g/m <sup>2</sup> |     | 54      | 27      | 59      | 60      |

| Example of Teknos paint system code | Example of paint system structure                 |
|-------------------------------------|---|
| TEC2.07/H/A1                        | ISO 12944-5/C2.0-EPZn(R) (EPZn(R)60/1-FeSa 2½).   |
| TEC3.08/M/A3                        | ISO 12944-5/C3.08-ESIZn(R) (ESIZn(R)60/1-FeSa 2½) |
| TEC4.08/L/A4                        | ISO 12944-5/C4.08-ESIZn(R) (ESIZn(R)60/1-FeSa 2½) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low      | Medium   | High     | Very high |
|--------------------------|----------|----------|----------|-----------|
| <b>C2.08</b>             | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>  |
| <b>C3.09</b>             | <b>X</b> | <b>X</b> | <b>X</b> |           |
| <b>C4.09</b>             | <b>X</b> | <b>X</b> |          |           |
| <b>C5.05</b>             | <b>X</b> |          |          |           |

**TEC2.08 Very high**  
**TEC3.09 High**  
**TEC4.09 Medium**  
**TEC5.05 Low**

**TEKNOZINC 80 SE, High Solid TOP COATS**  
**Paint systems 160 µm**

1 1.8.2018

TEKNOZINC 80 SE paint systems consist of different paints where the primer is a 2-component zinc epoxy paint containing at least 80% zinc by weight in the dry paint film.

Paint systems containing zinc rich TEKNOZINC 80 SE primer give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy, polyurethane or fast curing polyaspartic chemistry. Chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C5 with durability classes very high - low.

| Paint                              |            | EP-<br>top coat | PUR-<br>top coat |          | PAS-<br>top coat |
|------------------------------------|------------|-----------------|------------------|----------|------------------|
|                                    |            | A1              | A2               | A3       | A4               |
| TEKNOZINC 80 SE                    | <b>EP</b>  | 1x60 µm         | 1x60 µm          | 1x60 µm  | 1x60 µm          |
| TEKNOPLAST HS 150                  | <b>EP</b>  | 1x100 µm        |                  |          |                  |
| TEKNODUR COMBI 3430 -series        | <b>PUR</b> |                 | 1x100 µm         |          |                  |
| TEKNODUR COMBI 340-811             | <b>PUR</b> |                 |                  | 1x100 µm |                  |
| TEKNODUR COMBI 3560 -series        | <b>PAS</b> |                 |                  |          | 1x100 µm         |
| Total film thickness               |            | 160 µm          | 160 µm           | 160 µm   | 160 µm           |
| Paint system VOC, g/m <sup>2</sup> |            | 97              | 111 - 129        | 93       | 60 - 114         |

| Example of Teknos paint system code | Example of paint system structure                   |
|-------------------------------------|---|
| TEC2.08/VH/A1                       | 12944-5/C2.08-EPZn(R)/EP (EPZn(R)EP160/2-FeSa 2½).  |
| TEC3.09/H/A2                        | 12944-5/C3.09-EPZn(R)/PUR (EPZn(R)PUR160/2-FeSa 2½) |
| TEC4.09/M/A3                        | 12944-5/C4.09-EPZn(R)/PUR (EPZn(R)PUR160/2-FeSa 2½) |
| TEC5.05/L/A4                        | 12944-5/C5.05-EPZn(R)/PAS (EPZn(R)PAS160/2-FeSa 2½) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low      | Medium   | High     | Very high |
|--------------------------|----------|----------|----------|-----------|
| <b>C3.10</b>             | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>  |
| <b>C4.10</b>             | <b>X</b> | <b>X</b> | <b>X</b> |           |
| <b>C5.06</b>             | <b>X</b> | <b>X</b> |          |           |

**TEC3.10 Very high**  
**TEC4.10 High**  
**TEC5.06 Medium**

**TEKNOZINC 80 SE, High Solid TOP COATS**  
**Paint systems 200 µm**

1 1.8.2018

TEKNOZINC 80 SE paint systems consist of different paints where the primer is a 2-component zinc epoxy paint containing at least 80% zinc by weight in the dry paint film.

Paint systems containing zinc rich TEKNOZINC 80 SE primer give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy, polyurethane or fast curing polyaspartic chemistry. Chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

| Paint                              |            | EP-<br>top coat | PUR-<br>top coat |          | PAS-<br>top coat |
|------------------------------------|------------|-----------------|------------------|----------|------------------|
|                                    |            | A1              | A2               | A3       | A4               |
| TEKNOZINC 80 SE                    | <b>EP</b>  | 1x60 µm         | 1x60 µm          | 1x60 µm  | 1x60 µm          |
| TEKNOPLAST HS 150                  | <b>EP</b>  | 1x140 µm        |                  |          |                  |
| TEKNODUR COMBI 3430 -series        | <b>PUR</b> |                 | 2x70 µm          |          |                  |
| TEKNODUR COMBI 340-811             | <b>PUR</b> |                 |                  | 1x140 µm |                  |
| TEKNODUR COMBI 3560 -series        | <b>PAS</b> |                 |                  |          | 1x140 µm         |
| Total film thickness               |            | 200 µm          | 200 µm           | 200 µm   | 200 µm           |
| Paint system VOC, g/m <sup>2</sup> |            | 114             | 134 - 159        | 109      | 63 - 138         |

| Example of Teknos paint system code | Example of paint system structure                       |
|-------------------------------------|---|
| TEC3.10/VH/A1                       | ISO 12944-5/C3.10-EPZn(R)/EP (EPZn(R)EP200/2-FeSa 2½)   |
| TEC4.10/H/A2                        | ISO 12944-5/C4.10-EPZn(R)/PUR (EPZn(R)PUR200/3-FeSa 2½) |
| TEC5.06/M/A4                        | ISO 12944-5/C5.06-EPZn(R)/PAS (EPZn(R)PAS200/2-FeSa 2½) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low      | Medium   | High     | Very high |
|--------------------------|----------|----------|----------|-----------|
| <b>C4.11</b>             | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>  |
| <b>C5.07</b>             | <b>X</b> | <b>X</b> | <b>X</b> |           |

**TEC4.11 Very high**  
**TEC5.07 High**

## TEKNOZINC 80 SE, High Solid TOP COATS

### Paint systems 260 µm

1 1.8.2018

TEKNOZINC 80 SE paint systems consist of different paints where the primer is a 2-component zinc epoxy paint containing at least 80% zinc by weight in the dry paint film.

Paint systems containing zinc rich TEKNOZINC 80 SE primer give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy, polyurethane or fast curing polyaspartic chemistry. Chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C4 – C5 with durability classes very high - high.

| Paint                              |            | EP-<br>top coat | PUR-<br>top coat |          | PAS-<br>top coat |
|------------------------------------|------------|-----------------|------------------|----------|------------------|
|                                    |            | A1              | A2               | A3       | A4               |
| TEKNOZINC 80 SE                    | <b>EP</b>  | 1x60 µm         | 1x60 µm          | 1x60 µm  | 1x60 µm          |
| TEKNOPLAST HS 150                  | <b>EP</b>  | 2x100 µm        |                  |          |                  |
| TEKNODUR COMBI 3430 -series        | <b>PUR</b> |                 | 2x100 µm         |          |                  |
| TEKNODUR COMBI 340-811             | <b>PUR</b> |                 |                  | 2x100 µm |                  |
| TEKNODUR COMBI 3560 -series        | <b>PAS</b> |                 |                  |          | 2x100 µm         |
| Total film thickness               |            | 260 µm          | 260 µm           | 260 µm   | 260 µm           |
| Paint system VOC, g/m <sup>2</sup> |            | 140             | 169 - 204        | 133      | 67 - 174         |

| Example of Teknos paint system code | Example of paint system structure                       |
|-------------------------------------|---|
| TEC4.11/VH/A1                       | ISO 12944-5/C4.11-EPZn(R)/EP (EPZn(R)EP260/3-FeSa 2½)   |
| TEC5.07/H/A4                        | ISO 12944-5/C5.07-EPZn(R)/PAS (EPZn(R)PAS260/3-FeSa 2½) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low      | Medium   | High     | Very high |
|-----------------------------|----------|----------|----------|-----------|
| <b>C5.08</b>                | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>  |

**TEC5.08 Very high**

## TEKNOZINC 80 SE, High Solid TOP COATS Paint systems 320 µm

1 1.8.2018

TEKNOZINC 80 SE paint systems consist of different paints where the primer is a 2-component zinc epoxy paint containing at least 80% zinc by weight in the dry paint film.

Paint systems containing zinc rich TEKNOZINC 80 SE primer give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy, polyurethane or fast curing polyaspartic chemistry. Chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity category C5 with durability class very high.

| Paint                              |            | EP-<br>top coat | PUR-<br>top coat |          | PAS-<br>top coat |
|------------------------------------|------------|-----------------|------------------|----------|------------------|
|                                    |            | A1              | A2               | A3       | A4               |
| TEKNOZINC 80 SE                    | <b>EP</b>  | 1x60 µm         | 1x60 µm          | 1x60 µm  | 1x60 µm          |
| TEKNOPLAST HS 150                  | <b>EP</b>  | 2x130 µm        |                  |          |                  |
| TEKNODUR COMBI 3430 -series        | <b>PUR</b> |                 | 1x80 µm          |          |                  |
| TEKNODUR COMBI 3430 -series        | <b>PUR</b> |                 | 2x90 µm          |          |                  |
| TEKNODUR COMBI 340-811             | <b>PUR</b> |                 |                  | 2x130 µm |                  |
| TEKNODUR COMBI 3560 -series        | <b>PAS</b> |                 |                  |          | 2x130 µm         |
| Total film thickness               |            | 320 µm          | 320 µm           | 320 µm   | 320 µm           |
| Paint system VOC, g/m <sup>2</sup> |            | 165             | 203 - 249        | 156      | 71 - 210         |

| Example of Teknos paint system code | Example of paint system structure                     |
|-------------------------------------|---|
| TEC5.08/VH/A1                       | ISO 12944-5/C5.08-EPZn(R)/EP (EPZn(R)EP320/3-FeSa 2½) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**Im**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very<br>high |
|-----------------------------|-----|--------|------|--------------|
| I.01                        | X   | X      | X    |              |

**TEI.01 High**

## TEKNOZINC 80 SE and TEKNOZINC 3480 SE, IMMERSION Paint systems 360 µm

1 1.8.2018

TEKNOZINC 80 SE and TEKNOZINC 3480 SE paint systems consist of different paints where the primer is a 2-component zinc epoxy paint containing at least 80% zinc by weight in the dry paint film. Top coats are based on epoxy chemistry.

Below mentioned zinc rich paint systems are designed for carbon steel for immersion categories Im 1, Im 2 and Im 3.

| Paint                              |    | A1       | A2       | A3       |
|------------------------------------|----|----------|----------|----------|
| TEKNOZINC 80 SE                    | EP | 1x60 µm  | 1x60 µm  |          |
| TEKNOZINC 3480 SE                  | EP |          |          | 1x60 µm  |
| TEKNOPLAST HS 150                  | EP | 2x150 µm |          | 2x150 µm |
| TEKNOMASTIC COMBI 80-500           | EP |          | 2x150 µm |          |
| Total film thickness               |    | 360 µm   | 360 µm   | 360 µm   |
| Paint system VOC, g/m <sup>2</sup> |    | 182      | 73       | 155      |

| Example of Teknos paint system code | Example of paint system structure                     |
|-------------------------------------|---|
| TEI.01/H/A1                         | ISO 12944-5/I.01-EPZn(R)/EP (EPZn(R)EP360/3-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.



**Suitable corrosivity categories/durability ranges**

**Im**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very high |
|-----------------------------|-----|--------|------|-----------|
| I.02                        | X   | X      | X    | X         |

**TEI.02 Very high**

# TEKNOZINC 80 SE and TEKNOZINC 3480 SE, IMMERSION Paint systems 500 µm

1 1.8.2018

TEKNOZINC 80 SE and TEKNOZINC 3480 SE paint systems consist of different paints where the primer is a 2-component zinc epoxy paint containing at least 80% zinc by weight in the dry paint film. Top coats are based on epoxy chemistry.

Below mentioned zinc rich paint systems are designed for carbon steel for immersion categories Im 1, Im 2 and Im 3.

| Paint                              |    | A1       | A2       | A3       | A4       | A5       | A6       |
|------------------------------------|----|----------|----------|----------|----------|----------|----------|
| TEKNOZINC 80 SE                    | EP | 1x60 µm  | 1x60 µm  | 1x60 µm  |          |          |          |
| TEKNOZINC 3480 SE                  | EP |          |          |          | 1x60 µm  | 1x80 µm  | 1x80 µm  |
| TEKNOPLAST HS 150                  | EP | 1x120 µm |          |          | 1x120 µm |          |          |
| TEKNOPLAST HS 150                  | EP | 2x160 µm |          |          | 2x160 µm |          |          |
| TEKNOMASTIC 80 PRIMER              | EP |          | 2x220 µm |          |          | 2x210 µm |          |
| TEKNOMASTIC COMBI 80-500           | EP |          |          | 2x220 µm |          |          | 2x210 µm |
| Total film thickness               |    | 500 µm   | 500 µm   | 500 µm   | 500 µm   | 500 µm   | 500 µm   |
| Paint system VOC, g/m <sup>2</sup> |    | 242      | 161      | 161      | 215      | 139      | 139      |

| Example of Teknos paint system code | Example of paint system structure                     |
|-------------------------------------|---|
| TEI.02/VH/A3                        | ISO 12944-5/I.02-EPZn(R)/EP (EPZn(R)EP500/3-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**Im**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very<br>high |
|-----------------------------|-----|--------|------|--------------|
| I.03                        | X   | X      | X    |              |

**TEI.03 High**

## TEKNOMASTIC 80 PRIMER, IMMERSION Paint systems 380 µm

1 1.8.2018

TEKNOMASTIC 80 PRIMER paint systems for carbon steel for immersion categories Im 1, Im 2 and Im 3 are described in the table below.

Paint systems are designed so that a high solids TEKNOMASTIC 80 PRIMER is used as primer and a high solids or solvent-free epoxy coating is used as a topcoat. The topcoat epoxy is chosen according to the technical needs. The expected durability class for these paint systems is high.

| Paint                              |    | A1       | A2       | A3       | A4       | A5       |
|------------------------------------|----|----------|----------|----------|----------|----------|
| TEKNOMASTIC 80 PRIMER              | EP | 1x80 µm  | 1x80 µm  | 1x80 µm  | 1x80 µm  | 1x80 µm  |
| TEKNOMASTIC 80 PRIMER              | EP | 2x150 µm |          |          |          |          |
| INERTA 165                         | EP |          | 1x300 µm |          |          |          |
| INERTA 270                         | EP |          |          | 2x150 µm |          |          |
| INERTA 280                         | EP |          |          |          | 1x300 µm |          |
| TEKNOMASTIC COMBI 80-500           | EP |          |          |          |          | 2x150 µm |
| Total film thickness               |    | 380 µm   | 380 µm   | 380 µm   | 380 µm   | 380 µm   |
| Paint system VOC, g/m <sup>2</sup> |    | 92       | 52       | 99       | 35       | 92       |

| Example of Teknos paint system code | Example of paint system structure      |
|-------------------------------------|--|
| TEI.03/H/A1                         | ISO 12944-5/I.03-EP (EP380/3-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**Im**

| Paint system ISO 12944-5 | Low | Medium | High | Very high |
|--------------------------|-----|--------|------|-----------|
| I.04                     | X   | X      | X    | X         |

**TEI.04 Very high**

## TEKNOMASTIC 80 PRIMER, IMMERSION Paint systems 540 µm

1 1.8.2018

TEKNOMASTIC 80 PRIMER paint systems for carbon steel for immersion categories Im 1, Im 2 and Im 3 are described in the table below.

Paint systems are designed so that a high solids TEKNOMASTIC 80 PRIMER is used as primer and a high solids or solvent-free epoxy coating is used as a topcoat. The topcoat epoxy is chosen according to the technical needs. The expected durability class for these paint systems is very high.

| Paint                              |    | A1       | A2       | A3       | A4       | A5       |
|------------------------------------|----|----------|----------|----------|----------|----------|
| TEKNOMASTIC 80 PRIMER              | EP | 1x80 µm  | 1x80 µm  | 1x80 µm  | 1x80 µm  | 1x80 µm  |
| TEKNOMASTIC 80 PRIMER              | EP | 2x230 µm |          |          |          |          |
| INERTA 165                         | EP |          | 2x230 µm |          |          |          |
| INERTA 270                         | EP |          |          | 2x230 µm |          |          |
| INERTA 280                         | EP |          |          |          | 1x460 µm |          |
| TEKNOMASTIC COMBI 80-500           | EP |          |          |          |          | 2x230 µm |
| Total film thickness               |    | 540 µm   | 540 µm   | 540 µm   | 540 µm   | 540 µm   |
| Paint system VOC, g/m <sup>2</sup> |    | 131      | 69       | 142      | 43       | 131      |

| Example of Teknos paint system code | Example of paint system structure      |
|-------------------------------------|--|
| TEI.04/VH/A1                        | ISO 12944-5/I.04-EP (EP540/3-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**Im**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very<br>high |
|-----------------------------|-----|--------|------|--------------|
| I.05                        | X   | X      | X    |              |

**TEI.05 High**

## EPOXY COATINGS FOR IMMERSION Paint systems 400 µm

1 1.8.2018

These paint systems for immersion use consist of high solids or almost solvent-free epoxy coatings for durability class high. The suitable paint is chosen according to the technical needs.

The paint systems are designed for carbon steel for immersion categories Im 1, Im 2 and Im 3.

| Paint                              |    | A1       | A2       | A3       | A4       | A5       |
|------------------------------------|----|----------|----------|----------|----------|----------|
| INERTA 160                         | EP | 1x400 µm |          |          |          |          |
| INERTA 165                         | EP |          | 1x400 µm |          |          |          |
| INERTA 280                         | EP |          |          | 1x400 µm |          |          |
| INERTA 270                         | EP |          |          |          | 2x200 µm |          |
| TEKNOMASTIC 80 PRIMER              | EP |          |          |          |          | 2x200 µm |
| Total film thickness               |    | 400 µm   | 400 µm   | 400 µm   | 400 µm   | 400 µm   |
| Paint system VOC, g/m <sup>2</sup> |    | 17       | 43       | 21       | 106      | 97       |

| Example of Teknos paint system code | Example of paint system structure      |
|-------------------------------------|--|
| TEI.05/H/A1                         | ISO 12944-5/I.05-EP (EP400/1-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**Im**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very<br>high |
|-----------------------------|-----|--------|------|--------------|
| I.06                        | X   | X      | X    | X            |

**TEI.06 Very high**

## EPOXY COATINGS FOR IMMERSION

### Paint systems 600 µm

1 1.8.2018

These paint systems for immersion use consist of high solids or almost solvent-free epoxy coatings for durability class high. The suitable paint is chosen according to the technical needs.

The paint systems are designed for carbon steel for immersion categories Im 1, Im 2 and Im 3.

| Paint                              |    | A1       | A2       | A3       | A4       |
|------------------------------------|----|----------|----------|----------|----------|
| INERTA 160                         | EP | 1x600 µm |          |          |          |
| INERTA 165                         | EP |          | 2x300 µm |          |          |
| INERTA 280                         | EP |          |          | 1x600 µm |          |
| INERTA 160 FILL                    | EP |          |          |          | 1x600 µm |
| Total film thickness               |    | 600 µm   | 600 µm   | 600 µm   | 600 µm   |
| Paint system VOC, g/m <sup>2</sup> |    | 25       | 65       | 31       | 25       |

| Example of Teknos paint system code | Example of paint system structure      |
|-------------------------------------|--|
| TEI.06/VH/A1                        | ISO 12944-5/I.06-EP (EP600/1-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very high |
|-----------------------------|-----|--------|------|-----------|
| C2.01                       | X   |        |      |           |

**TEC2.01 Low**

## TEKNOSYNT PRIMER 3 Paint systems 80 µm

1 1.8.2018

TEKNOSYNT PRIMER 3 paint systems consist of white spirit containing thixotropic paints, that contain active anticorrosive pigments.

These paint systems can be used in field and station painting of structured steel objects.

These paint systems are designed for corrosivity category C2 with durability class low.

| Paint                              |    | D1      | D2      |
|------------------------------------|----|---------|---------|
| TEKNOSYNT PRIMER 3                 | AK | 1x40 µm | 1x40 µm |
| TEKNOSYNT COMBI 50                 | AK | 1x40 µm |         |
| TEKNOSYNT 90                       | AK |         | 1x40 µm |
| Total film thickness               |    | 80 µm   | 80 µm   |
| Paint system VOC, g/m <sup>2</sup> |    | 74      | 84      |

| Example of Teknos paint system code | Example of paint system structure      |
|-------------------------------------|--|
| TEC2.01/L/D1                        | ISO 12944-5/C2.01-AK (AK80/2-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very high |
|-----------------------------|-----|--------|------|-----------|
| C2.02                       | X   | X      |      |           |
| C3.01                       | X   |        |      |           |

**TEC2.02 Medium**  
**TEC3.01 Low**

**TEKNOSYNT PRIMER 3**  
**Paint systems 100 µm**

1 1.8.2018

TEKNOSYNT PRIMER 3 paint systems consist of white spirit containing thixotropic paints, that contain active anticorrosive pigments.

These paint systems can be used in field and station painting of structured steel objects.

These paint systems are designed for corrosivity categories C2 – C3 with durability classes medium - low.

| Paint                              |           | D1      | D2      |
|------------------------------------|-----------|---------|---------|
| TEKNOSYNT PRIMER 3                 | <b>AK</b> | 1x60 µm | 1x60 µm |
| TEKNOSYNT COMBI 50                 | <b>AK</b> | 1x40 µm |         |
| TEKNOSYNT 90                       | <b>AK</b> |         | 1x40 µm |
| Total film thickness               |           | 100 µm  | 100 µm  |
| Paint system VOC, g/m <sup>2</sup> |           | 95      | 106     |

| Example of Teknos paint system code | Example of paint system structure       |
|-------------------------------------|---|
| TEC2.02/M/D1                        | ISO 12944-5/C2.02-AK (AK100/2-FeSa 2½). |
| TEC3.01/L/D2                        | ISO 12944-5/C3.01-AK (AK100/2-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low | Medium | High | Very high |
|--------------------------|-----|--------|------|-----------|
| C2.03                    | X   | X      | X    |           |
| C3.02                    | X   | X      |      |           |
| C4.01                    | X   |        |      |           |

**TEC2.03 High**  
**TEC3.02 Medium**  
**TEC4.01 Low**

# TEKNOSYNT PRIMER 3

## Paint systems 160 µm

1 1.8.2018

TEKNOSYNT PRIMER 3 paint systems consist of white spirit containing thixotropic paints, that contain active anticorrosive pigments.

These paint systems can be used in field and station painting of structured steel objects.

These paint systems are designed for corrosivity categories C2 – C4 with durability classes high - low.

| Paint                              |    | D1       | D2       |
|------------------------------------|----|----------|----------|
| TEKNOSYNT PRIMER 3                 | AK | 1x100 µm | 1x100 µm |
| TEKNOSYNT COMBI 50                 | AK | 1x60 µm  |          |
| TEKNOSYNT 90                       | AK |          | 1x60 µm  |
| Total film thickness               |    | 160 µm   | 160 µm   |
| Paint system VOC, g/m <sup>2</sup> |    | 155      | 170      |

| Example of Teknos paint system code | Example of paint system structure       |
|-------------------------------------|---|
| TEC2.03/H/D1                        | ISO 12944-5/C2.03-AK (AK160/2-FeSa 2½). |
| TEC3.02/M/D2                        | ISO 12944-5/C3.02-AK (AK160/2-FeSa 2½)  |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.



**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low | Medium | High | Very high |
|--------------------------|-----|--------|------|-----------|
| C2.04                    | X   | X      | X    | X         |
| C3.03                    | X   | X      | X    |           |
| C4.02                    | X   | X      |      |           |

**TEC2.04 Very high**  
**TEC3.03 High**  
**TEC4.02 Medium**

## TEKNOSYNT PRIMER 3 Paint systems 200 µm

1 1.8.2018

TEKNOSYNT PRIMER 3 paint systems consist of white spirit containing thixotropic paints, that contain active anticorrosive pigments.

These paint systems can be used in field and station painting of structured steel objects.

These paint systems are designed for corrosivity categories C2 – C4 with durability classes very high - medium.

| Paint                              |           | D1      | D2      |
|------------------------------------|-----------|---------|---------|
| TEKNOSYNT PRIMER 3                 | <b>AK</b> | 2x80 µm | 2x80 µm |
| TEKNOSYNT COMBI 50                 | <b>AK</b> | 1x40 µm |         |
| TEKNOSYNT 90                       | <b>AK</b> |         | 1x40 µm |
| Total film thickness               |           | 200 µm  | 200 µm  |
| Paint system VOC, g/m <sup>2</sup> |           | 202     | 212     |

| Example of Teknos paint system code | Example of paint system structure       |
|-------------------------------------|---|
| TEC2.04/VH/D1                       | ISO 12944-5/C2.04-AK (AK200/3-FeSa 2½). |
| TEC3.03/H/D2                        | ISO 12944-5/C3.03-AK (AK200/3-FeSa 2½)  |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low | Medium | High | Very high |
|--------------------------|-----|--------|------|-----------|
| C3.04                    | X   | X      | X    | X         |
| C4.03                    | X   | X      | X    |           |

**TEC3.04 Very high**  
**TEC4.03 High**

## TEKNOSYNT PRIMER 3 Paint systems 260 µm

1 1.8.2018

TEKNOSYNT PRIMER 3 paint systems consist of white spirit containing thixotropic paints, that contain active anticorrosive pigments.

These paint systems can be used in field and station painting of structured steel objects.

These paint systems are designed for corrosivity categories C3 – C4 with durability classes very high - medium.

| Paint                              |           | D1      | D2      |
|------------------------------------|-----------|---------|---------|
| TEKNOSYNT PRIMER 3                 | <b>AK</b> | 1x70 µm | 1x80 µm |
| TEKNOSYNT PRIMER 3                 | <b>AK</b> | 2x70 µm | 2x60 µm |
| TEKNOSYNT COMBI 50                 | <b>AK</b> | 1x50 µm |         |
| TEKNOSYNT 90                       | <b>AK</b> |         | 1x60 µm |
| Total film thickness               |           | 260 µm  | 260 µm  |
| Paint system VOC, g/m <sup>2</sup> |           | 263     | 276     |

| Example of Teknos paint system code | Example of paint system structure       |
|-------------------------------------|---|
| TEC3.04/VH/D1                       | ISO 12944-5/C3.04-AK (AK260/4-FeSa 2½)  |
| TEC4.03/H/D2                        | ISO 12944-5/C4.03-AK (AK260/4-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low      | Medium   | High     | Very high |
|--------------------------|----------|----------|----------|-----------|
| <b>C2.05</b>             | <b>X</b> | <b>X</b> | <b>X</b> |           |
| <b>C3.05</b>             | <b>X</b> | <b>X</b> |          |           |
| <b>C4.04</b>             | <b>X</b> |          |          |           |

**TEC2.05 High**  
**TEC3.05 Medium**  
**TEC4.04 Low**

## TEKNOPLAST PRIMER 3 / 5 Paint systems 120 µm

1 1.8.2018

TEKNOPLAST PRIMER 3 / 5 paint systems consist of an epoxy primer with good adhesion to the substrate and high corrosion protection properties. TEKNOPOX PRIMER 4 can also be used as a primer in these paint systems instead of TEKNOPLAST PRIMER 3 or 5.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid polyurethane top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C4 with durability classes high - low.

| Paint                              |            | EP-       | PUR-      |           |           |           |
|------------------------------------|------------|-----------|-----------|-----------|-----------|-----------|
|                                    |            | top coat  | top coat  |           |           |           |
|                                    |            | <b>B1</b> | <b>B2</b> | <b>B3</b> | <b>B4</b> | <b>B5</b> |
| TEKNOPLAST PRIMER 3 / 5            | <b>EP</b>  | 1x80 µm   | 1x80 µm   | 1x60 µm   | 1x60 µm   | 1x60 µm   |
| TEKNOPLAST 50 / 90                 | <b>EP</b>  | 1x40 µm   |           |           |           |           |
| TEKNODUR 0050 / 0090               | <b>PUR</b> |           | 1x40 µm   |           |           |           |
| TEKNODUR 3410-series               | <b>PUR</b> |           |           | 1x60 µm   |           |           |
| TEKNODUR COMBI 3430-series         | <b>PUR</b> |           |           |           | 1x60 µm   |           |
| TEKNODUR COMBI 340-811             | <b>PUR</b> |           |           |           |           | 1x60 µm   |
| Total film thickness               |            | 120 µm    | 120 µm    | 120 µm    | 120 µm    | 120 µm    |
| Paint system VOC, g/m <sup>2</sup> |            | 98        | 97 / 103  | 81 - 88   | 84 - 95   | 73        |

| Example of Teknos paint system code | Example of paint system structure              |
|-------------------------------------|--|
| TEC2.05/H/ <b>B1</b>                | ISO 12944-5/C2.05-EP (EP120/2-FeSa 2½).        |
| TEC3.05/M/ <b>B4</b>                | ISO 12944-5/C3.05-EP/PUR (EPPUR120/2-FeSa 2½). |
| TEC4.04/L/ <b>B5</b>                | ISO 12944-5/C4.04-EP/PUR (EPPUR120/2-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low      | Medium   | High     | Very high |
|--------------------------|----------|----------|----------|-----------|
| <b>C2.06</b>             | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>  |
| <b>C3.06</b>             | <b>X</b> | <b>X</b> | <b>X</b> |           |
| <b>C4.05</b>             | <b>X</b> | <b>X</b> |          |           |
| <b>C5.01</b>             | <b>X</b> |          |          |           |

**TEC2.06 Very high**  
**TEC3.06 High**  
**TEC4.05 Medium**  
**TEC5.01 Low**

**TEKNOPLAST PRIMER 3 / 5**  
**Paint systems 180 µm**

1 1.8.2018

TEKNOPLAST PRIMER 3 / 5 paint systems consist of an epoxy primer with good adhesion to the substrate and high corrosion protection properties. TEKNOPOX PRIMER 4 can also be used as a primer in these paint systems instead of TEKNOPLAST PRIMER 3 or 5.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing aspartic top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C5 with durability classes very high - low.

| Paint                              |     | EP-<br>top coat |          | PUR-<br>top coat |           |           |          | PAS-<br>top coat |
|------------------------------------|-----|-----------------|----------|------------------|-----------|-----------|----------|------------------|
|                                    |     | B1              | B2       | B3               | B4        | B5        | B6       | B7               |
| TEKNOPLAST PRIMER 3 / 5            | EP  | 1x100 µm        | 1x120 µm | 2x70 µm          | 1x100 µm  | 1x100 µm  | 1x100 µm | 1x100 µm         |
| TEKNOPLAST HS 150                  | EP  | 1x80 µm         |          |                  |           |           |          |                  |
| TEKNOPLAST 50 / 90                 | EP  |                 | 1x60 µm  |                  |           |           |          |                  |
| TEKNODUR 0050 / 0090               | PUR |                 |          | 1x40 µm          |           |           |          |                  |
| TEKNODUR 3410-series               | PUR |                 |          |                  | 1x80 µm   |           |          |                  |
| TEKNODUR COMBI 3430-series         | PUR |                 |          |                  |           | 1x80 µm   |          |                  |
| TEKNODUR COMBI 340-811             | PUR |                 |          |                  |           |           | 1x80 µm  |                  |
| TEKNODUR COMBI 3560-series         | PAS |                 |          |                  |           |           |          | 1x80 µm          |
| Total film thickness               |     | 180 µm          | 180 µm   | 180 µm           | 180 µm    | 180 µm    | 180 µm   | 180 µm           |
| Paint system VOC, g/m <sup>2</sup> |     | 118             | 148      | 147 / 153        | 126 - 135 | 130 - 144 | 115      | 89 - 132         |

| Example of Teknos paint system code | Example of paint system structure              |
|-------------------------------------|--|
| TEC2.06/VH/B1                       | ISO 12944-5/C2.06-EP (EP180/2-FeSa 2½).        |
| TEC3.06/H/B3                        | ISO 12944-5/C3.06-EP/PUR (EPPUR180/3-FeSa 2½). |
| TEC4.05/M/B4                        | ISO 12944-5/C4.05-EP/PUR (EPPUR180/2-FeSa 2½). |
| TEC5.01/L/B7                        | ISO 12944-5/C5.01-EP/PAS (EPPAS180/2-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low      | Medium   | High     | Very high |
|--------------------------|----------|----------|----------|-----------|
| <b>C3.07</b>             | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>  |
| <b>C4.06</b>             | <b>X</b> | <b>X</b> | <b>X</b> |           |
| <b>C5.02</b>             | <b>X</b> | <b>X</b> |          |           |

**TEC3.07 Very high**  
**TEC4.06 High**  
**TEC5.02 Medium**

**TEKNOPLAST PRIMER 3 / 5**  
**Paint systems 240 µm**

1 1.8.2018

TEKNOPLAST PRIMER 3 / 5 paint systems consist of an epoxy primer with good adhesion to the substrate and high corrosion protection properties. TEKNOPOX PRIMER 4 can also be used as a primer in these paint systems instead of TEKNOPLAST PRIMER 3 or 5.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing aspartic top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

| Paint                              |     | EP-top coat |          | PUR-top coat |           |           |         | PAS-top coat |
|------------------------------------|-----|-------------|----------|--------------|-----------|-----------|---------|--------------|
|                                    |     | B1          | B2       | B3           | B4        | B5        | B6      | B7           |
| TEKNOPLAST PRIMER 3 / 5            | EP  | 2x80 µm     | 2x100 µm | 2x100 µm     | 2x90 µm   | 2x80 µm   | 2x80 µm | 2x80 µm      |
| TEKNOPLAST HS 150                  | EP  | 1x80 µm     |          |              |           |           |         |              |
| TEKNOPLAST 50 / 90                 | EP  |             | 1x40 µm  |              |           |           |         |              |
| TEKNODUR 0050 / 0090               | PUR |             |          | 1x40 µm      |           |           |         |              |
| TEKNODUR 3410-series               | PUR |             |          |              | 1x60 µm   |           |         |              |
| TEKNODUR COMBI 3430-series         | PUR |             |          |              |           | 1x80 µm   |         |              |
| TEKNODUR COMBI 340-811             | PUR |             |          |              |           |           | 1x80 µm |              |
| TEKNODUR COMBI 3560-series         | PAS |             |          |              |           |           |         | 1x80 µm      |
| Total film thickness               |     | 240 µm      | 240 µm   | 240 µm       | 240 µm    | 240 µm    | 240 µm  | 240 µm       |
| Paint system VOC, g/m <sup>2</sup> |     | 166         | 200      | 198 / 204    | 181 - 188 | 179 - 193 | 165     | 138 - 181    |

| Example of Teknos paint system code | Example of paint system structure              |
|-------------------------------------|--|
| TEC3.07/VH/B1                       | ISO 12944-5/C3.07-EP (EP240/3-FeSa 2½).        |
| TEC4.06/H/B3                        | ISO 12944-5/C4.06-EP/PUR (EPPUR240/3-FeSa 2½). |
| TEC5.02/M/B7                        | ISO 12944-5/C5.02-EP/PAS (EPPAS240/3-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low      | Medium   | High     | Very high |
|--------------------------|----------|----------|----------|-----------|
| <b>C4.07</b>             | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>  |
| <b>C5.03</b>             | <b>X</b> | <b>X</b> | <b>X</b> |           |

**TEC4.07 Very high**  
**TEC5.03 High**

# TEKNOPLAST PRIMER 3 / 5

## Paint systems 300 µm

1 1.8.2018

TEKNOPLAST PRIMER 3 / 5 paint systems consist of an epoxy primer with good adhesion to the substrate and high corrosion protection properties. TEKNOPOX PRIMER 4 can also be used as a primer in these paint systems instead of TEKNOPLAST PRIMER 3 or 5.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing aspartic top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C4 – C5 with durability classes very high - high.

| Paint                              |     | EP-top coat |          | PUR-top coat |           |           |          | PAS-top coat |
|------------------------------------|-----|-------------|----------|--------------|-----------|-----------|----------|--------------|
|                                    |     | B1          | B2       | B3           | B4        | B5        | B6       | B7           |
| TEKNOPLAST PRIMER 3 / 5            | EP  | 2x100 µm    | 2x120 µm | 1x100 µm     | 2x120 µm  | 2x100 µm  | 2x100 µm | 2x100 µm     |
| TEKNOPLAST HS 150                  | EP  | 1x100 µm    |          |              |           |           |          |              |
| TEKNOPLAST PRIMER 3 / 5            | EP  |             |          | 2x80 µm      |           |           |          |              |
| TEKNOPLAST 50 / 90                 | EP  |             | 1x60 µm  |              |           |           |          |              |
| TEKNODUR 0050 / 0090               | PUR |             |          | 1x40 µm      |           |           |          |              |
| TEKNODUR 3410-series               | PUR |             |          |              | 1x60 µm   |           |          |              |
| TEKNODUR COMBI 3430-series         | PUR |             |          |              |           | 1x100 µm  |          |              |
| TEKNODUR COMBI 340-811             | PUR |             |          |              |           |           | 1x100 µm |              |
| TEKNODUR COMBI 3560-series         | PAS |             |          |              |           |           |          | 1x100 µm     |
| Total film thickness               |     | 300 µm      | 300 µm   | 300 µm       | 300 µm    | 300 µm    | 300 µm   | 300 µm       |
| Paint system VOC, g/m <sup>2</sup> |     | 210         | 247      | 247 / 254    | 230 - 237 | 224 - 242 | 206      | 173 - 227    |

| Example of Teknos paint system code | Example of paint system structure              |
|-------------------------------------|--|
| TEC4.07/VH/B1                       | ISO 12944-5/C4.07-EP (EP300/3-FeSa 2½).        |
| TEC5.03/H/B7                        | ISO 12944-5/C5.03-EP/PAS (EPPAS300/3-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low      | Medium   | High     | Very<br>high |
|-----------------------------|----------|----------|----------|--------------|
| <b>C5.04</b>                | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>     |

**TEC5.04 Very high**

# TEKNOPLAST PRIMER 3 / 5

## Paint systems 360 µm

1 1.8.2018

TEKNOPLAST PRIMER 3 / 5 paint systems consist of an epoxy primer with good adhesion to the substrate and high corrosion protection properties. TEKNOPOX PRIMER 4 can also be used as a primer in these paint systems instead of TEKNOPLAST PRIMER 3 or 5.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing aspartic top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity category C5 with durability class very high.

| Paint                              |     | EP-<br>top coat |          | PUR-<br>top coat |           |           |          | PAS-<br>top coat |
|------------------------------------|-----|-----------------|----------|------------------|-----------|-----------|----------|------------------|
|                                    |     | B1              | B2       | B3               | B4        | B5        | B6       | B7               |
| TEKNOPLAST PRIMER 3 / 5            | EP  | 2x120 µm        | 3x100 µm | 1x100 µm         | 1x100 µm  | 1x100 µm  | 1x100 µm | 1x100 µm         |
| TEKNOPLAST HS 150                  | EP  | 1x120 µm        |          |                  |           |           |          |                  |
| TEKNOPLAST PRIMER 3 / 5            | EP  |                 |          | 2x110 µm         | 2x80 µm   | 2x80 µm   | 2x80 µm  | 2x80 µm          |
| TEKNOPLAST 50 / 90                 | EP  |                 | 1x60 µm  |                  |           |           |          |                  |
| TEKNODUR 0050 / 0090               | PUR |                 |          | 1x40 µm          |           |           |          |                  |
| TEKNODUR 3410-series               | PUR |                 |          |                  | 1x100 µm  |           |          |                  |
| TEKNODUR COMBI 3430-series         | PUR |                 |          |                  |           | 1x100 µm  |          |                  |
| TEKNODUR COMBI 340-811             | PUR |                 |          |                  |           |           | 1x100 µm |                  |
| TEKNODUR COMBI 3560-series         | PAS |                 |          |                  |           |           |          | 1x100 µm         |
| Total film thickness               |     | 360 µm          | 360 µm   | 360 µm           | 360 µm    | 360 µm    | 360 µm   | 360 µm           |
| Paint system VOC, g/m <sup>2</sup> |     | 249             | 299      | 297 / 303        | 269 - 278 | 273 - 291 | 255      | 222 - 276        |

| Example of Teknos paint system code | Example of paint system structure              |
|-------------------------------------|--|
| TEC5.04/VH/B3                       | ISO 12944-5/C5.04-EP/PUR (EPPUR360/4-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low      | Medium   | High     | Very<br>high |
|-----------------------------|----------|----------|----------|--------------|
| <b>C2.08</b>                | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>     |
| <b>C3.09</b>                | <b>X</b> | <b>X</b> | <b>X</b> |              |
| <b>C4.09</b>                | <b>X</b> | <b>X</b> |          |              |
| <b>C5.05</b>                | <b>X</b> |          |          |              |

**TEC2.08 Very high**  
**TEC3.09 High**  
**TEC4.09 Medium**  
**TEC5.05 Low**

## TEKNOZINC 3480 SE, High Solid TOP COATS Paint systems 160 µm

1 1.8.2018

TEKNOZINC 3480 SE zinc rich paint systems consist of high-solid zinc rich epoxy primer, which can be applied with film thicknesses between 60–80 µm.

Paint systems, containing zinc rich TEKNOZINC 3480 SE primer, give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy or polyurethane chemistry. Chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C5 with durability classes very high - low.

|                                    |     | EP-<br>top coat | PUR-<br>top coat |
|------------------------------------|-----|-----------------|------------------|
| Paint                              |     | B1              | B2               |
| TEKNOZINC 3480 SE                  | EP  | 1x60 µm         | 1x60 µm          |
| TEKNOPLAST HS 150                  | EP  | 1x100 µm        |                  |
| TEKNODUR COMBI 3430-series         | PUR |                 | 1x100 µm         |
| Total film thickness               |     | 160 µm          | 160 µm           |
| Paint system VOC, g/m <sup>2</sup> |     | 70              | 84 – 102         |

| Example of Teknos paint system code | Example of paint system structure                        |
|-------------------------------------|--|
| TEC2.08/VH/B1                       | ISO 12944-5/C2.08-EPZn(R)/EP (EPZn(R)EP160/2-FeSa 2½).   |
| TEC3.09/H/B2                        | ISO 12944-5/C3.09-EPZn(R)/PUR (EPZn(R)PUR160/2-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.



**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low      | Medium   | High     | Very<br>high |
|-----------------------------|----------|----------|----------|--------------|
| <b>C3.10</b>                | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>     |
| <b>C4.10</b>                | <b>X</b> | <b>X</b> | <b>X</b> |              |
| <b>C5.06</b>                | <b>X</b> | <b>X</b> |          |              |

**TEC3.10 Very high**  
**TEC4.10 High**  
**TEC5.06 Medium**

## TEKNOZINC 3480 SE, High Solid TOP COATS Paint systems 200 µm

1 1.8.2018

TEKNOZINC 3480 SE zinc rich paint systems consist of high-solid zinc rich epoxy primer, which can be applied with film thicknesses between 60–80 µm.

Paint systems, containing zinc rich TEKNOZINC 3480 SE primer, give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy or polyurethane chemistry. Chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

|                                    |            | EP-<br>top coat | PUR-<br>top coat |
|------------------------------------|------------|-----------------|------------------|
| <b>Paint</b>                       |            | <b>B1</b>       | <b>B2</b>        |
| TEKNOZINC 3480 SE                  | <b>EP</b>  | 1x80 µm         | 1x80 µm          |
| TEKNOPLAST HS 150                  | <b>EP</b>  | 1x120 µm        |                  |
| TEKNODUR COMBI 3430-series         | <b>PUR</b> |                 | 1x120 µm         |
| Total film thickness               |            | 200 µm          | 200 µm           |
| Paint system VOC, g/m <sup>2</sup> |            | 88              | 105 - 126        |

| Example of Teknos paint system code | Example of paint system structure                        |
|-------------------------------------|--|
| TEC3.10/VH/B1                       | ISO 12944-5/C3.10-EPZn(R)/EP (EPZn(R)EP200/2-FeSa 2½).   |
| TEC4.10/H/B2                        | ISO 12944-5/C4.10-EPZn(R)/PUR (EPZn(R)PUR200/2-FeSa 2½). |
| TEC5.06/M/B1                        | ISO 12944-5/C5.06-EPZn(R)/EP (EPZn(R)EP200/2-FeSa 2½).   |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low      | Medium   | High     | Very high |
|--------------------------|----------|----------|----------|-----------|
| <b>C4.11</b>             | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>  |
| <b>C5.07</b>             | <b>X</b> | <b>X</b> | <b>X</b> |           |

**TEC4.11 Very high**  
**TEC5.07 High**

# TEKNOZINC 3480 SE, High Solid TOP COATS

## Paint systems 260 µm

1 1.8.2018

TEKNOZINC 3480 SE zinc rich paint systems consist of high-solid zinc rich epoxy primer, which can be applied with film thicknesses between 60–80 µm.

Paint systems, containing zinc rich TEKNOZINC 3480 SE primer, give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy or polyurethane chemistry. Chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C4 – C5 with durability classes very high - high.

|                                    |            | EP-<br>top coat | PUR-<br>top coat |
|------------------------------------|------------|-----------------|------------------|
| <b>Paint</b>                       |            | <b>B1</b>       | <b>B2</b>        |
| TEKNOZINC 3480 SE                  | <b>EP</b>  | 1x60 µm         | 1x60 µm          |
| TEKNOPLAST HS 150                  | <b>EP</b>  | 2x100 µm        |                  |
| TEKNODUR COMBI 3430-series         | <b>PUR</b> |                 | 2x100 µm         |
| Total film thickness               |            | 260 µm          | 260 µm           |
| Paint system VOC, g/m <sup>2</sup> |            | 113             | 79 – 94          |

| Example of Teknos paint system code | Example of paint system structure                        |
|-------------------------------------|--|
| TEC4.11/VH/B1                       | ISO 12944-5/C4.10-EPZn(R)/EP (EPZn(R)EP260/3-FeSa 2½).   |
| TEC5.07/H/B2                        | ISO 12944-5/C5.07-EPZn(R)/PUR (EPZn(R)PUR260/3-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very high |
|-----------------------------|-----|--------|------|-----------|
| C5.08                       | X   | X      | X    | X         |

**TEC5.08 Very high**

## TEKNOZINC 3480 SE, High Solid TOP COATS Paint systems 320 µm

1 1.8.2018

TEKNOZINC 3480 SE zinc rich paint systems consist of high-solid zinc rich epoxy primer, which can be applied with film thicknesses between 60–80 µm.

Paint systems, containing zinc rich TEKNOZINC 3480 SE primer, give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy or polyurethane chemistry. Chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity category C5 with durability class very high.

|                                    |            | EP-<br>top coat | PUR-<br>top coat |
|------------------------------------|------------|-----------------|------------------|
| <b>Paint</b>                       |            | <b>B1</b>       | <b>B2</b>        |
| TEKNOZINC 3480 SE                  | <b>EP</b>  | 1x60 µm         | 1x60 µm          |
| TEKNOPLAST HS 150                  | <b>EP</b>  | 2x130 µm        |                  |
| TEKNODUR COMBI 3430-series         | <b>PUR</b> |                 | 2x130 µm         |
| Total film thickness               |            | 320 µm          | 320 µm           |
| Paint system VOC, g/m <sup>2</sup> |            | 138             | 102 - 124        |

| Example of Teknos paint system code | Example of paint system structure                      |
|-------------------------------------|--|
| TEC5.08/VH/B1                       | ISO 12944-5/C5.08-EPZn(R)/EP (EPZn(R)EP320/3-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very<br>high |
|-----------------------------|-----|--------|------|--------------|
| C2.01                       | X   |        |      |              |

**TEC2.01 Low**

# TEKNOCRYL PRIMER 3-11

## Paint systems 80 µm

1 1.8.2018

TEKNOCRYL PRIMER 3-11 paint system is an acrylic based physically drying paint system with good adhesion to the substrate and good corrosion protection properties.

These paint systems are designed for corrosivity category C2 with durability class low.

| Paint                              |    | E1      |
|------------------------------------|----|---------|
| TEKNOCRYL PRIMER 3-11              | AY | 1x40 µm |
| TEKNOCRYL 100-500                  | AY | 1x40 µm |
| Total film thickness               |    | 80 µm   |
| Paint system VOC, g/m <sup>2</sup> |    | 78      |

| Example of Teknos paint system code | Example of paint system structure      |
|-------------------------------------|--|
| TEC2.01/L/E1                        | ISO 12944-5/C2.01-AY (AY80/2-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low      | Medium   | High | Very<br>high |
|-----------------------------|----------|----------|------|--------------|
| <b>C2.02</b>                | <b>X</b> | <b>X</b> |      |              |
| <b>C3.01</b>                | <b>X</b> |          |      |              |

**TEC2.02 Medium**  
**TEC3.01 Low**

# TEKNOCRYL PRIMER 3-11

## Paint systems 100 µm

1 1.8.2018

TEKNOCRYL PRIMER 3-11 paint system is an acrylic based physically drying paint system with good adhesion to the substrate and good corrosion protection properties.

These paint systems are designed for corrosivity categories C2 – C3 with durability classes medium - low.

| Paint                              |           | E1      |
|------------------------------------|-----------|---------|
| TEKNOCRYL PRIMER 3-11              | <b>AY</b> | 1x60 µm |
| TEKNOCRYL 100-500                  | <b>AY</b> | 1x40 µm |
| Total film thickness               |           | 100 µm  |
| Paint system VOC, g/m <sup>2</sup> |           | 96      |

| Example of Teknos paint system code | Example of paint system structure       |
|-------------------------------------|---|
| TEC2.02/M/E1                        | ISO 12944-5/C2.02-AY (AY100/2-FeSa 2½). |
| TEC3.01/L/E1                        | ISO 12944-5/C3.01-AY (AY100/2-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low      | Medium   | High     | Very<br>high |
|-----------------------------|----------|----------|----------|--------------|
| <b>C2.04</b>                | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>     |
| <b>C3.03</b>                | <b>X</b> | <b>X</b> | <b>X</b> |              |
| <b>C4.02</b>                | <b>X</b> | <b>X</b> |          |              |

**TEC2.04 Very high**  
**TEC3.03 High**  
**TEC4.02 Medium**

# TEKNOCRYL PRIMER 3-11

## Paint systems 200 µm

1 1.8.2018

TEKNOCRYL PRIMER 3-11 paint system is an acrylic based physically drying paint system with good adhesion to the substrate and good corrosion protection properties.

These paint systems are designed for corrosivity categories C2 – C4 with durability classes very high - medium.

| Paint                              |           | E1      |
|------------------------------------|-----------|---------|
| TEKNOCRYL PRIMER 3-11              | <b>AY</b> | 2x80 µm |
| TEKNOCRYL 100-500                  | <b>AY</b> | 1x40 µm |
| Total film thickness               |           | 200 µm  |
| Paint system VOC, g/m <sup>2</sup> |           | 181     |

| Example of Teknos paint system code | Example of paint system structure       |
|-------------------------------------|---|
| TEC2.04/VH/E1                       | ISO 12944-5/C2.04-AY (AY200/3-FeSa 2½). |
| TEC3.03/H/E1                        | ISO 12944-5/C3.03-AY (AY200/3-FeSa 2½). |
| TEC4.02/M/E1                        | ISO 12944-5/C4.02-AY (AY200/3-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low      | Medium   | High     | Very<br>high |
|-----------------------------|----------|----------|----------|--------------|
| <b>C3.04</b>                | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>     |
| <b>C4.03</b>                | <b>X</b> | <b>X</b> | <b>X</b> |              |

**TEC3.04 Very high**  
**TEC4.03 High**

# TEKNOCRYL PRIMER 3-11

## Paint systems 260 µm

1 1.8.2018

TEKNOCRYL PRIMER 3-11 paint system is an acrylic based physically drying paint system with good adhesion to the substrate and good corrosion protection properties.

These paint systems are designed for corrosivity categories C3 – C4 with durability classes very high – high.

| Paint                              |           | E1      |
|------------------------------------|-----------|---------|
| TEKNOCRYL PRIMER 3-11              | <b>AY</b> | 1x60 µm |
| TEKNOCRYL PRIMER 3-11              | <b>AY</b> | 2x80 µm |
| TEKNOCRYL 100-500                  | <b>AY</b> | 1x40 µm |
| Total film thickness               |           | 260 µm  |
| Paint system VOC, g/m <sup>2</sup> |           | 233     |

| Example of Teknos paint system code | Example of paint system structure       |
|-------------------------------------|---|
| TEC3.04/VH/E1                       | ISO 12944-5/C3.04-AY (AY260/4-FeSa 2½). |
| TEC4.03/H/E1                        | ISO 12944-5/C4.03-AY (AY260/4-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low      | Medium   | High     | Very high |
|-----------------------------|----------|----------|----------|-----------|
| <b>C2.05</b>                | <b>X</b> | <b>X</b> | <b>X</b> |           |
| <b>C3.05</b>                | <b>X</b> | <b>X</b> |          |           |
| <b>C4.04</b>                | <b>X</b> |          |          |           |

**TEC2.05 High**  
**TEC3.05 Medium**  
**TEC4.04 Low**

# TEKNOPLAST PRIMER 7

## Paint systems 120 µm

1 1.8.2018

TEKNOPLAST PRIMER 7 paint systems consist of an high-solid epoxy primer with good adhesion to the substrate and high corrosion protection properties.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid polyurethane top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C4 with durability classes high - low.

| Paint                              |            | EP-<br>top coat | PUR-<br>top coat |         |
|------------------------------------|------------|-----------------|------------------|---------|
|                                    |            | D1              | D2               | D3      |
| TEKNOPLAST PRIMER 7                | <b>EP</b>  | 1x80 µm         | 1x80 µm          | 1x80 µm |
| TEKNOPLAST 50 / 90                 | <b>EP</b>  | 1x40 µm         |                  |         |
| TEKNODUR 0050 / 0090               | <b>PUR</b> |                 | 1x40 µm          |         |
| TEKNODUR 3410-series               | <b>PUR</b> |                 |                  | 1x40 µm |
| Total film thickness               |            | 120 µm          | 120 µm           | 120 µm  |
| Paint system VOC, g/m <sup>2</sup> |            | 66              | 65 / 71          | 55 - 59 |

| Example of Teknos paint system code | Example of paint system structure              |
|-------------------------------------|--|
| TEC2.05/H/D1                        | ISO 12944-5/C2.05-EP (EP120/2-FeSa 2½).        |
| TEC3.05/M/D2                        | ISO 12944-5/C3.05-EP/PUR (EPPUR120/2-FeSa 2½). |
| TEC4.04/L/D3                        | ISO 12944-5/C4.04-EP/PUR (EPPUR120/2-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.



**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low      | Medium   | High     | Very high |
|--------------------------|----------|----------|----------|-----------|
| <b>C2.06</b>             | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>  |
| <b>C3.06</b>             | <b>X</b> | <b>X</b> | <b>X</b> |           |
| <b>C4.05</b>             | <b>X</b> | <b>X</b> |          |           |
| <b>C5.01</b>             | <b>X</b> |          |          |           |

**TEC2.06 Very high**  
**TEC3.06 High**  
**TEC4.05 Medium**  
**TEC5.01 Low**

**TEKNOPLAST PRIMER 7**  
**Paint systems 180 µm**

1 1.8.2018

TEKNOPLAST PRIMER 7 paint systems consist of an high-solid epoxy primer with good adhesion to the substrate and high corrosion protection properties.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing polyaspartic top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C5 with durability classes very high - low.

| Paint                              |            | EP-<br>top coat |          | PUR-<br>top coat |          |          |          | PAS-<br>top coat |
|------------------------------------|------------|-----------------|----------|------------------|----------|----------|----------|------------------|
|                                    |            | D1              | D2       | D3               | D4       | D5       | D6       | D7               |
| TEKNOPLAST PRIMER 7                | <b>EP</b>  | 1x100 µm        | 1x140 µm | 1x140 µm         | 1x100 µm | 1x100 µm | 1x100 µm | 1x100 µm         |
| TEKNOPLAST HS 150                  | <b>EP</b>  | 1x80 µm         |          |                  |          |          |          |                  |
| TEKNOPLAST 50 / 90                 | <b>EP</b>  |                 | 1x40 µm  |                  |          |          |          |                  |
| TEKNODUR 0050 / 0090               | <b>PUR</b> |                 |          | 1x40 µm          |          |          |          |                  |
| TEKNODUR 3410-series               | <b>PUR</b> |                 |          |                  | 1x80 µm  |          |          |                  |
| TEKNODUR COMBI 3430-series         | <b>PUR</b> |                 |          |                  |          | 1x80 µm  |          |                  |
| TEKNODUR COMBI 340-811             | <b>PUR</b> |                 |          |                  |          |          | 1x80 µm  |                  |
| TEKNODUR COMBI 3560-series         | <b>PAS</b> |                 |          |                  |          |          |          | 1x80 µm          |
| Total film thickness               |            | 180 µm          | 180 µm   | 180 µm           | 180 µm   | 180 µm   | 180 µm   | 180 µm           |
| Paint system VOC, g/m <sup>2</sup> |            | 77              | 92       | 91 - 97          | 85 - 94  | 89 - 103 | 74       | 48 - 91          |

| Example of Teknos paint system code | Example of paint system structure              |
|-------------------------------------|--|
| TEC2.06/VH/D1                       | ISO 12944-5/C2.06-EP (EP180/2-FeSa 2½).        |
| TEC3.06/H/D3                        | ISO 12944-5/C3.06-EP/PUR (EPPUR180/2-FeSa 2½). |
| TEC4.05/M/D4                        | ISO 12944-5/C4.05-EP/PUR (EPPUR180/2-FeSa 2½). |
| TEC5.01/L/D7                        | ISO 12944-5/C5.01-EP/PAS (EPPAS180/2-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very high |
|-----------------------------|-----|--------|------|-----------|
| <b>C3.07</b>                | X   | X      | X    | X         |
| <b>C4.06</b>                | X   | X      | X    |           |
| <b>C5.02</b>                | X   | X      |      |           |

**TEC3.07 Very high**  
**TEC4.06 High**  
**TEC5.02 Medium**

# TEKNOPLAST PRIMER 7

## Paint systems 240 µm

1 1.8.2018

TEKNOPLAST PRIMER 7 paint systems consist of an high-solid epoxy primer with good adhesion to the substrate and high corrosion protection properties.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing polyaspartic top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

| Paint                              |     | EP-<br>top coat |          | PUR-<br>top coat |           |           |          | PAS-<br>top coat |
|------------------------------------|-----|-----------------|----------|------------------|-----------|-----------|----------|------------------|
|                                    |     | D1              | D2       | D3               | D4        | D5        | D6       | D7               |
| TEKNOPLAST PRIMER 7                | EP  | 1x160 µm        | 2x100 µm | 2x100 µm         | 1x160 µm  | 1x160 µm  | 1x160 µm | 1x160 µm         |
| TEKNOPLAST HS 150                  | EP  | 1x80 µm         |          |                  |           |           |          |                  |
| TEKNOPLAST 50 / 90                 | EP  |                 | 1x40 µm  |                  |           |           |          |                  |
| TEKNODUR 0050 / 0090               | PUR |                 |          | 1x40 µm          |           |           |          |                  |
| TEKNODUR 3410-series               | PUR |                 |          |                  | 1x80 µm   |           |          |                  |
| TEKNODUR COMBI 3430-series         | PUR |                 |          |                  |           | 1x80 µm   |          |                  |
| TEKNODUR COMBI 340-811             | PUR |                 |          |                  |           |           | 1x80 µm  |                  |
| TEKNODUR COMBI 3560-series         | PAS |                 |          |                  |           |           |          | 1x80 µm          |
| Total film thickness               |     | 240 µm          | 240 µm   | 240 µm           | 240 µm    | 240 µm    | 240 µm   | 240 µm           |
| Paint system VOC, g/m <sup>2</sup> |     | 103             | 117      | 116 / 122        | 110 - 119 | 114 - 128 | 100      | 73 - 116         |

| Example of Teknos paint system code | Example of paint system structure              |
|-------------------------------------|--|
| TEC3.07/VH/D1                       | ISO 12944-5/C3.07-EP (EP240/2-FeSa 2½).        |
| TEC4.06/H/D3                        | ISO 12944-5/C4.06-EP/PUR (EPPUR240/2-FeSa 2½). |
| TEC5.02/M/D7                        | ISO 12944-5/C5.02-EP/PAS (EPPAS240/2-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low | Medium | High | Very high |
|--------------------------|-----|--------|------|-----------|
| <b>C4.07</b>             | X   | X      | X    | X         |
| <b>C5.03</b>             | X   | X      | X    |           |

**TEC4.07 Very high**  
**TEC5.03 High**

# TEKNOPLAST PRIMER 7

## Paint systems 300 µm

1 1.8.2018

TEKNOPLAST PRIMER 7 paint systems consist of an high-solid epoxy primer with good adhesion to the substrate and high corrosion protection properties.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing polyaspartic top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C4 – C5 with durability classes very high - high.

| Paint                              |     | EP-<br>top coat |          | PUR-<br>top coat |           |           |          | PAS-<br>top coat |
|------------------------------------|-----|-----------------|----------|------------------|-----------|-----------|----------|------------------|
|                                    |     | D1              | D2       | D3               | D4        | D5        | D6       | D7               |
| TEKNOPLAST PRIMER 7                | EP  | 2x100 µm        | 2x130 µm | 2x130 µm         | 2x120 µm  | 2x100 µm  | 2x100 µm | 2x100 µm         |
| TEKNOPLAST HS 150                  | EP  | 1x100 µm        |          |                  |           |           |          |                  |
| TEKNOPLAST 50 / 90                 | EP  |                 | 1x40 µm  |                  |           |           |          |                  |
| TEKNODUR 0050 / 0090               | PUR |                 |          | 1x40 µm          |           |           |          |                  |
| TEKNODUR 3410-series               | PUR |                 |          |                  | 1x60 µm   |           |          |                  |
| TEKNODUR COMBI 3430-series         | PUR |                 |          |                  |           | 1x100 µm  |          |                  |
| TEKNODUR COMBI 340-811             | PUR |                 |          |                  |           |           | 1x100 µm |                  |
| TEKNODUR COMBI 3560-series         | PAS |                 |          |                  |           |           |          | 1x100 µm         |
| Total film thickness               |     | 300 µm          | 300 µm   | 300 µm           | 300 µm    | 300 µm    | 300 µm   | 300 µm           |
| Paint system VOC, g/m <sup>2</sup> |     | 128             | 143      | 142 / 148        | 134 - 141 | 142 - 160 | 124      | 91 - 145         |

| Example of Teknos paint system code | Example of paint system structure              |
|-------------------------------------|--|
| TEC4.07/VH/D3                       | ISO 12944-5/C4.07-EP/PUR (EPPUR300/3-FeSa 2½). |
| TEC5.03/H/D7                        | ISO 12944-5/C5.03-EP/PAS (EPPAS300/3-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low | Medium | High | Very high |
|--------------------------|-----|--------|------|-----------|
| C5.04                    | X   | X      | X    | X         |

**TEC5.04 Very high**

**TEKNOPLAST PRIMER 7**  
**Paint systems 360 µm**

1 1.8.2018

TEKNOPLAST PRIMER 7 paint systems consist of an high-solid epoxy primer with good adhesion to the substrate and high corrosion protection properties.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing polyaspartic top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity category C5 with durability class very high.

| Paint                              |     | EP-top coat |          | PUR-top coat |           |           |          | PAS-top coat |
|------------------------------------|-----|-------------|----------|--------------|-----------|-----------|----------|--------------|
|                                    |     | D1          | D2       | D3           | D4        | D5        | D6       | D7           |
| TEKNOPLAST PRIMER 7                | EP  | 2x130 µm    | 2x160 µm | 2x160 µm     | 2x130 µm  | 2x130 µm  | 2x130 µm | 2x120 µm     |
| TEKNOPLAST HS 150                  | EP  | 1x100 µm    |          |              |           |           |          |              |
| TEKNOPLAST 50 / 90                 | EP  |             | 1x40 µm  |              |           |           |          |              |
| TEKNODUR 0050 / 0090               | PUR |             |          | 1x40 µm      |           |           |          |              |
| TEKNODUR 3410-series               | PUR |             |          |              | 1x100 µm  |           |          |              |
| TEKNODUR COMBI 3430-series         | PUR |             |          |              |           | 1x100 µm  |          |              |
| TEKNODUR COMBI 340-811             | PUR |             |          |              |           |           | 1x100 µm |              |
| TEKNODUR COMBI 3560-series         | PAS |             |          |              |           |           |          | 1x120 µm     |
| Total film thickness               |     | 360 µm      | 360 µm   | 360 µm       | 360 µm    | 360 µm    | 360 µm   | 360 µm       |
| Paint system VOC, g/m <sup>2</sup> |     | 154         | 169      | 167 / 174    | 164 - 175 | 168 - 186 | 150      | 109 - 163    |

| Example of Teknos paint system code | Example of paint system structure              |
|-------------------------------------|--|
| TEC5.04/VH/D3                       | ISO 12944-5/C5.04-EP/PUR (EPPUR360/3-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low      | Medium   | High     | Very high |
|--------------------------|----------|----------|----------|-----------|
| <b>C3.10</b>             | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>  |
| <b>C4.10</b>             | <b>X</b> | <b>X</b> | <b>X</b> |           |
| <b>C5.06</b>             | <b>X</b> | <b>X</b> |          |           |

**TEC3.10 Very high**  
**TEC4.10 High**  
**TEC5.06 Medium**

**TEKNOZINC 80 SE**  
**Paint systems 200 µm**

1 1.8.2018

TEKNOZINC 80 SE paint systems consist of different paints where the primer is a 2-component zinc epoxy paint containing at least 80% zinc by weight in the dry paint film.

Paint systems, containing zinc rich TEKNOZINC 80 SE primer, give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy or polyurethane chemistry. Some of chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

| Paint                              |     | EP-<br>top coat |          | PUR-<br>top coat |           |           |          |
|------------------------------------|-----|-----------------|----------|------------------|-----------|-----------|----------|
|                                    |     | D1              | D2       | D3               | D4        | D5        | D6       |
| TEKNOZINC 80 SE                    | EP  | 1x60 µm         | 1x60 µm  | 1x60 µm          | 1x60 µm   | 1x60 µm   | 1x60 µm  |
| TEKNOPLAST PRIMER 3 / 5            | EP  | 1x100 µm        |          | 1x100 µm         |           |           |          |
| TEKNOPLAST PRIMER 7                | EP  |                 | 1x100 µm |                  | 1x100 µm  | 1x80 µm   |          |
| TEKNOPOX PRIMER 9-00               | EP  |                 |          |                  |           |           | 1x100 µm |
| TEKNOPLAST 50/90                   | EP  | 1x40 µm         | 1x40 µm  |                  |           |           |          |
| TEKNODUR 0050/0090                 | PUR |                 |          | 1x40 µm          | 1x40 µm   |           |          |
| TEKNODUR 3410-series               | PUR |                 |          |                  |           | 1x60 µm   |          |
| TEKNODUR 100 9-00                  | PUR |                 |          |                  |           |           | 1x40 µm  |
| Total film thickness               |     | 200 µm          | 200 µm   | 200 µm           | 200 µm    | 200 µm    | 200 µm   |
| Paint system VOC, g/m <sup>2</sup> |     | 170             | 129      | 168 / 174        | 127 / 133 | 119 - 126 | 147      |

| Example of Teknos paint system code | Example of paint system structure                            |
|-------------------------------------|--|
| TEC3.10/VH/D1                       | ISO 12944-5/C3.10-EPZn(R)/EP (EPZn(R)EP200/3-FeSa 2½)        |
| TEC4.10/H/D3                        | ISO 12944-5/C4.10-EPZn(R)/EP/PUR (EPZn(R)EPPUR200/3-FeSa 2½) |
| TEC5.06/M/D5                        | ISO 12944-5/C5.06-EPZn(R)/EP/PUR (EPZn(R)EPPUR200/3-FeSa 2½) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low      | Medium   | High     | Very high |
|--------------------------|----------|----------|----------|-----------|
| <b>C4.11</b>             | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>  |
| <b>C5.07</b>             | <b>X</b> | <b>X</b> | <b>X</b> |           |

**TEC4.11 Very high**  
**TEC5.07 High**

## TEKNOZINC 80 SE Paint systems 260 µm

1 1.8.2018

TEKNOZINC 80 SE paint systems consist of different paints where the primer is a 2-component zinc epoxy paint containing at least 80% zinc by weight in the dry paint film.

Paint systems, containing zinc rich TEKNOZINC 80 SE primer, give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy or polyurethane chemistry. Some of chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C4 – C5 with durability classes very high - high.

| Paint                              |     | EP-<br>top coat |         | PUR-<br>top coat |           |           |         |
|------------------------------------|-----|-----------------|---------|------------------|-----------|-----------|---------|
|                                    |     | D1              | D2      | D3               | D4        | D5        | D6      |
| TEKNOZINC 80 SE                    | EP  | 1x60 µm         | 1x60 µm | 1x60 µm          | 1x60 µm   | 1x60 µm   | 1x60 µm |
| TEKNOPLAST PRIMER 3 / 5            | EP  | 2x80 µm         |         | 2x80 µm          |           |           |         |
| TEKNOPLAST PRIMER 7                | EP  |                 | 2x80 µm |                  | 2x80 µm   | 1x120 µm  |         |
| TEKNOPOX PRIMER 9-00               | EP  |                 |         |                  |           |           | 2x80 µm |
| TEKNOPLAST 50/90                   | EP  | 1x40 µm         | 1x40 µm |                  |           |           |         |
| TEKNODUR 0050/0090                 | PUR |                 |         | 1x40 µm          | 1x40 µm   |           |         |
| TEKNODUR 3410-series               | PUR |                 |         |                  |           | 1x80 µm   |         |
| TEKNODUR 100 9-00                  | PUR |                 |         |                  |           |           | 1x40 µm |
| Total film thickness               |     | 260 µm          | 260 µm  | 260 µm           | 260 µm    | 260 µm    | 260 µm  |
| Paint system VOC, g/m <sup>2</sup> |     | 218             | 155     | 217 / 223        | 153 / 159 | 147 - 156 | 181     |

| Example of Teknos paint system code | Example of paint system structure                            |
|-------------------------------------|--|
| TEC4.11/VH/D1                       | ISO 12944-5/C4.11-EPZn(R)/EP (EPZn(R)EP260/4-FeSa 2½)        |
| TEC5.07/H/D3                        | ISO 12944-5/C5.07-EPZn(R)/EP/PUR (EPZn(R)EPPUR260/4-FeSa 2½) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very<br>high |
|-----------------------------|-----|--------|------|--------------|
| C5.08                       | X   | X      | X    | X            |

**TEC5.08 Very high**

**TEKNOZINC 80 SE  
Paint systems 320 µm**

1 1.8.2018

TEKNOZINC 80 SE paint systems consist of different paints where the primer is a 2-component zinc epoxy paint containing at least 80% zinc by weight in the dry paint film.

Paint systems, containing zinc rich TEKNOZINC 80 SE primer, give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy or polyurethane chemistry. Some of chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity category C5 with durability class very high.

| Paint                              |     | EP-<br>top coat | PUR-<br>top coat |           |          |
|------------------------------------|-----|-----------------|------------------|-----------|----------|
|                                    |     | D1              | D2               | D3        | D4       |
| TEKNOZINC 80 SE                    | EP  | 1x60 µm         | 1x60 µm          | 1x60 µm   | 1x60 µm  |
| TEKNOPLAST PRIMER 7                | EP  | 2x110 µm        | 2x110 µm         | 2x100 µm  |          |
| TEKNOPOX PRIMER 9-00               | EP  |                 |                  |           | 2x110 µm |
| TEKNOPLAST 50/90                   | EP  | 1x40 µm         |                  |           |          |
| TEKNODUR 0050/0090                 | PUR |                 | 1x40 µm          |           |          |
| TEKNODUR 3410-series               | PUR |                 |                  | 1x60 µm   |          |
| TEKNODUR 100 9-00                  | PUR |                 |                  |           | 1x40 µm  |
| Total film thickness               |     | 320 µm          | 320 µm           | 320 µm    | 320 µm   |
| Paint system VOC, g/m <sup>2</sup> |     | 180             | 179 / 185        | 170 - 177 | 214      |

| Example of Teknos paint system code | Example of paint system structure                     |
|-------------------------------------|---|
| TEC5.08/VH/D1                       | ISO 12944-5/C5.08-EPZn(R)/EP (EPZn(R)EP320/4-FeSa 2½) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low      | Medium   | High     | Very high |
|-----------------------------|----------|----------|----------|-----------|
| <b>C2.05</b>                | <b>X</b> | <b>X</b> | <b>X</b> |           |
| <b>C3.05</b>                | <b>X</b> | <b>X</b> |          |           |
| <b>C4.04</b>                | <b>X</b> |          |          |           |

**TEC2.05 High**  
**TEC3.05 Medium**  
**TEC4.04 Low**

# TEKNOMASTIC 80 PRIMER

## Paint systems 120 µm

1 1.8.2018

TEKNOMASTIC 80 PRIMER paint systems consist of an epoxy primer with good adhesion to the substrate and high corrosion protection properties.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid polyurethane top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C4 with durability classes high - low.

| Paint                              |            | EP-<br>top coat | PUR-<br>top coat |         |
|------------------------------------|------------|-----------------|------------------|---------|
|                                    |            | E1              | E2               | E3      |
| TEKNOMASTIC 80 PRIMER              | <b>EP</b>  | 1x80 µm         | 1x80 µm          | 1x80 µm |
| TEKNOPLAST 50 / 90                 | <b>EP</b>  | 1x40 µm         |                  |         |
| TEKNODUR 0050 / 0090               | <b>PUR</b> |                 | 1x40 µm          |         |
| TEKNODUR 3410-series               | <b>PUR</b> |                 |                  | 1x40 µm |
| Total film thickness               |            | 120 µm          | 120 µm           | 120 µm  |
| Paint system VOC, g/m <sup>2</sup> |            | 52              | 50 / 56          | 40 - 44 |

| Example of Teknos paint system code | Example of paint system structure              |
|-------------------------------------|--|
| TEC2.05/H/E1                        | ISO 12944-5/C2.06-EP (EP120/2-FeSa 2½).        |
| TEC3.05/M/E2                        | ISO 12944-5/C3.05-EP/PUR (EPPUR120/2-FeSa 2½). |
| TEC4.04/L/E3                        | ISO 12944-5/C4.04-EP/PUR (EPPUR120/2-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.



**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low      | Medium   | High     | Very high |
|--------------------------|----------|----------|----------|-----------|
| <b>C2.06</b>             | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>  |
| <b>C3.06</b>             | <b>X</b> | <b>X</b> | <b>X</b> |           |
| <b>C4.05</b>             | <b>X</b> | <b>X</b> |          |           |
| <b>C5.01</b>             | <b>X</b> |          |          |           |

**TEC2.06 Very high**  
**TEC3.06 High**  
**TEC4.05 Medium**  
**TEC5.01 Low**

**TEKNOMASTIC 80 PRIMER**  
**Paint systems 180 µm**

1 1.8.2018

TEKNOMASTIC 80 PRIMER paint systems consist of an epoxy primer with good adhesion to the substrate and high corrosion protection properties.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing polyaspartic top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C5 with durability classes very high - low.

| Paint                              |     | EP-top coat |          | PUR-top coat |          |          |          | PAS-top coat |
|------------------------------------|-----|-------------|----------|--------------|----------|----------|----------|--------------|
|                                    |     | E1          | E2       | E3           | E4       | E5       | E6       | E7           |
| TEKNOMASTIC 80 PRIMER              | EP  | 1x100 µm    | 1x120 µm | 1x120 µm     | 1x100 µm | 1x100 µm | 1x100 µm | 1x100 µm     |
| TEKNOPLAST HS 150                  | EP  | 1x80 µm     |          |              |          |          |          |              |
| TEKNOPLAST 50 / 90                 | EP  |             | 1x60 µm  |              |          |          |          |              |
| TEKNODUR 0050 / 0090               | PUR |             |          | 1x60 µm      |          |          |          |              |
| TEKNODUR 3410-series               | PUR |             |          |              | 1x80 µm  |          |          |              |
| TEKNODUR COMBI 3430-series         | PUR |             |          |              |          | 1x80 µm  |          |              |
| TEKNODUR COMBI 340-811             | PUR |             |          |              |          |          | 1x80 µm  |              |
| TEKNODUR COMBI 3560-series         | PAS |             |          |              |          |          |          | 1x80 µm      |
| Total film thickness               |     | 180 µm      | 180 µm   | 180 µm       | 180 µm   | 180 µm   | 180 µm   | 180 µm       |
| Paint system VOC, g/m <sup>2</sup> |     | 58          | 78       | 60 / 66      | 66 - 75  | 70 - 84  | 56       | 29 - 72      |

| Example of Teknos coding | Example of paint system structure              |
|--------------------------|--|
| TEC2.06/VH/E1            | ISO 12944-5/C2.06-EP (EP180/2-FeSa 2½).        |
| TEC3.06/H/E3             | ISO 12944-5/C3.06-EP/PUR (EPPUR180/2-FeSa 2½). |
| TEC4.05/M/E5             | ISO 12944-5/C4.05-EP/PUR (EPPUR180/2-FeSa 2½). |
| TEC5.01/L/E7             | ISO 12944-5/C5.01-EP/PAS (EPPAS180/2-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low      | Medium   | High     | Very high |
|-----------------------------|----------|----------|----------|-----------|
| <b>C3.07</b>                | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>  |
| <b>C4.06</b>                | <b>X</b> | <b>X</b> | <b>X</b> |           |
| <b>C5.02</b>                | <b>X</b> | <b>X</b> |          |           |

**TEC3.07 Very high**  
**TEC4.06 High**  
**TEC5.02 Medium**

**TEKNOMASTIC 80 PRIMER**  
**Paint systems 240 µm**

1 1.8.2018

TEKNOMASTIC 80 PRIMER paint systems consist of an epoxy primer with good adhesion to the substrate and high corrosion protection properties.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing polyaspartic top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

| Paint                              |            | EP-<br>top coat |          | PUR-<br>top coat |          |          |          | PAS-<br>top coat |
|------------------------------------|------------|-----------------|----------|------------------|----------|----------|----------|------------------|
|                                    |            | E1              | E2       | E3               | E4       | E5       | E6       | E7               |
| TEKNOMASTIC 80 PRIMER              | <b>EP</b>  | 1x160 µm        | 2x100 µm | 2x100 µm         | 1x160 µm | 1x160 µm | 1x160 µm | 1x160 µm         |
| TEKNOPLAST HS 150                  | <b>EP</b>  | 1x80 µm         |          |                  |          |          |          |                  |
| TEKNOPLAST 50 / 90                 | <b>EP</b>  |                 | 1x40 µm  |                  |          |          |          |                  |
| TEKNODUR 0050 / 0090               | <b>PUR</b> |                 |          | 1x40 µm          |          |          |          |                  |
| TEKNODUR 3410-series               | <b>PUR</b> |                 |          |                  | 1x80 µm  |          |          |                  |
| TEKNODUR COMBI 3430-series         | <b>PUR</b> |                 |          |                  |          | 1x80 µm  |          |                  |
| TEKNODUR COMBI 340-811             | <b>PUR</b> |                 |          |                  |          |          | 1x80 µm  |                  |
| TEKNODUR COMBI 3560-series         | <b>PAS</b> |                 |          |                  |          |          |          | 1x80 µm          |
| Total film thickness               |            | 240 µm          | 240 µm   | 240 µm           | 240 µm   | 240 µm   | 240 µm   | 240 µm           |
| Paint system VOC, g/m <sup>2</sup> |            | 73              | 81       | 79 / 85          | 81 - 90  | 85 - 99  | 70       | 44 - 87          |

| Example of Teknos paint system code | Example of paint system structure              |
|-------------------------------------|--|
| TEC3.07/VH/E1                       | ISO 12944-5/C3.07-EP (EP240/2-FeSa 2½).        |
| TEC4.06/H/E3                        | ISO 12944-5/C4.06-EP/PUR (EPPUR240/3-FeSa 2½). |
| TEC5.02/M/E7                        | ISO 12944-5/C5.02-EP/PAS (EPPAS240/2-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low      | Medium   | High     | Very high |
|--------------------------|----------|----------|----------|-----------|
| <b>C4.07</b>             | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>  |
| <b>C5.03</b>             | <b>X</b> | <b>X</b> | <b>X</b> |           |

**TEC4.07 Very high**  
**TEC5.03 High**

# TEKNOMASTIC 80 PRIMER

## Paint systems 300 µm

1 1.8.2018

TEKNOMASTIC 80 PRIMER paint systems consist of an epoxy primer with good adhesion to the substrate and high corrosion protection properties.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing polyaspartic top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C4 – C5 with durability classes very high - high.

| Paint                              |            | EP-<br>top coat | PUR-<br>top coat |          |           |          |          | PAS-<br>top coat |
|------------------------------------|------------|-----------------|------------------|----------|-----------|----------|----------|------------------|
|                                    |            | E1              | E2               | E3       | E4        | E5       | E6       |                  |
| TEKNOMASTIC 80 PRIMER              | <b>EP</b>  | 1x200 µm        | 2x130 µm         | 2x120 µm | 1x200 µm  | 1x200 µm | 1x200 µm |                  |
| TEKNOPLAST HS 150                  | <b>EP</b>  | 1x100 µm        |                  |          |           |          |          |                  |
| TEKNODUR 0050 / 0090               | <b>PUR</b> |                 | 1x40 µm          |          |           |          |          |                  |
| TEKNODUR 3410-series               | <b>PUR</b> |                 |                  | 1x60 µm  |           |          |          |                  |
| TEKNODUR COMBI 3430-series         | <b>PUR</b> |                 |                  |          | 1x100 µm  |          |          |                  |
| TEKNODUR COMBI 340-811             | <b>PUR</b> |                 |                  |          |           | 1x100 µm |          |                  |
| TEKNODUR COMBI 3560-series         | <b>PAS</b> |                 |                  |          |           |          | 1x100 µm |                  |
| Total film thickness               |            | 300 µm          | 300 µm           | 300 µm   | 300 µm    | 300 µm   | 300 µm   |                  |
| Paint system VOC, g/m <sup>2</sup> |            | 92              | 94 / 99          | 89 - 96  | 105 - 123 | 87       | 54 - 108 |                  |

| Example of Teknos paint system code | Example of paint system structure              |
|-------------------------------------|--|
| TEC4.07/VH/E2                       | ISO 12944-5/C4.07-EP/PUR (EPPUR300/3-FeSa 2½). |
| TEC5.03/H/E6                        | ISO 12944-5/C5.03-EP/PAS (EPPAS300/2-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very high |
|-----------------------------|-----|--------|------|-----------|
| C5.04                       | X   | X      | X    | X         |

**TEC5.04 Very high**

# TEKNOMASTIC 80 PRIMER

## Paint systems 360 µm

1 1.8.2018

TEKNOMASTIC 80 PRIMER paint systems consist of an epoxy primer with good adhesion to the substrate and high corrosion protection properties.

As a top coat different kind of paint chemistries can be used. Epoxy top coats have good mechanical properties as their nature and polyurethane top coats are used when a good colour and gloss retention are required. These paint systems contain also a high-solid fast curing polyaspartic top coat as option.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) or polyaspartic (PAS) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity category C5 with durability class very high.

| Paint                              |     | EP-      | PUR-      |           |           |          | PAS-     |
|------------------------------------|-----|----------|-----------|-----------|-----------|----------|----------|
|                                    |     | top coat | top coat  |           |           |          | top coat |
|                                    |     | E1       | E2        | E3        | E4        | E5       | E6       |
| TEKNOMASTIC 80 PRIMER              | EP  | 2x140 µm | 2x160 µm  | 2x140 µm  | 2x140 µm  | 2x140 µm | 2x120 µm |
| TEKNOPLAST HS 150                  | EP  | 1x80 µm  |           |           |           |          |          |
| TEKNODUR 0050 / 0090               | PUR |          | 1x40 µm   |           |           |          |          |
| TEKNODUR 3410-series               | PUR |          |           | 1x80 µm   |           |          |          |
| TEKNODUR COMBI 3430-series         | PUR |          |           |           | 1x80 µm   |          |          |
| TEKNODUR COMBI 340-811             | PUR |          |           |           |           | 1x80 µm  |          |
| TEKNODUR COMBI 3560-series         | PAS |          |           |           |           |          | 1x120 µm |
| Total film thickness               |     | 360 µm   | 360 µm    | 360 µm    | 360 µm    | 360 µm   | 360 µm   |
| Paint system VOC, g/m <sup>2</sup> |     | 102      | 109 / 115 | 110 - 119 | 114 - 128 | 99       | 37 - 101 |

| Example of Teknos paint system code | Example of paint system structure              |
|-------------------------------------|--|
| TEC5.04/VH/E2                       | ISO 12944-5/C5.04-EP/PUR (EPPUR360/3-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low      | Medium   | High     | Very high |
|--------------------------|----------|----------|----------|-----------|
| <b>C3.10</b>             | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>  |
| <b>C4.10</b>             | <b>X</b> | <b>X</b> | <b>X</b> |           |
| <b>C5.06</b>             | <b>X</b> | <b>X</b> |          |           |

**TEC3.10 Very high**  
**TEC4.10 High**  
**TEC5.06 Medium**

**TEKNOZINC 3480 SE**  
**Paint systems 200 µm**

1 1.8.2018

TEKNOZINC 3480 SE zinc rich paint systems consist of zinc rich paints, in which the zinc content is at least 80% by weight in a dry paint film.

Paint systems, containing zinc rich TEKNOZINC 3480 SE primer, give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy or polyurethane chemistry. Some of chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

| Paint                              |     | EP-<br>top coat |          | PUR-<br>top coat |           |         |          |
|------------------------------------|-----|-----------------|----------|------------------|-----------|---------|----------|
|                                    |     | E1              | E2       | E3               | E4        | E5      | E6       |
| TEKNOZINC 3480 SE                  | EP  | 1x60 µm         | 1x60 µm  | 1x60 µm          | 1x60 µm   | 1x60 µm | 1x60 µm  |
| TEKNOPLAST PRIMER 3 / 5            | EP  | 1x100 µm        |          | 1x100 µm         |           |         |          |
| TEKNOPLAST PRIMER 7                | EP  |                 | 1x100 µm |                  | 1x100 µm  | 1x80 µm |          |
| TEKNOPOX PRIMER 9-00               | EP  |                 |          |                  |           |         | 1x100 µm |
| TEKNOPLAST 50/90                   | EP  | 1x40 µm         | 1x40 µm  |                  |           |         |          |
| TEKNODUR 0050/0090                 | PUR |                 |          | 1x40 µm          | 1x40 µm   |         |          |
| TEKNODUR 3410-series               | PUR |                 |          |                  |           | 1x60 µm |          |
| TEKNODUR 100-09                    | PUR |                 |          |                  |           |         | 1x40 µm  |
| Total film thickness               |     | 200 µm          | 200 µm   | 200 µm           | 200 µm    | 200 µm  | 200 µm   |
| Paint system VOC, g/m <sup>2</sup> |     | 143             | 102      | 141 / 147        | 100 / 106 | 92 - 99 | 120      |

| Example of Teknos paint system code | Example of paint system structure                            |
|-------------------------------------|--|
| TEC3.10/VH/E1                       | ISO 12944-5/C3.10-EPZn(R)/EP (EPZn(R)EP200/3-FeSa 2½)        |
| TEC4.10/H/E2                        | ISO 12944-5/C4.10-EPZn(R)/EP (EPZn(R)EP200/3-FeSa 2½)        |
| TEC5.06/M/E5                        | ISO 12944-5/C5.06-EPZn(R)/EP/PUR (EPZn(R)EPPUR200/3-FeSa 2½) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low      | Medium   | High     | Very high |
|--------------------------|----------|----------|----------|-----------|
| <b>C4.11</b>             | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>  |
| <b>C5.07</b>             | <b>X</b> | <b>X</b> | <b>X</b> |           |

**TEC4.11 Very high**  
**TEC5.07 High**

## TEKNOZINC 3480 SE Paint systems 260 µm

1 1.8.2018

TEKNOZINC 3480 SE zinc rich paint systems consist of zinc rich paints, in which the zinc content is at least 80% by weight in a dry paint film.

Paint systems, containing zinc rich TEKNOZINC 3480 SE primer, give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy or polyurethane chemistry. Some of chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C4 – C5 with durability classes very high - high.

| Paint                              |            | EP-<br>top coat |         | PUR-<br>top coat |           |           |         |
|------------------------------------|------------|-----------------|---------|------------------|-----------|-----------|---------|
|                                    |            | E1              | E2      | E3               | E4        | E5        | E6      |
| TEKNOZINC 3480 SE                  | <b>EP</b>  | 1x60 µm         | 1x60 µm | 1x60 µm          | 1x60 µm   | 1x60 µm   | 1x60 µm |
| TEKNOPLAST PRIMER 3 / 5            | <b>EP</b>  | 2x80 µm         |         | 2x80 µm          |           |           |         |
| TEKNOPLAST PRIMER 7                | <b>EP</b>  |                 | 2x80 µm |                  | 2x80 µm   | 1x120 µm  |         |
| TEKNOPOX PRIMER 9-00               | <b>EP</b>  |                 |         |                  |           |           | 2x80 µm |
| TEKNOPLAST 50/90                   | <b>EP</b>  | 1x40 µm         | 1x40 µm |                  |           |           |         |
| TEKNODUR 0050/0090                 | <b>PUR</b> |                 |         | 1x40 µm          | 1x40 µm   |           |         |
| TEKNODUR 3410-series               | <b>PUR</b> |                 |         |                  |           | 1x80 µm   |         |
| TEKNODUR 100 9-00                  | <b>PUR</b> |                 |         |                  |           |           | 1x40 µm |
| Total film thickness               |            | 260 µm          | 260 µm  | 260 µm           | 260 µm    | 260 µm    | 260 µm  |
| Paint system VOC, g/m <sup>2</sup> |            | 191             | 128     | 190 / 196        | 126 / 132 | 120 - 129 | 154     |

| Example of Teknos paint system code | Example of paint system structure                            |
|-------------------------------------|--|
| TEC4.11/VH/E1                       | ISO 12944-5/C4.11-EPZn(R)/EP (EPZn(R)EP260/4-FeSa 2½)        |
| TEC5.07/H/E4                        | ISO 12944-5/C5.07-EPZn(R)/EP/PUR (EPZn(R)EPPUR260/4-FeSa 2½) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very<br>high |
|-----------------------------|-----|--------|------|--------------|
| C5.08                       | X   | X      | X    | X            |

**TEC5.08 Very high**

## TEKNOZINC 3480 SE Paint systems 320 µm

1 1.8.2018

TEKNOZINC 3480 SE zinc rich paint systems consist of zinc rich paints, in which the zinc content is at least 80% by weight in a dry paint film.

Paint systems, containing zinc rich TEKNOZINC 3480 SE primer, give excellent corrosion protection properties. Top coats for these corrosivity categories can be chosen from epoxy or polyurethane chemistry. Some of chosen top coats are of high solid type.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint systems described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

| Paint                              |     | EP-      | PUR-      |          |          |  |
|------------------------------------|-----|----------|-----------|----------|----------|--|
|                                    |     | top coat | top coat  |          |          |  |
|                                    |     | E1       | E2        | E3       | E4       |  |
| TEKNOZINC 3480 SE                  | EP  | 1x60 µm  | 1x60 µm   | 1x60 µm  | 1x60 µm  |  |
| TEKNOPLAST PRIMER 7                | EP  | 2x110 µm | 2x110 µm  | 2x100 µm |          |  |
| TEKNOPOX PRIMER 9-00               | EP  |          |           |          | 2x110 µm |  |
| TEKNOPLAST 50/90                   | EP  | 1x40 µm  |           |          |          |  |
| TEKNODUR 0050/0090                 | PUR |          | 1x40 µm   |          |          |  |
| TEKNODUR 3410-series               | PUR |          |           | 1x60 µm  |          |  |
| TEKNODUR 100 9-00                  | PUR |          |           |          | 1x40 µm  |  |
| Total film thickness               |     | 320 µm   | 320 µm    | 320 µm   | 320 µm   |  |
| Paint system VOC, g/m <sup>2</sup> |     | 153      | 152 / 158 | 143 -150 | 151      |  |

| Example of Teknos paint system code | Example of paint system structure                     |
|-------------------------------------|---|
| TEC5.08/VH/E1                       | ISO 12944-5/C5.08-EPZn(R)/EP (EPZn(R)EP320/4-FeSa 2½) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very high |
|-----------------------------|-----|--------|------|-----------|
| C2.01                       | X   |        |      |           |

**TEC2.01 Low**

## 1-COMPONENT COMBI Paint systems 80 µm

1 1.8.2018

1-COMPONENT COMBI paint systems consist of different kind of alkyd paints having very good corrosion protection properties. 1-COMPONENT COMBI paints contain efficient active anticorrosive pigments. TEKNOLAC COMBI 50 has the fastest drying properties and TEKNOSYNT COMBI 50 is a thixotropic urethane/alkyd based paint.

These paint systems can be used in field and station painting of structured steel objects.

These paint systems are designed for corrosivity category C2 with durability class low.

| Paint                              |    | A1      | A2      | A3      |
|------------------------------------|----|---------|---------|---------|
| TEKNOLAC COMBI 50                  | AK | 1x80 µm |         |         |
| TEKNOLAC COMBI 2280-02             | AK |         | 1x80 µm |         |
| TEKNOSYNT COMBI 50                 | AK |         |         | 1x80 µm |
| Total film thickness               |    | 80 µm   | 80 µm   | 80 µm   |
| Paint system VOC, g/m <sup>2</sup> |    | 92      | 48      | 89      |

| Example of Teknos paint system code | Example of paint system structure      |
|-------------------------------------|--|
| TEC2.01/L/A1                        | ISO 12944-5/C2.01-AK (AK80/1-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.



**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very high |
|-----------------------------|-----|--------|------|-----------|
| C2.02                       | X   | X      |      |           |
| C3.01                       | X   |        |      |           |

**TEC2.02 Medium**  
**TEC3.01 Low**

# 1-COMPONENT COMBI Paint systems 100 µm

1 1.8.2018

1-COMPONENT COMBI paint systems consist of different kind of alkyd paints having very good corrosion protection properties. 1-COMPONENT COMBI paints contain efficient active anticorrosive pigments. TEKNOLAC COMBI 50 has the fastest drying properties and TEKNOSYNT COMBI 50 is a thixotropic urethane/alkyd based paint.

These paint systems can be used in field and station painting of structured steel objects.

These paint systems are designed for corrosivity categories C2 - C3 with durability classes medium - low.

| Paint                              |           | A1       | A2       | A3       |
|------------------------------------|-----------|----------|----------|----------|
| TEKNOLAC COMBI 50                  | <b>AK</b> | 1x100 µm |          |          |
| TEKNOLAC COMBI 2280-02             | <b>AK</b> |          | 1x100 µm |          |
| TEKNOSYNT COMBI 50                 | <b>AK</b> |          |          | 1x100 µm |
| Total film thickness               |           | 100 µm   | 100 µm   | 100 µm   |
| Paint system VOC, g/m <sup>2</sup> |           | 60       | 60       | 80       |

| Example of Teknos paint system code | Example of paint system structure       |
|-------------------------------------|---|
| TEC2.02/M/A1                        | ISO 12944-5/C2.02-AK (AK100/1-FeSa 2½). |
| TEC3.01/L/A2                        | ISO 12944-5/C3.01-AK (AK100/1-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system<br>ISO 12944-5 | Low      | Medium   | High     | Very<br>high |
|-----------------------------|----------|----------|----------|--------------|
| <b>C2.03</b>                | <b>X</b> | <b>X</b> | <b>X</b> |              |
| <b>C3.02</b>                | <b>X</b> | <b>X</b> |          |              |
| <b>C4.01</b>                | <b>X</b> |          |          |              |

**TEC2.03 High**  
**TEC3.02 Medium**  
**TEC4.01 Low**

# 1-COMPONENT COMBI Paint systems 160 µm

1 1.8.2018

1-COMPONENT COMBI paint systems consist of different kind of alkyd paints having very good corrosion protection properties. 1-COMPONENT COMBI paints contain efficient active anticorrosive pigments. TEKNOLAC COMBI 50 has the fastest drying properties and TEKNOSYNT COMBI 50 is a thixotropic urethane/alkyd based paint.

These paint systems can be used in field and station painting of structured steel objects.

These paint systems are designed for corrosivity categories C2 – C4 with durability classes high - low.

| Paint                              |           | A1      | A2      | A3      |
|------------------------------------|-----------|---------|---------|---------|
| TEKNOLAC COMBI 50                  | <b>AK</b> | 2x80 µm |         |         |
| TEKNOLAC COMBI 2280-02             | <b>AK</b> |         | 2x80 µm |         |
| TEKNOSYNT COMBI 50                 | <b>AK</b> |         |         | 2x80 µm |
| Total film thickness               |           | 160 µm  | 160 µm  | 160 µm  |
| Paint system VOC, g/m <sup>2</sup> |           | 185     | 96      | 178     |

| Example of Teknos paint system code | Example of paint system structure       |
|-------------------------------------|---|
| TEC2.03/H/A1                        | ISO 12944-5/C2.03-AK (AK160/2-FeSa 2½). |
| TEC3.02/M/A2                        | ISO 12944-5/C3.02-AK (AK160/2-FeSa 2½). |
| TEC4.01/L/A3                        | ISO 12944-5/C4.01-AK (AK160/2-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low      | Medium   | High     | Very high |
|--------------------------|----------|----------|----------|-----------|
| <b>C2.04</b>             | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>  |
| <b>C3.03</b>             | <b>X</b> | <b>X</b> | <b>X</b> |           |
| <b>C4.02</b>             | <b>X</b> | <b>X</b> |          |           |

**TEC2.04 Very high**  
**TEC3.03 High**  
**TEC4.02 Medium**

# 1-COMPONENT COMBI Paint systems 200 µm

1 1.8.2018

1-COMPONENT COMBI paint systems consist of different kind of alkyd paints having very good corrosion protection properties. 1-COMPONENT COMBI paints contain efficient active anticorrosive pigments. TEKNOLAC COMBI 50 has the fastest drying properties and TEKNOSYNT COMBI 50 is a thixotropic urethane/alkyd based paint.

These paint systems can be used in field and station painting of structured steel objects.

These paint systems are designed for corrosivity categories C2 – C4 with durability classes very high - low.

| Paint                              |           | A1      | A2       | A3      |
|------------------------------------|-----------|---------|----------|---------|
| TEKNOLAC COMBI 50                  | <b>AK</b> | 1x80 µm |          |         |
| TEKNOLAC COMBI 50                  | <b>AK</b> | 2x60 µm |          |         |
| TEKNOLAC COMBI 2280-02             | <b>AK</b> |         | 1x80 µm  |         |
| TEKNOLAC COMBI 2280-02             | <b>AK</b> |         | 1x120 µm |         |
| TEKNOSYNT COMBI 50                 | <b>AK</b> |         |          | 1x80 µm |
| TEKNOSYNT COMBI 50                 | <b>AK</b> |         |          | 2x60 µm |
| Total film thickness               |           | 200 µm  | 200 µm   | 200 µm  |
| Paint system VOC, g/m <sup>2</sup> |           | 230     | 121      | 160     |

| Example of Teknos paint system code | Example of paint system structure       |
|-------------------------------------|---|
| TEC2.04/VH/A1                       | ISO 12944-5/C2.04-AK (AK200/3-FeSa 2½). |
| TEC3.03/H/A2                        | ISO 12944-5/C3.03-AK (AK200/2-FeSa 2½). |
| TEC4.02/M/A3                        | ISO 12944-5/C4.02-AK (AK200/3-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**C**

| Paint system ISO 12944-5 | Low      | Medium   | High     | Very high |
|--------------------------|----------|----------|----------|-----------|
| <b>C3.04</b>             | <b>X</b> | <b>X</b> | <b>X</b> | <b>X</b>  |
| <b>C4.03</b>             | <b>X</b> | <b>X</b> | <b>X</b> |           |

**TEC3.04 Very high**  
**TEC4.03 High**

# 1-COMPONENT COMBI

## Paint systems 260 µm

1 1.8.2018

1-COMPONENT COMBI paint systems consist of different kind of alkyd paints having very good corrosion protection properties. 1-COMPONENT COMBI paints contain efficient active anticorrosive pigments. TEKNOLAC COMBI 50 has the fastest drying properties and TEKNOSYNT COMBI 50 is a thixotropic urethane/alkyd based paint.

These paint systems can be used in field and station painting of structured steel objects.

These paint systems are designed for corrosivity categories C3 – C4 with durability classes very high - high.

| Paint                              |           | A1       | A2       | A3       |
|------------------------------------|-----------|----------|----------|----------|
| TEKNOLAC COMBI 50                  | <b>AK</b> | 1x60 µm  |          |          |
| TEKNOLAC COMBI 50                  | <b>AK</b> | 2x100 µm |          |          |
| TEKNOLAC COMBI 2280-02             | <b>AK</b> |          | 1x60 µm  |          |
| TEKNOLAC COMBI 2280-02             | <b>AK</b> |          | 2x100 µm |          |
| TEKNOSYNT COMBI 50                 | <b>AK</b> |          |          | 1x60 µm  |
| TEKNOSYNT COMBI 50                 | <b>AK</b> |          |          | 2x100 µm |
| Total film thickness               |           | 260 µm   | 260 µm   | 260 µm   |
| Paint system VOC, g/m <sup>2</sup> |           | 300      | 157      | 208      |

| Example of Teknos paint system code | Example of paint system structure       |
|-------------------------------------|---|
| TEC3.04/VH/A1                       | ISO 12944-5/C3.04-AK (AK260/3-FeSa 2½). |
| TEC4.03/H/A2                        | ISO 12944-5/C3.04-AK (AK260/3-FeSa 2½). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

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

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**G**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very high |
|-----------------------------|-----|--------|------|-----------|
| G2.01                       | Zn  | Zn     | Zn   |           |
| G3.01                       | Zn  | Zn     |      |           |
| G4.01                       | Zn  |        |      |           |

**TEG2.01 High**  
**TEG3.01 Medium**  
**TEG4.01 Low**

## 2-COMPONENT COMBI, HOT DIP GALVANIZED Paint systems 80 µm

1 1.8.2018

2-COMPONENT COMBI paint systems for hot dip galvanized steel consist of different types of paint chemistries. These one layer paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C4 with durability classes high - low.

| Paint                              |     | R1      | R2      |
|------------------------------------|-----|---------|---------|
| TEKNOPLAST HS 150                  | EP  | 1x80 µm |         |
| TEKNODUR COMBI 3430 -series        | PUR |         | 1x80 µm |
| Total film thickness               |     | 80 µm   | 80 µm   |
| Paint system VOC, g/m <sup>2</sup> |     | 34      | 46 - 60 |

| Example of Teknos paint system code | Example of paint system structure     |
|-------------------------------------|---------------------------------------|
| TEG2.01/H/R1                        | ISO 12944-5/G2.01-EP (EP80/1-ZnSaS).  |
| TEG3.01/M/R2                        | ISO 12944-5/G3.01-PUR (PUR80/1-ZnSaS) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

**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 according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

**G**

| Paint system ISO 12944-5 | Low | Medium | High | Very high |
|--------------------------|-----|--------|------|-----------|
| G2.03                    | Zn  | Zn     | Zn   | Zn        |
| G3.02                    | Zn  | Zn     | Zn   |           |
| G4.02                    | Zn  | Zn     |      |           |
| G5.01                    | Zn  |        |      |           |

**TEG2.03 Very high**  
**TEG3.02 High**  
**TEG4.02 Medium**  
**TEG5.01 Low**

## 2-COMPONENT COMBI, HOT DIP GALVANIZED Paint systems 120 µm

1 1.8.2018

2-COMPONENT COMBI paint systems for hot dip galvanized steel consist of different types of paint chemistries. These one layer paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C5 with durability classes very high - low.

| Paint                              |     | R1       | R2       |
|------------------------------------|-----|----------|----------|
| TEKNOPLAST HS 150                  | EP  | 1x120 µm |          |
| TEKNODUR COMBI 3430 -series        | PUR |          | 1x120 µm |
| Total film thickness               |     | 120 µm   | 120 µm   |
| Paint system VOC, g/m <sup>2</sup> |     | 51       | 69 - 90  |

| Example of Teknos paint system code | Example of paint system structure      |
|-------------------------------------|--|
| TEG2.03/VH/R1                       | ISO 12944-5/G2.03-EP (EP120/1-ZnSaS).  |
| TEG3.02/H/R2                        | ISO 12944-5/G3.02-PUR (PUR120/1-ZnSaS) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

**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 according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**G**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very high |
|-----------------------------|-----|--------|------|-----------|
| G3.04                       | Zn  | Zn     | Zn   | Zn        |
| G4.04                       | Zn  | Zn     | Zn   |           |
| G5.02                       | Zn  | Zn     |      |           |

**TEG3.04 Very high**  
**TEG4.04 High**  
**TEG5.02 Medium**

## 2-COMPONENT COMBI, HOT DIP GALVANIZED Paint systems 160 µm

1 1.8.2018

2-COMPONENT COMBI paint systems for hot dip galvanized steel consist of different types of paint chemistries. These one layer paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

| Paint                              |     | R1      | R2       |
|------------------------------------|-----|---------|----------|
| TEKNOPLAST HS 150                  | EP  | 2x80 µm |          |
| TEKNODUR COMBI 3430 -series        | PUR |         | 2x80 µm  |
| Total film thickness               |     | 160 µm  | 160 µm   |
| Paint system VOC, g/m <sup>2</sup> |     | 68      | 92 - 120 |

| Example of Teknos paint system code | Example of paint system structure      |
|-------------------------------------|--|
| TEG3.04/VH/R1                       | ISO 12944-5/G3.04-EP (EP160/2-ZnSaS).  |
| TEG4.04/H/R2                        | ISO 12944-5/G4.04-PUR (PUR160/2-ZnSaS) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

**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 according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**G**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very high |
|-----------------------------|-----|--------|------|-----------|
| <b>G4.06</b>                | Zn  | Zn     | Zn   | Zn        |
| <b>G5.04</b>                | Zn  | Zn     | Zn   |           |

**TEG4.06 Very high**  
**TEG5.04 High**

## 2-COMPONENT COMBI, HOT DIP GALVANIZED Paint systems 200 µm

1 1.8.2018

2-COMPONENT COMBI paint systems for hot dip galvanized steel consist of different types of paint chemistries. These one layer paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C4 – C5 with durability classes very high - high.

| Paint                              |            | R1       | R2        |
|------------------------------------|------------|----------|-----------|
| TEKNOPLAST HS 150                  | <b>EP</b>  | 1x80 µm  |           |
| TEKNOPLAST HS 150                  | <b>EP</b>  | 1x120 µm |           |
| TEKNODUR COMBI 3430 -series        | <b>PUR</b> |          | 1x80 µm   |
| TEKNODUR COMBI 3430 -series        | <b>PUR</b> |          | 1x120 µm  |
| Total film thickness               |            | 200 µm   | 200 µm    |
| Paint system VOC, g/m <sup>2</sup> |            | 85       | 115 - 150 |

| Example of Teknos paint system code | Example of paint system structure      |
|-------------------------------------|--|
| TEG4.06/VH/R1                       | ISO 12944-5/G4.06-EP (EP200/2-ZnSaS).  |
| TEG5.04/H/R2                        | ISO 12944-5/G5.04-PUR (PUR200/2-ZnSaS) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

**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 according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.



**Suitable corrosivity categories/durability ranges**

**G**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very<br>high |
|-----------------------------|-----|--------|------|--------------|
| G5.05                       | Zn  | Zn     | Zn   | Zn           |

**TEG5.05 Very high**

## 2-COMPONENT COMBI, HOT DIP GALVANIZED Paint systems 240 µm

1 1.8.2018

2-COMPONENT COMBI paint systems for hot dip galvanized steel consist of different types of paint chemistries. These one layer paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity category C5 with durability class very high.

| Paint                              |     | R1       | R2        |
|------------------------------------|-----|----------|-----------|
| TEKNOPLAST HS 150                  | EP  | 1x80 µm  |           |
| TEKNOPLAST HS 150                  | EP  | 1x160 µm |           |
| TEKNODUR COMBI 3430 -series        | PUR |          | 1x80 µm   |
| TEKNODUR COMBI 3430 -series        | PUR |          | 1x160 µm  |
| Total film thickness               |     | 240 µm   | 240 µm    |
| Paint system VOC, g/m <sup>2</sup> |     | 102      | 138 - 180 |

| Example of Teknos paint system code | Example of paint system structure     |
|-------------------------------------|---------------------------------------|
| TEG5.05/VH/R1                       | ISO 12944-5/G5.05-EP (EP240/2-ZnSaS). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

**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 according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**G**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very<br>high |
|-----------------------------|-----|--------|------|--------------|
| G3.05                       | Zn  | Zn     | Zn   | Zn           |
| G4.05                       | Zn  | Zn     | Zn   |              |
| G5.03                       | Zn  | Zn     |      |              |

**TEG3.05 Very high**  
**TEG4.05 High**  
**TEG5.03 Medium**

## TEKNOCRYL PRIMER 3-11, HOT DIP GALVANIZED Paint systems 200 µm

1 1.8.2018

TEKNOCRYL PRIMER 3-11 paint system is an acrylic based physically drying paint system with good adhesion on hot dip galvanized substrates.

This paint system is designed for corrosivity categories C3 – C5 with durability classes very high - medium.

| Paint                              |    | R1      |
|------------------------------------|----|---------|
| TEKNOCRYL PRIMER 3-11              | AY | 2x80 µm |
| TEKNOCRYL 100-500                  | AY | 1x40 µm |
| Total film thickness               |    | 200 µm  |
| Paint system VOC, g/m <sup>2</sup> |    | 181     |

| Example of Teknos paint system code | Example of paint system structure     |
|-------------------------------------|---------------------------------------|
| TEG3.05/VH/R1                       | ISO 12944-5/G3.05-AY (AY200/3-ZnSaS). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

**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 according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**G**

| Paint system ISO 12944-5 | Low | Medium | High | Very high |
|--------------------------|-----|--------|------|-----------|
| <b>G2.03</b>             | Zn  | Zn     | Zn   | Zn        |
| <b>G3.02</b>             | Zn  | Zn     | Zn   |           |
| <b>G4.02</b>             | Zn  | Zn     |      |           |
| <b>G5.01</b>             | Zn  |        |      |           |

**TEG2.03 Very high**  
**TEG3.02 High**  
**TEG4.02 Medium**  
**TEG5.01 Low**

## TEKNOPLAST PRIMER 5, HOT DIP GALVANIZED Paint systems 120 µm

1 1.8.2018

TEKNOPLAST PRIMER 5 paint systems for hot dip galvanized steel consist of different types of paint chemistries. These paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C5 with durability classes very high - low.

| Paint                              |            | EP-<br>top coat | PUR-<br>top coat |         |
|------------------------------------|------------|-----------------|------------------|---------|
|                                    |            | S1              | S2               | S3      |
| TEKNOPLAST PRIMER 5                | <b>EP</b>  | 1x80 µm         | 1x80 µm          | 1x80 µm |
| TEKNOPLAST 50 / 90                 | <b>EP</b>  | 1x40 µm         |                  |         |
| TEKNODUR 0050 / 0090               | <b>PUR</b> |                 | 1x40 µm          |         |
| TEKNODUR 3410-series               | <b>PUR</b> |                 |                  | 1x40 µm |
| Total film thickness               |            | 120 µm          | 120 µm           | 120 µm  |
| Paint system VOC, g/m <sup>2</sup> |            | 98              | 97 / 103         | 87 - 91 |

| Example of Teknos paint system code | Example of paint system structure           |
|-------------------------------------|---|
| TEG2.03/VH/S1                       | ISO 12944-5/G2.03-EP (EP120/2-ZnSaS).       |
| TEG3.02/H/S2                        | ISO 12944-5/G3.02-EP/PUR (EPPUR120/2-ZnSaS) |
| TEG4.02/M/S3                        | ISO 12944-5/G4.02-EP/PUR (EPPUR120/2-ZnSaS) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

**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 according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**G**

| Paint system ISO 12944-5 | Low | Medium | High | Very high |
|--------------------------|-----|--------|------|-----------|
| <b>G3.04</b>             | Zn  | Zn     | Zn   | Zn        |
| <b>G4.04</b>             | Zn  | Zn     | Zn   |           |
| <b>G5.02</b>             | Zn  | Zn     |      |           |

**TEG3.04 Very high**  
**TEG4.04 High**  
**TEG5.02 Medium**

# TEKNOPLAST PRIMER 5, HOT DIP GALVANIZED

## Paint systems 160 µm

1 1.8.2018

TEKNOPLAST PRIMER 5 paint systems for hot dip galvanized steel consist of different types of paint chemistries. These paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

| Paint                              |     | EP-<br>top coat | PUR-<br>top coat |           |         |
|------------------------------------|-----|-----------------|------------------|-----------|---------|
|                                    |     | S1              | S2               | S3        | S4      |
| TEKNOPLAST PRIMER 5                | EP  | 1x80 µm         | 1x80 µm          | 1x80 µm   | 1x80 µm |
| TEKNOPLAST HS 150                  | EP  | 1x80 µm         |                  |           |         |
| TEKNODUR 3410-series               | PUR |                 | 1x80 µm          |           |         |
| TEKNODUR COMBI 3430-series         | PUR |                 |                  | 1x80 µm   |         |
| TEKNODUR COMBI 340-811             | PUR |                 |                  |           | 1x80 µm |
| Total film thickness               |     | 160 µm          | 160 µm           | 160 µm    | 160 µm  |
| Paint system VOC, g/m <sup>2</sup> |     | 100             | 108 - 117        | 112 - 126 | 97      |

| Example of Teknos paint system code | Example of paint system structure           |
|-------------------------------------|---|
| TEG3.04/VH/S1                       | ISO 12944-5/G3.04-EP (EP160/2-ZnSaS).       |
| TEG4.04/H/S3                        | ISO 12944-5/G4.04-EP/PUR (EPPUR160/2-ZnSaS) |
| TEG5.02/M/S4                        | ISO 12944-5/G5.02-EP/PUR (EPPUR160/2-ZnSaS) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

**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 according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**G**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very high |
|-----------------------------|-----|--------|------|-----------|
| <b>G4.06</b>                | Zn  | Zn     | Zn   | Zn        |
| <b>G5.04</b>                | Zn  | Zn     | Zn   |           |

**TEG4.06 Very high**  
**TEG5.04 High**

# TEKNOPLAST PRIMER 5, HOT DIP GALVANIZED

## Paint systems 200 µm

1 1.8.2018

TEKNOPLAST PRIMER 5 paint systems for hot dip galvanized steel consist of different types of paint chemistries. These paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C4 – C5 with durability classes very high - high.

| Paint                              |     | EP-<br>top coat |          | PUR-<br>top coat |           |          | PAS-<br>top coat |
|------------------------------------|-----|-----------------|----------|------------------|-----------|----------|------------------|
|                                    |     | S1              | S2       | S3               | S4        | S5       | S6               |
| TEKNOPLAST PRIMER 5                | EP  | 1x80 µm         | 1x80 µm  | 2x80 µm          | 1x80 µm   | 1x80 µm  | 1x80 µm          |
| TEKNOPLAST HS 150                  | EP  | 1x120 µm        |          |                  |           |          |                  |
| TEKNOMASTIC COMBI 80-500           | EP  |                 | 1x120 µm |                  |           |          |                  |
| TEKNODUR 3410-series               | PUR |                 |          | 1x40 µm          |           |          |                  |
| TEKNODUR COMBI 3430-series         | PUR |                 |          |                  | 1x120 µm  |          |                  |
| TEKNODUR COMBI 340-811             | PUR |                 |          |                  |           | 1x120 µm |                  |
| TEKNODUR COMBI 3560-series         | PUR |                 |          |                  |           |          | 1x120 µm         |
| Total film thickness               |     | 200 µm          | 200 µm   | 200 µm           | 200 µm    | 200 µm   | 200 µm           |
| Paint system VOC, g/m <sup>2</sup> |     | 117             | 95       | 153 - 157        | 135 - 156 | 113      | 74 - 138         |

| Example of Teknos paint system code | Example of paint system structure           |
|-------------------------------------|---|
| TEG4.06/VH/S1                       | ISO 12944-5/G4.06-EP (EP200/2-ZnSaS).       |
| TEG4.06/VH/S3                       | ISO 12944-5/G4.06-EP/PUR (EPPUR200/3-ZnSaS) |
| TEG5.04/H/S4                        | ISO 12944-5/G5.04-EP/PUR (EPPUR200/2-ZnSaS) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

**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 according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

**G**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very high |
|-----------------------------|-----|--------|------|-----------|
| G5.05                       | Zn  | Zn     | Zn   | Zn        |

**TEG5.05 Very high**

## TEKNOPLAST PRIMER 5, HOT DIP GALVANIZED Paint systems 240 µm

1 1.8.2018

TEKNOPLAST PRIMER 5 paint systems for hot dip galvanized steel consist of different types of paint chemistries. These paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity category C5 with durability class very high.

| Paint                              |     | EP-<br>top coat |          | PUR-<br>top coat |           |         | PAS-<br>top coat |
|------------------------------------|-----|-----------------|----------|------------------|-----------|---------|------------------|
|                                    |     | S1              | S2       | S3               | S4        | S5      | S6               |
| TEKNOPLAST PRIMER 5                | EP  | 2x80 µm         | 1x80 µm  | 2x80 µm          | 2x80 µm   | 2x80 µm | 1x80 µm          |
| TEKNOPLAST HS 150                  | EP  | 1x80 µm         |          |                  |           |         |                  |
| TEKNOMASTIC COMBI 80-500           | EP  |                 | 1x160 µm |                  |           |         |                  |
| TEKNODUR 3410-series               | PUR |                 |          | 1x80 µm          |           |         |                  |
| TEKNODUR COMBI 3430-series         | PUR |                 |          |                  | 1x80 µm   |         |                  |
| TEKNODUR COMBI 340-811             | PUR |                 |          |                  |           | 1x80 µm |                  |
| TEKNODUR COMBI 3560-series         | PUR |                 |          |                  |           |         | 1x160 µm         |
| Total film thickness               |     | 240 µm          | 240 µm   | 240 µm           | 240 µm    | 240 µm  | 240 µm           |
| Paint system VOC, g/m <sup>2</sup> |     | 166             | 105      | 174 - 183        | 178 - 192 | 163     | 76 - 162         |

| Example of Teknos paint system code | Example of paint system structure           |
|-------------------------------------|---|
| TEG5.05/VH/S1                       | ISO 12944-5/G5.05-EP (EP240/3-ZnSaS).       |
| TEG5.05/VH/S6                       | ISO 12944-5/G5.05-EP/PAS (EPPAS240/2-ZnSaS) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

**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 according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**G**

| Paint system ISO 12944-5 | Low | Medium | High | Very high |
|--------------------------|-----|--------|------|-----------|
| <b>G2.03</b>             | Zn  | Zn     | Zn   | Zn        |
| <b>G3.02</b>             | Zn  | Zn     | Zn   |           |
| <b>G4.02</b>             | Zn  | Zn     |      |           |
| <b>G5.01</b>             | Zn  |        |      |           |

**TEG2.03 Very high**  
**TEG3.02 High**  
**TEG4.02 Medium**  
**TEG5.01 Low**

## TEKNOPLAST PRIMER 7, HOT DIP GALVANIZED Paint systems 120 µm

1 1.8.2018

TEKNOPLAST PRIMER 7 paint systems for hot dip galvanized steel consist of different types of paint chemistries. These paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C2 – C5 with durability classes very high - low.

| Paint                              |            | EP-<br>top coat | PUR-<br>top coat |         |
|------------------------------------|------------|-----------------|------------------|---------|
|                                    |            | T1              | T2               | T3      |
| TEKNOPLAST PRIMER 7                | <b>EP</b>  | 1x80 µm         | 1x80 µm          | 1x80 µm |
| TEKNOPLAST 50 / 90                 | <b>EP</b>  | 1x40 µm         |                  |         |
| TEKNODUR 0050 / 0090               | <b>PUR</b> |                 | 1x40 µm          |         |
| TEKNODUR 3410-series               | <b>PUR</b> |                 |                  | 1x40 µm |
| Total film thickness               |            | 120 µm          | 120 µm           | 120 µm  |
| Paint system VOC, g/m <sup>2</sup> |            | 66              | 65 / 71          | 55 - 59 |

| Example of Teknos paint system code | Example of paint system structure           |
|-------------------------------------|---|
| TEG2.03/VH/T1                       | ISO 12944-5/G2.03-EP (EP120/2-ZnSaS).       |
| TEG3.02/H/T2                        | ISO 12944-5/G3.02-EP/PUR (EPPUR120/2-ZnSaS) |
| TEG4.02/M/T3                        | ISO 12944-5/G4.02-EP/PUR (EPPUR120/2-ZnSaS) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

**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 according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

**G**

| Paint system ISO 12944-5 | Low | Medium | High | Very high |
|--------------------------|-----|--------|------|-----------|
| G3.04                    | Zn  | Zn     | Zn   | Zn        |
| G4.04                    | Zn  | Zn     | Zn   |           |
| G5.02                    | Zn  | Zn     |      |           |

**TEG3.04 Very high**  
**TEG4.04 High**  
**TEG5.02 Medium**

## TEKNOPLAST PRIMER 7, HOT DIP GALVANIZED Paint systems 160 µm

1 1.8.2018

TEKNOPLAST PRIMER 7 paint systems for hot dip galvanized steel consist of different types of paint chemistries. These paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C3 – C5 with durability classes very high - medium.

| Paint                              |     | EP-<br>top coat | PUR-<br>top coat |         |         |
|------------------------------------|-----|-----------------|------------------|---------|---------|
|                                    |     | T1              | T2               | T3      | T4      |
| TEKNOPLAST PRIMER 7                | EP  | 1x80 µm         | 1x80 µm          | 1x80 µm | 1x80 µm |
| TEKNOPLAST HS 150                  | EP  | 1x80 µm         |                  |         |         |
| TEKNODUR 3410-series               | PUR |                 | 1x80 µm          |         |         |
| TEKNODUR COMBI 3430-series         | PUR |                 |                  | 1x80 µm |         |
| TEKNODUR COMBI 340-811             | PUR |                 |                  |         | 1x80 µm |
| Total film thickness               |     | 160 µm          | 160 µm           | 160 µm  | 160 µm  |
| Paint system VOC, g/m <sup>2</sup> |     | 68              | 76 - 85          | 80 - 94 | 65      |

| Example of Teknos paint system code | Example of paint system structure           |
|-------------------------------------|---|
| TEG3.04/VH/T1                       | ISO 12944-5/G3.04-EP (EP160/2-ZnSaS).       |
| TEG4.04/H/T3                        | ISO 12944-5/G4.04-EP/PUR (EPPUR160/2-ZnSaS) |
| TEG5.02/M/T4                        | ISO 12944-5/G5.02-EP/PUR (EPPUR160/2-ZnSaS) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

**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 according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about the above-mentioned products please see individual product data sheets.



**Suitable corrosivity categories/durability ranges**

**G**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very high |
|-----------------------------|-----|--------|------|-----------|
| <b>G4.06</b>                | Zn  | Zn     | Zn   | Zn        |
| <b>G5.04</b>                | Zn  | Zn     | Zn   |           |

**TEG4.06 Very high**  
**TEG5.04 High**

## TEKNOPLAST PRIMER 7, HOT DIP GALVANIZED Paint systems 200 µm

1 1.8.2018

TEKNOPLAST PRIMER 7 paint systems for hot dip galvanized steel consist of different types of paint chemistries. These paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C4 – C5 with durability classes very high - high.

| Paint                              |     | EP-<br>top coat |          | PUR-<br>top coat |           |          | PAS-<br>top coat |
|------------------------------------|-----|-----------------|----------|------------------|-----------|----------|------------------|
|                                    |     | T1              | T2       | T3               | T4        | T5       | T6               |
| TEKNOPLAST PRIMER 7                | EP  | 1x80 µm         | 1x80 µm  | 2x80 µm          | 1x80 µm   | 1x80 µm  | 1x80 µm          |
| TEKNOPLAST HS 150                  | EP  | 1x120 µm        |          |                  |           |          |                  |
| TEKNOMASTIC COMBI 80-500           | EP  |                 | 1x120 µm |                  |           |          |                  |
| TEKNODUR 3410-series               | PUR |                 |          | 1x40 µm          |           |          |                  |
| TEKNODUR COMBI 3430-series         | PUR |                 |          |                  | 1x120 µm  |          |                  |
| TEKNODUR COMBI 340-811             | PUR |                 |          |                  |           | 1x120 µm |                  |
| TEKNODUR COMBI 3560-series         | PAS |                 |          |                  |           |          | 1x120 µm         |
| Total film thickness               |     | 200 µm          | 200 µm   | 200 µm           | 200 µm    | 200 µm   | 200 µm           |
| Paint system VOC, g/m <sup>2</sup> |     | 86              | 63       | 89 - 93          | 103 - 124 | 81       | 40 - 104         |

| Example of Teknos paint system code | Example of paint system structure           |
|-------------------------------------|---|
| TEG4.06/VH/T1                       | ISO 12944-5/G4.06-EP (EP200/2-ZnSaS).       |
| TEG4.06/VH/T3                       | ISO 12944-5/G4.06-EP/PUR (EPPUR200/3-ZnSaS) |
| TEG5.04/H/T4                        | ISO 12944-5/G5.04-EP/PUR (EPPUR200/2-ZnSaS) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

**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 according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

**G**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very high |
|-----------------------------|-----|--------|------|-----------|
| G5.05                       | Zn  | Zn     | Zn   | Zn        |

**TEG5.05 Very high**

# TEKNOPLAST PRIMER 7, HOT DIP GALVANIZED

## Paint systems 240 µm

1 1.8.2018

TEKNOPLAST PRIMER 7 paint systems for hot dip galvanized steel consist of different types of paint chemistries. These paint systems are designed for hot dip galvanized steel. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity category C5 with durability class very high.

| Paint                              |     | EP-<br>top coat |          | PUR-<br>top coat |           |         | PAS-<br>top coat |
|------------------------------------|-----|-----------------|----------|------------------|-----------|---------|------------------|
|                                    |     | T1              | T2       | T3               | T4        | T5      | T6               |
| TEKNOPLAST PRIMER 7                | EP  | 2x80 µm         | 1x80 µm  | 2x80 µm          | 2x80 µm   | 2x80 µm | 1x80 µm          |
| TEKNOPLAST HS 150                  | EP  | 1x80 µm         |          |                  |           |         |                  |
| TEKNOMASTIC COMBI 80-500           | EP  |                 | 1x160 µm |                  |           |         |                  |
| TEKNODUR 3410-series               | PUR |                 |          | 1x80 µm          |           |         |                  |
| TEKNODUR COMBI 3430-series         | PUR |                 |          |                  | 1x80 µm   |         |                  |
| TEKNODUR COMBI 340-811             | PUR |                 |          |                  |           | 1x80 µm |                  |
| TEKNODUR COMBI 3560-series         | PAS |                 |          |                  |           |         | 1x160 µm         |
| Total film thickness               |     | 240 µm          | 240 µm   | 240 µm           | 240 µm    | 240 µm  | 240 µm           |
| Paint system VOC, g/m <sup>2</sup> |     | 102             | 73       | 110 - 119        | 114 - 128 | 99      | 44 - 130         |

| Example of Teknos paint system code | Example of paint system structure           |
|-------------------------------------|---|
| TEG5.05/VH/T1                       | ISO 12944-5/G5.05-EP (EP240/3-ZnSaS).       |
| TEG5.05/VH/T6                       | ISO 12944-5/G5.05-EP/PAS (EPPAS240/2-ZnSaS) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

**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 according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity category / offshore environments

**CX**

| Paint system ISO 12944-9 | High     |
|--------------------------|----------|
| <b>CX</b>                | <b>X</b> |
| <b>CX + Im4</b>          |          |
| <b>Im4</b>               |          |

## OFFSHORE PAINT SYSTEMS FOR CARBON STEEL

### Paint systems 280 µm

1 1.8.2018

These paint systems are designed for corrosion protection of carbon steel structures at offshore environments.

These paint systems consist of a zinc rich epoxy primer, an epoxy intermediate coat and a polyurethane top coat.

ISO 12944-9 describes paint systems for high durability according to ISO 12944-1.

| Paint                              |            | <b>CXA1</b> |
|------------------------------------|------------|-------------|
| TEKNOZINC 90 SE                    | <b>EP</b>  | 1x60 µm     |
| TEKNOMASTIC 80 PRIMER              | <b>EP</b>  | 1x160 µm    |
| TEKNODUR 0050                      | <b>PUR</b> | 1x60 µm     |
| Total film thickness               |            | 280 µm      |
| Paint system VOC, g/m <sup>2</sup> |            | 136         |

| Paint                              |            | <b>CXA2</b> |
|------------------------------------|------------|-------------|
| TEKNOZINC 80 SE                    | <b>EP</b>  | 1x60 µm     |
| TEKNOPLAST PRIMER 7 MIOX           | <b>EP</b>  | 1x80 µm     |
| TEKNOPLAST PRIMER 7                | <b>EP</b>  | 1x80 µm     |
| TEKNODUR 0050                      | <b>PUR</b> | 1x60 µm     |
| Total film thickness               |            | 280 µm      |
| Paint system VOC, g/m <sup>2</sup> |            | 168         |

| Example of Teknos paint system code | Example of paint system structure                         |
|-------------------------------------|---|
| TECX/H/A1                           | ISO 12944-9/CX-EPZn(R)/EP/PUR (EPZn(R)EPPUR280/3-FeSa 2½) |
| TECX/H/A2                           | ISO 12944-9/CX-EPZn(R)/EP/PUR (EPZn(R)EPPUR280/4-FeSa 2½) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

**Steel surfaces:** Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1). The surface profile must be at least medium (G) as defined in standard ISO 8503-1.

For more detailed information about of the above-mentioned products please see individual product data sheets.

## Suitable corrosivity category / offshore environments

# CX, Im4, CX + Im4

| Paint system ISO<br>12944-9 | High |
|-----------------------------|------|
| CX                          | X    |
| CX + Im4                    | X    |
| Im4                         | X    |

## OFFSHORE PAINT SYSTEMS FOR SPLASH AND TIDAL ZONES Paint system 600 µm

1 1.8.2018

This paint system is designed for corrosion protection of carbon steel structures in splash and tidal zones, at offshore environments.

This paint system consists of an epoxy paint.

ISO 12944-9 describes paint systems for high durability according to ISO 12944-1.

| Paint                              |    | CXS1     |
|------------------------------------|----|----------|
| TEKNOMASTIC 80 PRIMER              | EP | 3x200 µm |
| Total film thickness               |    | 600 µm   |
| Paint system VOC, g/m <sup>2</sup> |    | 146      |

| Example of Teknos paint system code | Example of paint system structure   |
|-------------------------------------|-------------------------------------|
| TECX/H/S1                           | ISO 12944-9/CX-EP (EP600/3-FeSa 2½) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

**Steel surfaces:** Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1). The surface profile must be at least medium (G) as defined in standard ISO 8503-1.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity category / offshore environments

**Im4**

| Paint system ISO 12944-9 | High |
|--------------------------|------|
| CX                       |      |
| CX + Im4                 |      |
| Im4                      | X    |

## OFFSHORE PAINT SYSTEMS FOR IMMERSION

### Paint system 350 µm

1 1.8.2018

This paint system is designed for corrosion protection of carbon steel structures in immersion conditions at offshore environments.

This paint system consists of an epoxy paint.

ISO 12944-9 describes paint systems for high durability according to ISO 12944-1.

| Paint                              |    | CX11     |
|------------------------------------|----|----------|
| TEKNOMASTIC 80 PRIMER              | EP | 2x175 µm |
| Total film thickness               |    | 350 µm   |
| Paint system VOC, g/m <sup>2</sup> |    | 85       |

| Example of Teknos paint system code | Example of paint system structure   |
|-------------------------------------|-------------------------------------|
| TECX/H/11                           | ISO 12944-9/CX-EP (EP350/2-FeSa 2½) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

**Steel surfaces:** Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1). The surface profile must be at least medium (G) as defined in standard ISO 8503-1.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity category / offshore environments

**CXG**

| Paint system ISO 12944-9 | High |
|--------------------------|------|
| CX                       | Zn   |
| CX + Im4                 |      |
| Im4                      |      |

## OFFSHORE PAINT SYSTEMS FOR HOT DIP GALVANIZED

### Paint system 220 µm

1 1.8.2018

These paint systems are designed for corrosion protection of hot dip galvanized steel structures at offshore environments.

These paint systems consist of an epoxy primer, an epoxy intermediate coat and a polyurethane top coat.

ISO 12944-9 describes paint systems for high durability according to ISO 12944-1.

| Paint                              |     | CXG1     |
|------------------------------------|-----|----------|
| TEKNOPLAST PRIMER 3                | EP  | 1x20 µm  |
| TEKNOPLAST HS 150                  | EP  | 1x140 µm |
| TEKNODUR 0050                      | PUR | 1x60 µm  |
| Total film thickness               |     | 220 µm   |
| Paint system VOC, g/m <sup>2</sup> |     | 122      |

| Example of Teknos paint system code | Example of paint system structure        |
|-------------------------------------|--|
| TECX/H/G1                           | ISO 12944-9/CX-EP/PUR (EPPUR220/3-ZnSaS) |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**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.

**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 according to standard ISO 12944-5 to paint hot dip galvanized objects that are subjected to immersion strain.

For more detailed information about of the above-mentioned products please see individual product data sheets.

**Suitable corrosivity categories/durability ranges**

**TSM**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very high |
|-----------------------------|-----|--------|------|-----------|
| TSM4.01                     | TSM | TSM    | TSM  |           |

**TETSM4.01 High**

**TEKNOPLAST PRIMER 5,  
THERMALLY SPRAYED METAL**

**Paint systems 160 µm**

1 1.8.2018

TEKNOPLAST PRIMER 5 paint systems for thermally sprayed metal consist of epoxy and polyurethane top coats. TEKNOPLAST PRIMER 5 is also used as a sealer on thermally sprayed metal substrates. For sealer usage TEKNOPLAST PRIMER 5 is diluted 20–40 % by volume with TEKNOSOLV 9506. The function of the sealer is to fill the metal pores and to form an even, non-measurable layer on the surface. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity category C4 with durability class high.

|                                    |     | EP-<br>top coat | PUR-<br>top coat |
|------------------------------------|-----|-----------------|------------------|
| Paint                              |     | A1              | A2               |
| TEKNOPLAST PRIMER 5 (Sealer)       |     | NA              | NA               |
| TEKNOPLAST PRIMER 5                | EP  | 1x80 µm         | 1x80 µm          |
| TEKNOPLAST HS 150                  | EP  | 1x80 µm         |                  |
| TEKNODUR COMBI 3430-series         | PUR |                 | 1x80 µm          |
| Total film thickness               |     | 160 µm          | 160 µm           |
| Paint system VOC, g/m <sup>2</sup> |     | 100             | 112 - 126        |

| Example of Teknos paint system code | Example of paint system structure     |
|-------------------------------------|---------------------------------------|
| TETSM4.01/H/A1                      | ISO 12944-5/TSM4.01-EP (EP160/2-TSM). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**Surface preparation** Thermally sprayed metal coatings shall be painted immediately after thermal spraying before any condensation can take place.

For more detailed information about of the above-mentioned products please see individual product data sheets.

Suitable corrosivity categories/durability ranges

**TSM**

| Paint system ISO 12944-5 | Low | Medium | High | Very high |
|--------------------------|-----|--------|------|-----------|
| TSM4.02                  | TSM | TSM    | TSM  | TSM       |
| TSM5.01                  | TSM | TSM    | TSM  |           |

**TETSM4.02 Very high**  
**TETSM5.01 High**

# TEKNOPLAST PRIMER 5, THERMALLY SPRAYED METAL

## Paint systems 200 µm

1 1.8.2018

TEKNOPLAST PRIMER 5 paint systems for thermally sprayed metal consist of epoxy and polyurethane top coats. TEKNOPLAST PRIMER 5 is also used as a sealer on thermally sprayed metal substrates. For sealer usage TEKNOPLAST PRIMER 5 is diluted 20–40 % by volume with TEKNOSOLV 9506. The function of the sealer is to fill the metal pores and to form an even, non-measurable layer on the surface. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity categories C4 – C5 with durability classes very high - high.

|                                    |     | EP-<br>top coat | PUR-<br>top coat |
|------------------------------------|-----|-----------------|------------------|
| Paint                              |     | A1              | A2               |
| TEKNOPLAST PRIMER 5 (Sealer)       |     | NA              | NA               |
| TEKNOPLAST PRIMER 5                | EP  | 1x80 µm         | 1x80 µm          |
| TEKNOPLAST HS 150                  | EP  | 1x120 µm        |                  |
| TEKNODUR COMBI 3430-series         | PUR |                 | 1x120 µm         |
| Total film thickness               |     | 200 µm          | 200 µm           |
| Paint system VOC, g/m <sup>2</sup> |     | 117             | 135 - 156        |

| Example of Teknos paint system code | Example of paint system structure            |
|-------------------------------------|--|
| TETSM4.02/VH/A1                     | ISO 12944-5/TSM4.02-EP (EP200/2-TSM).        |
| TETSM5.01/H/A2                      | ISO 12944-5/TSM5.01-EP/PUR (EPPUR200/2-TSM). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**Surface preparation** Thermally sprayed metal coatings shall be painted immediately after thermal spraying before any condensation can take place.

For more detailed information about of the above-mentioned products please see individual product data sheets.



Suitable corrosivity categories/durability ranges

**TSM**

| Paint system<br>ISO 12944-5 | Low | Medium | High | Very high |
|-----------------------------|-----|--------|------|-----------|
| TSM5.02                     | TSM | TSM    | TSM  | TSM       |

**TETSM5.02 Very high**

# TEKNOPLAST PRIMER 5, THERMALLY SPRAYED METAL

## Paint systems 240 µm

1 1.8.2018

TEKNOPLAST PRIMER 5 paint systems for thermally sprayed metal consist of epoxy and polyurethane top coats. TEKNOPLAST PRIMER 5 is also used as a sealer on thermally sprayed metal substrates. For sealer usage TEKNOPLAST PRIMER 5 is diluted 20–40 % by volume with TEKNOSOLV 9506. The function of the sealer is to fill the metal pores and to form an even, non-measurable layer on the surface. Epoxy paints have from their nature good mechanical and corrosion protection properties. Polyurethane paints have good gloss and colour retention properties outdoors.

Where excellent gloss and colour retention is expected of the surface finish, it is recommended to add 40 µm dry film of TEKNODUR 0250, 0290 or 295-900 clear coat as a top layer on top of the polyurethane (PUR) paint system described below. Please consult TEKNOS representative for choosing the most suitable product.

These paint systems are designed for corrosivity category C5 with durability class very high.

|                                    |     | EP-<br>top coat | PUR-<br>top coat |
|------------------------------------|-----|-----------------|------------------|
| Paint                              |     | A1              | A2               |
| TEKNOPLAST PRIMER 5 (Sealer)       |     | NA              | NA               |
| TEKNOPLAST PRIMER 5                | EP  | 1x120 µm        | 1x120 µm         |
| TEKNOPLAST HS 150                  | EP  | 1x120 µm        |                  |
| TEKNODUR COMBI 3430-series         | PUR |                 | 1x120 µm         |
| Total film thickness               |     | 240 µm          | 240 µm           |
| Paint system VOC, g/m <sup>2</sup> |     | 150             | 168 - 189        |

| Example of Teknos paint system code | Example of paint system structure     |
|-------------------------------------|---------------------------------------|
| TETSM5.02/VH/A1                     | ISO 12944-5/TSM5.02-EP (EP240/2-TSM). |

These Teknos painting systems have been designed in accordance with ISO 12944:2017-2018 standards. In order to reach the durability ranges in specified corrosivity categories, care must be taken to ensure full compliance of steel construction design, steel prework and surface preparation quality with ISO 12944 standards.

**Surface preparation** Thermally sprayed metal coatings shall be painted immediately after thermal spraying before any condensation can take place.

For more detailed information about of the above-mentioned products please see individual product data sheets.