

TEKNOCRYL AQUA COMBI 2780

water-borne single coat paint

PAINT TYPE	TEKNOCRYL AQUA COMBI 2780 is an air-drying water-borne primer and single coat paint based on acrylate dispersion and alkyd. Contains active anticorrosive pigments.
USAGE	Intended for single coat painting, but can also be used as primer in systems including a top coat, e.g. TEKNOCRYL AQUA 2790. Can be used both in- and outdoors for painting on steel, aluminium or zinc.
SPECIAL PROPERTIES	The paint dries quickly and has very good anticorrosive properties. Can be applied in film thickness up to 100 µm dry film without any risk of runnings.

TECHNICAL DATA

Solids 41 ±2% by volume

Total mass of solids abt. 560 g/l

Volatile organic compound (VOC) abt. 44 g/l

Recommended film thickness and theoretical spreading rate	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m ² /l)
	40	97	10,2
	80	195	5,1
	100	245	4,1

As many of the paint's properties will change if too thick coats are applied, it is not recommended that the product is applied to a film thickness that is more than double of the thickest recommended film.

Practical spreading rate The values depend on the application technique, surface conditions, overspray, etc.

Drying time at +23°C / 50% RH (dry film 40 µm)

- dust free (ISO 9117-3:2010) after 30 min
- touch dry (DIN 53150:1995) after 45 min

Overcoatable, 50% RH (dry film 40 µm)

surface temperature	by itself or by TEKNOCRYL AQUA 2790	
	min.	max.
+15°C	after 6 h	-
+23°C	after 3 h	-

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

Thinner Water

Clean up Water, possibly with an addition of TEKNOSOLV 1612 if the paint has started to dry.

Finish Semi-matt

Colours Certain colours are delivered from stock. Can be adjusted individually for customers by agreement.

SAFETY MARKINGS See Safety Data Sheet.

DIRECTION FOR USE**Surface preparation**

Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods. The surfaces are prepared according to the different materials as follows:

STEEL SURFACES: Remove mill scale and rust by blast cleaning to preparation grade Sa 2½ (standard ISO 8501-1). Roughening the surface of thin-plate improves the adhesion of the paint to the substrate.

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. Painting of hot-dip-galvanized objects that are subjected to immersion strain must be discussed separately with Teknos.

It is recommended that new zinc-coated thin-plate structures are treated with sweep blast-cleaning (SaS). Surfaces that have been weathered to matt can be treated also with RENSA STEEL washing agent for galvanized surfaces.

ALUMINIUM SURFACES: Treat the surfaces with RENSA STEEL washing agent for galvanized surfaces. Surfaces that are exposed to weathering are also roughened up with sweep blast-cleaning (AlSaS) or sanding.

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

The place and time of the preparation are to be chosen so that the prepared surface will not get dirty or damp before the subsequent treatment.

Prefabrication primer

KORRO PVB, KORRO E Epoxy and KORRO SS Zinc Silicate Prefabrication primers can be used, when required.

Cleaning of spraying equipment etc. before painting

1. Rinse with TEKNOSOLV 1639 or similar.
2. Rinse with TEKNOSOLV 1612 or ethanol.
3. Rinse with water.

Application

Before use stir the paint thoroughly.

Apply preferably by airless spray or airless spray equipped with air-assisted pistol (nozzle 0.013 - 0.018"). The paint is sprayed evenly to the specified film thickness. Special care should be taken when spraying edges, corners and welding joints. Small areas can also be painted with a brush, but in this case one additional coat has to be applied in order to achieve the specified film thickness.

Application conditions

The surface must be dry. The temperature of the ambient air, the surface and the paint shall be above +15°C and the relative air humidity 35-50%. Low relative humidity increases the risk of dry spray, and the levelling may also be poorer. Additionally the temperature of the surface to be painted and the paint must be at least 3°C above the dew point of the ambient air.

The spray booth

For selection of suitable additives for the water curtain booth contact the supplier of these chemicals. Different types of water-borne paints often demand different additives, and therefore this must be determined for each case separately.

The drying process

In a water-borne paint the water and the film forming agents must have totally evaporated from the paint film before it is subjected to moisture and cold. Painted objects are by normal ventilation conditions to be kept indoors at a temperature of min. +20°C for a minimum of 40 hours.

The relative air humidity must not exceed 60% and the drying temperature must not be below +15°C. High air humidity increases the time of evaporation for the water in the paint and thus prolongs the drying time. This can be prevented by increasing the temperature and/or the ventilation. Increased temperature results in a higher saturation point of the water vapour in the air, and the increased ventilation removes the water vapour more quickly. These measures shorten the drying time considerably.

ADDITIONAL INFORMATION

The storage stability is shown on the label. Store in a cool place and in tightly closed containers. Do not transport or store the paint in temperatures below 0°C.

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

MUST NOT FREEZE.

The information of this data sheet is normative and based on laboratory tests and practical experience. Teknos guarantees that the product quality conforms to our quality system. Teknos accepts, however, no liability for the actual application work, as this is to a great extent dependent on the conditions during handling and application. Teknos accepts no liability for any damage resulting from misapplication of the product. This product is intended for professional use only. This implies that the user possesses sufficient knowledge for using the product correctly with regard to technical and working safety aspects. The latest versions of Teknos data sheets, material safety data sheets and system sheets are on our home pages www.teknos.com.



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