

PAINT TYPE	TEKNOPLAST PRIMER 7-01 is a two-pack solvent borne epoxy primer with low solvent content.
USE	Used as a priming coat in abrasion and chemical resistant Epoxy Coating Systems. Can also be used for priming zinc, aluminium, thin-plate and acid-proof steel surfaces and as an intermediate coat over zinc epoxy and zinc silicate primers.
SPECIAL PROPERTIES	The paint is quickly overcoatable and is therefore suited to a fast painting tempo. It is also suitable for application by twin-feed spray. The paint film withstands heavy abrasion, oils, grease, solvents and chemical splashing. When painting at temperatures below +10 °C either TEKNOPLAST PRIMER WINTER HARDENER 7399 or TEKNOPLAST WINTER HARDENER 7212 is to be used. The paint comes up to the specifications of Swedish Standard SSG 1021 type GA.

TECHNICAL DATA

Mixing ratio	Base (Comp. A): Hardener (Comp. B): TEKNOPLAST HARDENER	4 parts by volume 1 part by volume
Pot life, +23 °C	3 h	
Solids	66 ± 2 % by volume (ISO 3233:1988)	
Total mass of solids	Abt. 1100 g/l	
Volatile organic compound (VOC)	Abt. 320 g/l	
Recommended film thickness and theoretical spreading rate	Dry film (µm) 80 120	Wet film (µm) 121 181
		Theoretical spreading rate (m ² /l) 8.2 5.5

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 the 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 80 µm)

- dust free (ISO 1517:1973) After 1 hour
- touch dry (DIN 53150:1995) After 4 hours

- overcoatable (dry film 80 µm)

surface temperature	by itself		by TEKNOPLAST top coats		by TEKNODUR top coat or TEKNODUR AQUA top coats	
	min.	max.*	min.	max.*	min.	max.*
+10 °C	after 4 h	after 6 months	after 4 h	after 6 months	after 12 h	after 7 d
+23 °C	after 1 h	after 6 months	after 2 h	after 6 months	after 2 h	after 3 d

* Maximum overcoating interval without roughening.

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

Thinner	TEKNOSOLV 9506.
Clean up	TEKNOSOLV 9506 or TEKNOPLAST 9530.
Finish	Semi-matt.
Colours	Light grey, light yellow and RAL 5015.
HEALTH AND SAFETY	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 to paint galvanized objects that are subjected to immersion strain. 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 suitable Cleaning Agent.

ALUMINIUM SURFACES: Treat the surfaces with suitable Cleaning Agent. 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 E Epoxy, KORRO SE Zinc Epoxy and KORRO SS Zinc Silicate Prefabrication Primers can be used, when required.

Mixing of the components

Take into consideration the pot life of the mixture when estimating the amount to be mixed at a time. Before painting the base and hardener are mixed in right proportion. Stir thoroughly down to the bottom of the vessel. Inadequate stirring or incorrect mixing ratio results in imperfect curing and impaired film properties.

Application conditions

The surface to be painted must be dry. During the application and drying period the temperature of the ambient air, the surface and the paint shall be above 10 °C and the relative air humidity below 80 %.

Additionally the temperature of the surface to be painted and the paint must be at least 3 °C above the dew point of the ambient air.

When using TEKNOPLAST PRIMER WINTER HARDENER 7399 or TEKNOPLAST WINTER HARDENER 7212 the temperature of the ambient air and the surface to be painted shall be over -5 °C. The temperature of the paint during the mixing and application is to be above +15 °C.

Application

Before use stir the paint thoroughly.
If required, dilute the paint with TEKNOSOLV 9506.

Apply preferably by airless as only this method provides the recommended film thickness in a single operation. Use airless spray nozzle 0.013" - 0.019". Brush or roller can be used for touching up and painting small areas.

When twin-feed spray is used for application, the mixing ratio of the dosage pump must be 4:1. The feed pump pressure and the consumption of components are to be checked during application to ensure of the correct mixing ratio. The components cannot be thinned if twin-feed spray with fixed ratio is used.

ADDITIONAL INFORMATION

The storage stability is shown on the label. Store in a cool place in a tightly closed containers.

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