

**Suitable corrosivity categories/durability ranges**

**C**

Paint system 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 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.