TEKNOZINC 3233

1C moisture cure zinc-rich primer

Zinc-rich corrosion protective MCU (moisture cured urethane) primer for steel.

It is useful for corrosion protection of sandblasted steel constructions.
TEKNOZINC 3233 offers a good cathodic corrosion protection, similar to galvanizing, excellent resistance to mechanical wear, tested resistance to hydraulic oils and diesel fuels (1000 h at 60 °C).
Weldability: tested according to DVS guideline 0501 editions 03/76.

TECHNICAL DATA

Fields of application	Steel constructions
Recommended substrate	Steel
Binder	Zinc dust
Solids	Approx. 62% by volume Approx. 87% by weight
Volatile organic compound (VOC)	Approx. 330 g/l (DIRECTIVE 2010/75/EU) The VOC value provided is the average value for factory produced products, and consequently it will be subject to variations between individual products covered by this Technical Data Sheet.
Theoretical spreading rate	

Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m^2/l)
60	100	10.3
80	140	7.75

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.
Colours	RAL 7012
Gloss (60°)	Matt
Thinner	TEKNOSOLV 6740-03 or TEKNOSOLV 6740.
Density	Approx. 2.6 g/ml
Storage	The storage stability is shown on the label. Store in a cool place and in tightly closed containers.

DIRECTION FOR USE

Surface preparation	Remove from the surfaces any contaminants that might be detrimental to surface preparation and application. 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. 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. Additional instructive information for surface preparation can be found in standards EN ISO 12944-4 and ISO 8501-2.
Application method	Airless spraying, Conventional spraying, Brush
Application	Stir thoroughly before use. Suitable airless nozzle size 0.013 - 0.017" Before use clean the spray gun and paint vessels with a thinner suitable for the paint. If required the paint can be diluted with TEKNOSOLV 6740-03 or TEKNOSOLV 6740.
Application conditions	The surface to be treated must be dry. During the application and drying period the temperature of the ambient air and the surface shall be at least above +5°C, and the temperature of the product above +15°C during mixing and spraying. The temperature of the surface to be treated must be at least +3°C above the dew point of the ambient air.

Drying time	+23°C / 50% RH (dry film 60 µm)
- dust free	20 min
- touch dry	1 h
- dry to handle	24 h
Overcoatable	

Surface temperature	**By topcoats of the TEKNODUR or TEKNOCRYL series**	
	Min.	Max.
+5°C	3 h	6 months
+23°C	1 h	6 months

Given times relates to the recommended coating thickness, drying in good ventilation conditions.
The relative humidity should be at least 30%, due to moisture curing mechanism of the paint. Low humidity can be prolonging the drying time.

Cleaning	TEKNOSOLV 6740-03 or TEKNOSOLV 6740.

HEALTH AND SAFETY

Safety and precaution measures	See safety data sheet.

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