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Composition Mixture of pigments, fillers and Zn phosphate in solution of acrylic resin in organic solvents with addition of UV stabilizers, hardened with aliphatic polyisocyanate.

Characteristics and use The paint is determined as a high build coating for anticorrosive protection of steel in highly exposed corrosive environments C3 to C5 according to EN ISO 12944-2. The paint is possible to use as a top enamel on the surface treated with suitable epoxy or polyurethane primer or as a single coat directly onto the prepared steel substrate. Before use the paint is mixed properly with the hardener in specified ratio. The final properties of coat are achieved after complete maturing ca 7 days.

- ◆ quick drying
- ◆ high-solid paint, high spreading capacity
- ◆ excellent corrosion protection
- ◆ good chemical and mechanical resistance
- ◆ it stays on vertical surfaces
- ◆ suitable for the tinting system HOSTEMIX
- ◆ TELPUR T330 HS is suitable for **direct** food contact (selected shades)

Application area Exterior and interior with medium and high corrosive stress e.g. chemical plants, buildings and areas of almost constant condensation and high contamination.

Shades According to BALT, RAL, NCS and ČSN colour chart and the others according to individual customer requirements.

Physical properties	Flow time	30 – 50 s (cup Ford Ø 6 mm)
	Weight solids	75 ± 2 %
	Volume solids	64 ± 2 %
	Flash point	> 25 °C
	Density of product	1350 - 1450 kg/m ³
	Density of hardened mixture	1320 - 1400 kg/m ³

Emission limits	VOC: 0.22 – 0.26 kg/kg of hardened mixture	TOC: 0.19 - 0.23 kg/kg of hardened mixture
	This product is for professional use only. Not for DIY.	

Properties of cured coat	Hiding power	degree 1 - 2
	Gloss / 60°	< 50
	Hardness / Persoz	up 12 % after 24 h

Drying time	Surface temperature	10 °C	23 °C
	Dust free	3 h	1.5 h
	Dry through	24 h	24 h
	Dry film thickness DFT	100 µm	100 µm

Spreading capacity	Wet film thickness WFT	160 µm	250 µm
	Dry film thickness DFT	100 µm	160 µm
	Theoretical spreading capacity	4.5 - 5 m ² /kg	2.8 – 3.1 m ² /kg

Thinning TELSOL PUR 3, BALTECH U6003, to thin after hardening.
Other diluents (especially those containing alcohols) can significantly slow down the curing mechanism of the chemical reaction.

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**Hardening**

Hardener: TELHARD PUR HS, TELHARD PUR, TELHARD PUR 4

Mixing ratio: 100 weight parts TELPUR T330 HS : 7 weight part TELHARD PUR HS.
100 weight parts TELPUR T330 HS : 8 weight part TELHARD PUR
100 weight parts TELPUR T330 HS : 10 weight part TELHARD PUR 4*

The pot life of the hardened mixture is 90 minutes (20 °C).

In the case TELHARD PUR hardener is used, the volume solids of the mixture is reduced to 62 ± 2% vol.

* when using the hardener TELHARD PUR 4 the gloss increases (50-60)

Surface preparation

For corrosive environment C3, C4 and C5 the surface must be prepared by blast-cleaning to degree Sa 2 ½ according to EN ISO 8501-1 (welds and edges must be prepared according to EN ISO 8501-3).

It is necessary to clean, degrease and remove poorly adhering old coats from previously painted surfaces. To ensure compatibility of new coat with old one it is recommended to contact the producer or carry out test reference coating on surface of 1 m².**Application conditions**

Stir the paint properly with a mechanical stirrer before use so that there will be no sediment on the bottom and harden. To thin and filter if it necessary.

The temperature of the paint itself should be 15-25 °C. If the paint temperature is below 15 °C, a higher dilution is required and this can subsequently cause problems with the formation of a homogeneous paint film and a longer drying time.

For coating / spraying outside the suitable weather forecast is necessary. During rain, fog, creation of condensation water, effect of aggressive gases and during wind with strong content of dust the coating work must be suspended and can be restart after absolute drying of surface-treated material. Minimal air temperature for application is 10 °C, temperature of painted surface must be 3 °C above dew point. Temperature and relative humidity must be measured in proximity of painted surface. The surface temperature must not be higher than 40 °C. Relative humidity must not be higher than 75 %. Lower temperature and higher humidity during an application and a drying and high thickness of applied coats markedly slow down drying and hardening of the coat. Imperfectly dried surface can cause problems with adhesion of paint to surface or with adhesion between individual coats. In addition, it can negatively affect overall appearance of the paint film and can lead to reduced gloss or other irreversible surface defects such as graying and whitish haze. Both the paint and the object to be treated, as well as the surrounding environment, must have a suitable temperature. Condensation that occurs during or just after application can cause a matte finish and poor quality paint film.

If the paint film is prematurely exposed to standing water, the shade may change, especially in dark shades and at low temperature.

Thermal resistance

Thermal resistance of the cured coat: up to 120 °C: without restrictions, the hardness of the coating film gradually increases during long-term loading and the flexibility decreases. At temperatures of 120 °C to 150 °C, visual changes, gradual increase in hardness, decrease in flexibility and embrittlement of the coating film may occur.

Workflow**Combined coating system:**

Apply 1 coat (by spraying) of TELPOX P170 or TELPOX PM 150, dry film thickness 80 - 120 µm, drying time 24 hours.

Apply 1 or 2 coats (by spraying) of TELPUR T330 HS, dry film thickness 80 - 120 µm

Single coating system:

Apply 1 or 2 coats (by spraying) of TELPUR T330 HS, dry film thickness should be at least 120µm. If necessary, recoating is possible after 20 minutes by the system so-called "wet into wet".

The paint is applied by cross spraying or in parallel strips to achieve a final uniform layer. First it is necessary to treat problematic places (corners, edges, welds, surface defects).

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It is very important to apply each coat in a uniform layer, in a thickness specified by the specific paint system. Consumption of paint must be checked to avoid excessive thickness, to avoid splashing, cracking and solvent retention.

For larger compact areas always use the material from the same batch. Using the same batch can guarantee the same shade of the colour. We recommend mixing the content of the individual cans by homogeneous mixing.

The stability of some shades may be influenced by exposure to harsh chemical environments. But it does not affect a protective characteristics of the coating.

For some shades it may be necessary to apply an additional coat to ensure full hiding power.

Optimal thickness of system

The optimal thickness and composition of the paint system depends on the aggressivity of atmosphere and on the expected durability of a protective system. The selection of an appropriate system should be in accordance with EN ISO 12944-5: 2018.

Application

Airless/AirMix spraying (5 – 15 % thinning according to the type of spraying device)

Application data

Data for airless spraying Airless/AirMix (tested on the device EcoPump VP 55 445, 64:1 gear ratio, in combination with air assist spraying gun EcoGun 2100 (DÜRR))

Device	Nozzle	Pressure on nozzle	Thinning
AirMix	0.011 inch (0.28 mm)	12-18 Mpa (120-180 atm) air assist 1.0-2.0 atm	5-15 %
AirMix	0.013 inch (0.33 mm)	12-18 Mpa (120-180 atm) air assist 1.0-2.0 atm	5-15 %
Airless	0.011 inch (0.28 mm)	15-20 Mpa (150-200 atm)	5-10 %
Airless	0.013 inch (0.33 mm)	15-20 Mpa (150-200 atm)	5-10 %

Recommended filter of spraying gun yellow 100/149 (mesh/ µm), spraying angel 20 – 60°. It is not recommended using free adjustable nozzle.

We recommend using a powerful pneumatic device with a higher gear ratio of at least 56: 1.

It is recommended to include a reverse valve into the pump.

Handling

Read the instructions in the Safety Data Sheet before use and follow all safety instructions and regulations. The product contains organic solvents. Follow basic hygiene rules. Do not eat, drink or smoke while using this product. Avoid contact with eyes, skin or clothing. Wear protective gloves, eye protection, protective clothing. Ensure effective ventilation of the workplace.

Packing

10 kg; 20 kg (tinted, not hardened product)

Storability

The product keeps the product qualities 5 years from production date in original closed container. To store in dry storage at the temperature 5 to 25 °C. Flammable liquid II. hazard class.

Disposal of packing and waste

Hand over the used, properly empty packing at the collection point of the packing waste. Dispose the packing with the product rest at the place determined by the town for disposal of hazardous waste or hand over to the person authorized for hazardous waste disposal. Further see the product safety data sheet.

These data are only for information and their accuracy is influenced by the properties of individual materials and unpredictable factors during application. The user is responsible for correct use of the product according to the direction for use and for correct application of painting system, i.e. he must always evaluate all conditions of application, which could influence final quality of the top treatment. Therefore, we always recommend to the user to carry out the test for actual working conditions and type of surface applied. Above mentioned data are data, which influence individual working conditions and therefore they do not establish a legal claim. It is necessary to consult information outside the terms of this catalogue sheet with the producer.

The producer stipulates the right for the change in the catalogue sheets without previous notification.