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Composition Mixture of inorganic pigments, zinlphosphate and fillers in solution of modified alkyd resin in organic solvents.

Characteristics and use The paint TELKYD P160 is determined for high build prime coats on metal and steel surfaces, mainly under two component polyurethane and epoxy enamels. Temperature during drying must not decrease under 10 °C, drying can be accelerated at the temperature 60 °C during 30 minutes. The coating film resists dry heat up to 80 °C, but with prolonged heat exposure, the shade gradually changes and the coating becomes brittle.

- ◆ excellent adhesion to steel surfaces
- ◆ quick drying
- ◆ suitable under 2K PUR and 2K POX topcoats
- ◆ does not affect the gloss of topcoats
- ◆ it stays on vertical surfaces

Application area Exterior and interior with medium and high corrosive stress, e.g. chemical plants, industrial zones, coating of traffic devices.

Shades RAL 7035 grey, RAL 1014 ivory

Physical properties	Flow time	30 – 40 s / Ø 6 mm Ford
	Weight solids	ca 67 %
	Volume solids	ca 45 %
	Flash point	> 25° C
	Density of product	ca 1450 kg/m ³

Emission limits	VOC: 0.33 kg/kg	TOC: 0.29 kg/kg
	This product is for professional use only. Not for DIY.	

Properties of cured coat	Hiding power	degree 1 - 2
	Gloss / 60°	< 20
	Hardness / Persoz	up 10 % in 2 days
	Adhesion with crosshatch test	degree 0

Drying time	Surface temperature	23 °C
	Dust free	15 min
	Dry through	4 h
	Dry film thickness DFT	40 µm

Spreading capacity	Wet film thickness WFT	110 µm	220 µm
	Dry film thickness DFT	50 µm	100 µm
	Theoretical spreading capacity	6.2 m ² /kg	3.1 m ² /kg

Thinning BALTECH S6005, TELSOL BR 5, TELSOL UNI

Surface preparation For corrosive environment C2, C3 and C4 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.

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Application conditions

Stir the paint properly with a mechanical stirrer before use so that there will be no sediment on the bottom. 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.

Do not apply the paint on a hot summer day.

Stackability must be tested for specific conditions (climatic conditions, thickness, number of coats, the shape of the substrate, substrate type, etc.).

Workflow

Application by Airless/Airmix:

1. Apply 1coat of two-component polyurethane primer TELKYD P160. Drying 4 hours (20 °C), recommended dry film thickness is 80 - 100 µm.
2. Apply 1 or 2 coats of two-component polyurethane enamel TELPUR T340 HS or enamel TELPUR T360.

Application by conventional spraying:

1. Apply 2 coats of two-component polyurethane primer TELKYD P160. Recoating is possible by the system so-called "wet into wet" within 10 – 15 minutes. Recommended dry film thickness is 80 – 100 µm. Drying 4 hours (20 °C).
2. Apply 1 or 2 coats of two-component polyurethane TELPUR T360 or two-component polyurethane enamel TELPUR T340 HS. Optimal dry film thickness of one coat is 40 µm (total 80 µm).

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).

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. It is not recommended to exceed twice the recommended film thickness.

For larger compact areas always use the material from the same batch. Using the same batch can guarantee the same shade of the colour.

For the finished coating system, it is advisable to establish a maintenance plan within the expected durability of the protective system according to EN ISO 12944-8:2018. The choice of the appropriate type (level) of maintenance is then mainly dependent on the state of corrosion attack (ISO 4628-3).

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.

Product may be specified in another film thickness than indicated depending on purpose and area of use. Therefore this can alter spreading rate, drying time, overcoating interval and the expected durability of a protective system.

Application

Airless/Airmix spraying (5 – 15 % thinning depending on the type of device)

Conventional spraying (recommended viscosity 25 – 35 s / cup Ford Ø 4 mm; 10 - 15 % thinning)

Application data

Data for conventional spraying

Spraying gun e.g. EST 315, EcoGun 116, EcoGun 246

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Nozzle according to desired capacity; nozzle 1.4 – 2.0; Air pressure 1.5 – 2 atm.

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)). Spray data are only indicative and subject to adjustment to the type of spraying equipment used.

Device	Nozzle	Pressure on nozzle	Thinning
AirMix	0.011 inch (0.28 mm)	12-17 Mpa (120-170 atm) air assist 1.5-2.5 atm	5-15 %
AirMix	0.013 inch (0.33 mm)	15-20 Mpa (150-200 atm) air assist 1.5-2.5 atm	5-10 %
Airless	0.011 inch (0.28 mm)	15-20 Mpa (150-200 atm)	5-10 %
Airless	0.013 inch (0.33 mm)	17-25 Mpa (170-250 atm)	5 %

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

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

25 kg; 5 kg

Storability

The product keeps the product qualities 24 months 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.