

Page number: 01



**Composition** Mixture of inorganic pigments, fillers and iron mica in solution of medium molecular epoxy resin in organic solvents with addition of additives.

**Characteristics and use** The paint is determined for undercoats (interlayer) of painting system of steel surfaces, where there are high requirements for anticorrosive protection. The paint contains special type of filler – iron mica, which ensures barrier protection of painting systems with e.g. epoxy, polyurethane and other paints. Before use the paint is mixed properly with the hardener in specified ratio.

- ◆ excellent anticorrosive properties
- ◆ barrier protection with iron mica
- ◆ it ensures long-term lifetime of painting systems
- ◆ suitable for indirect food contact

**Application area** Exterior and interior with medium and high corrosive stress, e.g. steel constructions, pylons, bridges, halls, chemical plants.

**Shades** 0517 – green, 0660 – beige

<b>Physical properties</b>	Flow time	medium, short (thixotropic character)
	Weight solids	ca 77 %
	Volume solids	65 % (hardened mixture)
	Flash point	24 °C
	Density of hardened mixture	1760 kg/m <sup>3</sup>

<b>Emission limits</b>	VOC: 0.30 kg/kg of hardened mixture	TOC: 0.25 kg/kg of hardened mixture
	This product is for professional use only. Not for DIY.	

<b>Properties of cured coat</b>	Hiding power	degree 1
	Gloss / 60°	< 20
	Adhesion with crosshatch test	degree 0 - 1
	Hardness / Persoz	up 20 % after 24 h

<b>Drying time</b>	Surface temperature	10 °C	15 °C	23 °C
	Dust free	2 h	2 h	1h
	Dry through	8 h	6 h	5h
	Dry film thickness DFT	80 µm	80 µm	80 µm

<b>Spreading capacity</b>	Wet film thickness WFT	60 µm	125 µm
	Dry film thickness DFT	40 µm	80 µm
	Theoretical spreading capacity	9.2 m <sup>2</sup> /kg	4.6 m <sup>2</sup> /kg

**Thinning** TELSOL POX, S 6300, to thin after hardening.

**Hardening** Hardener: TELHARD POX, TELHARD POX RAPID

**Mixing ratio:** 100 weight parts TELPOX P 120: 13 weight parts TELHARD POX.  
100 weight parts TELPOX P 120: 6 weight parts TELHARD POX RAPID

For TELHARD POX the pot life of the hardened mixture is 8 hours (20 °C). For TELHARD POX RAPID the pot life of the hardened mixture is 2 hours (20 °C).

Page number: 02

**Surface preparation** For corrosive environment C3, C4 and C5 the steel surface must be prepared by blast-cleaning to degree Sa 2 ½ according to EN ISO 8501-1 (welds and edges must be finished according to EN ISO 8501-3). The blasted surface must be provided with prime epoxy coat with content of zinc dust, respectively with ethylsilicate coat with content of zinc dust.

**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.  
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.  
At lower temperatures, it is only possible to use TELHARD POX RAPID hardener.

**Workflow**

1. Apply 1 coat of anticorrosive zinc primer TELPOX P 110. Drying 24 hours (20 °C), optimal dry film thickness of zinc primer should be approximately 35-40 µm.
2. Apply 1 coat of two-component epoxy primer with iron mica TELPOX P 120. Drying 24 hours (20 °C), recommended dry film thickness is 80 µm. The temperature during drying must not decrease below 10 °C.
3. Apply 2 coats of two-component polyurethane enamel TELPUR T 330 HS or two-component epoxy enamel TELPOX T 300. 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.

**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 spraying (without thinning)  
Conventional spraying (recommended viscosity 25 – 30 s / cup Ford Ø 4 mm; ca 10 % thinning)  
Brush (without thinning)  
Application by brush is recommended only for small areas and for corrections.

**Application data** **Data for conventional spraying**  
Spraying gun e.g. EST 311, EST 314 or EST 115  
Nozzle with bigger diameter, e.g. 23; Air pressure 3 – 3.5 atm.

**Data for airless spraying, e.g. VYZA VARIO 56-45 (EST)**

Nozzle	Pressure on nozzle	Spraying angle	Filter of spraying gun
0.013 inch (0.33 mm)	22 Mpa (220 atm)	20 – 60°	It is recommended to remove filters from the device.
0.015 inch (0.38 mm)	22 Mpa (220 atm)	20 – 60°	

It is not recommended using free adjustable nozzle.

Page number: 03

<b>Handling</b>	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.
<b>Packing</b>	25 kg (not hardened product)
<b>Storability</b>	The product keeps the product qualities 12 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.
<b>Disposal of packing and waste</b>	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.