

TECHNICAL DATA SHEET

Item number: 0503-022-XXXX

Product name: ALMAKOR COMBI

ALMAKOR COMBI

Product description: Anticorrosive alkyd primer, air drying. It is ideal for priming steel and cast iron surfaces. The product is characterized by good adhesion and mechanical resistance. In a set with ALMALUX modified alkyd enamel, it protects against corrosion and against weather conditions and changing temperatures.

The product has been tested and approved by industrial customers.

CERTIFICATE of the Medical University of Gdańsk issued by the Division of Environmental Toxicology - hygienic certificate No. 412/322/421/2017.

National Technical Assessment issued by the Road and Bridge Research Institute in Warsaw no.IBDIM-KOT-2020/0610 1st edition.

RECOMMENDED USE

- primer in alkyd coating systems
- temporary anti-corrosion protection during transport and storage

for priming:

- sheet metal, metal elements
- railings, fences, balustrades
- steel gates, wrought furniture, gratings, garden decoration
- farming equipment elements

TECHNICAL PROPERTIES

- | | |
|---|-------|
| • Density, ($\pm 0,1$) kg/dm ³ | 1,4 |
| • Recommended film thickness per one coat/layer, μm . | 45/80 |
| • Drying time (20°C): 1 degree (dust free), min | 15 |
| 3 degree (dry-to-touch), min | 30 |
| • Theoretical coverage at film thickness 40 μm dm ³ /m ² | 0,07 |
| • Solids content (± 2), % by volume | 65 |
| • VOC in ready-to-use product, g/l | 490 |
| • Recommended number of layers | 1-2 |

GLOSS: eggshell

COLOR: oxide red shades off grey graphite
 oxide yellow brown black white

alma-color®

PRODUCT APPLICATION

Stir thoroughly before use (remove the skim coat if present)

Product application method

- airless spraying: $\varnothing 0.38 \div 0.43$; pressure 150 \div 200 bar; air shield 2 bar
- brush
- pneumatic spraying nozzle $\varnothing 1.6 \div 2.0$ mm, pressure 3-4 bar, distance 15-20 cm
- immersion

Thinner: item number 8002. Amount of thinner: 0-5% by volume.

It is recommended to apply the primer in temperatures above 15°C.

APPLICATION

Surface- the higher degree of surface cleanness the longer period of paint durability. The paint achieves the highest chemical and mechanical resistance when applied directly on steel that was sand-blasted or shot-blasted to at least Sa 2 ½ * cleanness degree.

Steel surface cleaned to at least St2* or St 3* cleanness degree (manual cleaning or with the use of power tools) i.e. dry and free from salts, grease, oil and dust. The surface must be free from oil, grease, dust, poorly adhering mill scales, rust, paint and other contaminants.

* Additional information on surface preparation can be found in ISO 12944-4 and ISO 8501-2.

Time to apply the next layers:

It is recommended to apply within 1-5 hours from the application of the previous coat.

The times given apply to the recommended coating thickness, drying in good ventilation conditions. These times may change with changes in temperature, ventilation conditions, the number of layers and the thickness of the coating.

ADDITIONAL INFORMATION

The minimum thickness of the set of ALMAKOR COMBI AND ALMALUX must not be less than 120µm to ensure the C3 corrosivity class and L durability of the steel substrate.

Painting conditions

- surface temperature above dew point (avoiding condensation)
- good ventilation



National Technical Assessment No. IBDiM-KOT-2020/0610 1st edition.

SHELF LIFE: 12 months from the production date in original unsealed container.

The above information cannot be considered complete or comprehensive. This information is based on laboratory research and practical experience and is to the best of our knowledge. As a manufacturer, we are not able to monitor the conditions in which the product is used, as well as many factors affecting the final effect of its use. We are not responsible for any damage caused by using the product in a manner inconsistent with the recommendations or for inappropriate purposes. We reserve the right to change the instructions without prior notice.

Updating 03.2021

ATTENTION! This product is designed for professional use in the given industry. Detailed information regarding product safety can be found in the MSDS.