
TECHNICAL DATA SHEET

3 02.09.2014

Page 1 of 3

GORI 644-00Larch wood primer

GORI 644, a 2-component water borne primer for the treatment of larch wood designated for exterior use such as windows and doors.

TECHNICAL DATA

Binder:	Synthetic binder	
Solid content:	White:	approx. 55 % w/w
	Colourless:	approx. 30 % w/w
Volatile organic compound (VOC):	See Safety Data Sheet.	
Colour range:	White and colourless	

APPLICATION DETAILS See page 2 and 3 for respectively spray application and flow coat / dipping application.

HEALTH AND SAFETY See Safety Data Sheet.

ADDITIONAL INFORMATION

Pack size:	20 l (Content: Colourless: 7.5 l and white 9 l)
Storage:	The product must be stored at temperatures above 5 °. Shelf life in unopened containers: See "Best before date" on the label. Keep containers tightly closed after use.

The above information is normative and based on laboratory tests and practical experiences. The information is noncommittal, and we cannot accept liability for the results obtained under working conditions beyond our control, and consequently the buyer or the user is not released from the obligation to test the suitability of our products for specific means and application methods under the actual application conditions. Our liability covers only damage caused directly by defects in the products supplied by Teknos. The latest versions of Teknos' Technical Data Sheets and Safety Data Sheets are available from our homepage www.teknos.com.

TECHNICAL DATA SHEET

3 02.09.2014

Page 2 of 3

GORI 644-00

APPLICATION DETAILS – SPRAY APPLICATION

Pre-treatment: The wood must be clean and free from wood dust and contamination. The moisture content of the wood should be approx. 13 % and should not exceed 15 %.

All softwood should be treated with a wood preservative.

Mixing ratio:	White:	1.8 parts by volume	GORI 644: 1 part by volume	HARDENER 7531
		2.4 parts by weight	GORI 644: 1 part by weight	HARDENER 7531
	Colourless:	1.5 parts by volume	GORI 644: 1 part by volume	HARDENER 7531
		1.5 parts by weight	GORI 644: 1 part by weight	HARDENER 7531

Application: Airmix (aircoat) or airless by hand or in automatic spraying equipment.

Application conditions: Stir the product well before use. After adding HARDENER 7531 the product is stirred with mechanical stirring equipment and the mixture rests for 10 min., then stir again.

Spraying conditions:	<u>Nozzle</u>	<u>Pressure</u>	<u>Air support</u>
	Airless flat 0.28 mm	100-110 bar	
	Aircoat flat 0.28 mm	80-100 bar	1.0-1.5 bar
	Film thickness:		150-200 µm wet
	Theoretical consumption:		5-7 m ² /l
	Optimum temperature for products and surroundings:		18-22 °C
	Minimum product temperature by use:		18 °C
	Optimum relative air humidity:		approx. 50 %

Pot life: 8 hours

System treatment: Primed parts must always be protected with a topcoat treatment before they are exposed to the influence of the weather.

Drying times: Determined at 20 °C and 50 % relative humidity:

Dry to handle:	1-2 hours
Dry to sand* / recoat:	3-4 hours

*As the layer thickness is of paramount importance for the effectiveness of the product, it is important not to sand the surface too much.

The drying time can be reduced using special drying systems to force drying. The drying times are approximate and may vary according to wood quality, temperatures, humidity, ventilation and film thickness.

Cleaning: The equipment is cleaned with water.

TECHNICAL DATA SHEET

3 02.09.2014

Page 3 of 3

GORI 644-00

APPLICATION DETAILS – FLOW COAT / DIPPING

Pre-treatment:	The wood must be clean and free from wood dust and contamination. The moisture content of the wood should be approx. 13 % and should not exceed 15 %.		
	All softwood should be treated with a wood preservative.		
Mixing ratio:	White:	1.8 parts by volume 2.4 parts by weight	GORI 644: 1 part by volume GORI 644: 1 part by weight HARDENER 7531 HARDENER 7531
	Colourless:	1.5 parts by volume 1.5 parts by weight	GORI 644: 1 part by volume GORI 644: 1 part by weight HARDENER 7531 HARDENER 7531
Application:	To be applied by flow coating or dipping.		
Application conditions:	Stir the product well before use. After adding HARDENER 7531 the product is stirred with mechanical stirring equipment and the mixture rests for 10 min., then stir again.		
	After adding HARDENER 7531 the product is adjusted with water to a viscosity of 13-14 s in DIN cup 4.		
	Film thickness:		75-100 µm wet
	Theoretical consumption:		10-13 m ² /l
	Optimum temperature for products and surroundings:		18-22 °C
	Minimum product temperature by use:		18 °C
	Optimum relative air humidity:		approx. 50 %
	It might be necessary to adjust with water and antifoam agent during the process.		
Pot life:	When working with flow coat it is important to work according to the following guideline:		
	<ul style="list-style-type: none"> • After filling liquid into the flow coat it is only possible to produce for 5 days. On day 5 the flow coat must be emptied, cleaned and possible liquid surplus must be discarded. • By possible production stop during a production period of 5 days, the liquid can only stay in the flow coat for maximum 3 days. If the 3 days are exceeded the flow coat must be emptied, cleaned and possible liquid surplus must be discarded. 		
System treatment:	Primed parts must always be protected with a topcoat treatment before they are exposed to the influence of the weather.		
Drying times:	Determined at 20 °C and 50 % relative humidity:		
	Dry to handle:		1-2 hours
	Dry to sand* / recoat:		2-3 hours
	*As the layer thickness is of paramount importance for the effectiveness of the product, it is important not to sand the surface too much.		
	The drying time can be reduced using special drying systems to force drying. The drying times are approximate and may vary according to wood quality, temperatures, humidity, ventilation and film thickness.		
Cleaning:	The equipment is cleaned with water.		