

AREA OF USE

- For use as primer, intermediate and top coat on surfaces such as steel, stainless steel, galvanized steel, aluminum, copper, bronze, fiberglass, hard plastic and concrete
- Paint for maintenance and new construction
- For use on all types of metal structures in industrial and marine environments
- Replaces epoxy, acrylic and alkyd paints

DESCRIPTION

- High-quality single-component modified polyester paint with active anti-corrosive pigments
- Excellent corrosion protection
- Outstanding adhesion properties
- Low solvent content
- Semi-gloss surface: 30–50% gloss depending on color (Gardner 60°)
- Meets the requirements of DIN-ISO 12944-6 and DIN-55928, cf. Technical Information
- Approved in accordance with NORSOK M-501, System 1. TÜV approved
- Approved for use on children's toys
- Power Coat 3 in 1 in RAL 9006 and RAL 9007 may exhibit a significantly more matte appearance compared to other colors with the same gloss level. For optimal results, it is recommended to apply a suitable clear topcoat, such as Kristallglasur Clear Coat or the Anti-Graffiti Two-Component Clear Coat.



ADVANTAGES

- Single component
- Short drying times
- Can be applied at temperatures down to -10°C
- Excellent mechanical wear resistance
- Does not contain lead, chromates or zinc
- Excellent adhesion to most substrates
- Impact resistant
- High flexibility
- Resistant to chemicals
- Approved for direct contact with food
- Approved for use on playground equipment
- Primer, intermediate coat and top coat in one
- Good edge coverage

TECHNICAL DATA

Dry matter content, volume	53 %
Specific gravity	1.1–1.4 kg/liter
Recommended TFT	60 µm (> 60 µm is recommended to increase gloss durability)
Theoretical consumption @ TFT	8.8 m ² /liter
Dry heat resistance (all colors)	200°C
Dry heat resistance RAL 3009	< 300°C
Dry heat resistance RAL 9006	< 250°C
VOC value	< 400 g/ltr
Colors	Normally approx. 80 colors in stock Other RAL or NCS colors available to order
Drying time at 20 °C and 65% R.H.	Touch dry : 20 – 30 min Recoating : After 90 Recommended recoating time : approx. 120 min Use dry : min±100 min Fully cured : min 3 days Fully dried : ± 8 – 10 hours
Recoatable	Unlimited
No sanding required before repainting Approved in accordance with Norsok M-501, System 1	

SURFACE TREATMENT

Before pretreatment, grease, oil, salts, and other contaminants shall be removed from the surface using a suitable cleaning agent.

Steel	Remove loose rust, rust flakes, scale and loose paint with a scraper or steel brush to a minimum of ST 2 (ISO 8501-1: 1988). For larger surfaces, blast cleaning or ultra-high pressure cleaning is recommended. Clean thoroughly before painting.
Galvanized steel	Light sanding with, for example, Scotch-Brite or similar. Never use steel wool. For larger surfaces, blast cleaning with lime is recommended. Clean thoroughly before painting.
Aluminum	Light sanding with, for example, Scotch-Brite or similar. Never use steel wool. For larger surfaces, blast cleaning with lime is recommended. Clean thoroughly before painting.
Plastic	Thorough cleaning. Always test "3 in 1" on the surface to be treated. "3 in 1" is very suitable for use on most plastic materials such as PVC and GRP (glass fiber reinforced polyester).

Note: Not suitable for soft surfaces such as polyethylene, plexiglass (acrylic) and polystyrene. Risk of dissolution or melting.

All surfaces must be clean. High-pressure wash and degrease with a suitable solvent if necessary.

CURING AND GLOSS ADDITIVES

To accelerate the drying process or to enhance scratch resistance, the Curing Accelerator for 3 in 1 may be added. Ambient air temperature must exceed +15°C during application for the accelerator to be effective. Please refer to the dedicated product data sheet for further information.

If a higher gloss level is desired, Power Coat Gloss Additive for 3 in 1 may be added. One 750 ml can per 5 liters of base product increases gloss by approximately 20%. The gloss additive results in only a negligible reduction in coverage and an insignificant extension of drying time.

APPLICATION

Method	Brush or roller	Air paint sprayer	Airless paint sprayer	HVLP	Airbrush
Max. TFT (1 coat)	Brush 40–80 µm Roller 40–60 µm	50 – 125 µm	50 – 125 µm	50 – 125 µm	50 – 125 µm
Special thinner	Power Coat Special Thinner is used to regulate viscosity and delay the drying process, which will give a better finish when applying with a brush or roller. Max. 5%.				
Combination thinner	No thinner	5 – 10%	Maks. 3 – 5%	3 – 5%	15 %
Nozzle size	–	1,4 – 3,5 mm	0,017" – 0,027"	1,6 – 3,5	–
Fluid pressure	–	4 – 5 bar	Min. 150 bar	5/1 bar (material-/air pressure)	0,8 – 2 bar

Power Coat Spesialtynner: Slow-evaporating thinner for application with brush or roller.

Power Coat Kombitynner: Thinner for spraying and cleaning.

Cleaning: Use Power Coat Kombitynner. Ideal application temperature: +15°C – +25°C. Possible application temperature is -10°C – +30°C. Relative humidity must be below 85%.

SYSTEM

Power Coat 3 in 1 meets the requirements of DIN-ISO 12944-6 for all six corrosion categories in atmospheric environments on steel (Sa 2 ½) and manually cleaned steel (St 2). According to DIN-ISO 12944-6, the expected service life for corrosion categories C-5-I (extreme industrial environment) and C-5-M (extreme maritime environment) is more than 15 years with a 3-coat system. In corrosion categories C-1 (negligible), C-2 (light), C-3 (moderate) and C-4 (severe), the longest expected service life is achieved with a 1-coat or 2-coat system.

According to DIN 12944-5, Power Coat 3 in 1 is approved as basic protection on steel surfaces (cleaned to Sa 2 ½ or St 2), (Section 5.1.2.1), and also for maintenance of previously painted surfaces according to Section 5.1.2.2. According to the requirements of DIN 129044-1 Section 5 (see also 12944-5 Section 5.3), Power Coat does not contain any substances that are harmful to the environment. According to the requirements of DIN 129044-1 Section 5 (see also 12944-5 Section 5.3), Power Coat 3 in 1 does not contain any toxic or carcinogenic substances and has a low solvent content (VOC).

The expected service life in the corrosion categories in DIN EN ISO 12944-6 is achieved with Power Coat 3 in 1 as follows:

Corrosion category	C1	C2	C3	C4	C5I	C5M
Service life						
Short (+/- 5 years)	80 µm	80 µm	80 µm	80 µm	* 160 µm	* 160 µm
Medium (+/- 10 years)	80 µm	80 µm	80 µm	160 µm	* 160 µm	* 160 µm
Long (+/- 15 years)	80 µm	160 µm	160 µm	240 µm	240 µm	240 µm

Note: All thicknesses are given in TFT (dry film thickness)!

Number of coats	80 µm	160 µm	240 µm
Brush/roller	1-2	2-3	3-5
Spray gun	1	2	3

*Derived from test results.

Test results are in accordance with DIN EN ISO 12944-6.

When applying Power Coat 3 in 1 with a brush/roller, the DFT will vary greatly depending on the type of brush/roller, the desired finish, and how the paint is applied. It is strongly recommended to check the film thickness with a wet film gauge during application and a dry film gauge after the paint has fully cured.

Practical examples of "expected service life" according to DIN-EN-ISO 12944-6:

1 coat:

- >15 years: Indoors in heated buildings, C1.
- Up to 15 years: In environments with low pollution and a dry climate. Unheated buildings where condensation may occur, C2.

2 coats:

- >15 years: In environments with low pollution and a dry climate. Unheated buildings where condensation may occur, C2.
- Up to 15 years: Densely populated areas, industrial and maritime environments with moderate levels of sulfur dioxide pollution and moderate salinity. Production halls with high levels of humidity and air pollution, C3 and C4.

3 coats:

- >15 years: All of the above cases. In addition, industrial and maritime environments with high humidity and aggressive influences. Maritime and offshore environments with high salinity, C5 I/M.

STORAGE

Storage stability: 24 months in unopened original packaging. Store in a dry and cool place in a well-ventilated room, away from direct sunlight.

SAFETY DATA

Occupational health data, protective measures, labeling, fire and explosion data can be found in the product's Safety Data Sheet, which can be found at www.jsc.no, www.ecoonline.no, www.nobb.no og www.cobuilder.no.

PR-nr.: 3 in 1: 85024 - Glanstilsetning for 3 in 1: 93025

All information provided in this product data sheet is given to the best of our knowledge. Product details may be subject to change. J.S.Cock AS is not liable for product malfunctions caused by customers. The product data sheet may be subject to change without notice.