

FONTECOAT EP PRIMER

DESCRIPTION

A two component waterborne epoxy primer.

PRODUCT FEATURES AND RECOMMENDED USES

- ◆ Used as a primer for steel surfaces in epoxy and polyurethane paint systems.
- ◆ Recommended as a primer for haulage equipment, cranes, steel masts, conveyors and other steelwork, machinery and equipment.
- ◆ Can be used on ships for surfaces above water line.
- ◆ Can also be applied onto concrete substrate e.g. walls, plasterboard etc.

TECHNICAL DATA

Volume solids 47 ± 2 %. (ISO 3233)

Weight solids 60 ± 2 %.

Specific gravity 1.3 kg / l (mixed)

Mixing ratio and product codes

Base	1 part by volume	007 1001-5
Hardener	1 part by volume	007 1019

Pot life 1½ h (23 °C)

Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
50 µm	105 µm	9.4 m ² /l
70 µm	150 µm	6.7 m ² /l

Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated.

Drying time

DFT 60 µm	+ 15 °C	+ 23 °C	+ 35 °C
Dust dry, after	4 h	2 h	1 h
Touch dry, after	8 h	4 h	2 h
Recoat by itself, after	12 h	6 h	3 h
Recoat by solvent borne paints, after	48 h	24 h	12 h

Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation.

Finish Semigloss.

Colours Red TVT 4000, grey TVT 4004 etc.

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APPLICATION DETAILS

Surface preparation	<p>Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4)</p> <p><u>Steel surfaces:</u> Blast clean to grade Sa2½. (ISO 8501-1) If blast cleaning is not possible, phosphating is recommended for cold rolled steel to improve adhesion.</p> <p><u>Primed surfaces:</u> Oil, grease, salt and dirt are removed from the surface by appropriate means. Repair any damage to the primer coat. Note the overcoating time of primer. (ISO 12944-4)</p>
Primer	FONTECOAT EP PRIMER and TEMACOAT GPL-S PRIMER.
Finish	FONTECOAT EP 50, FONTECOAT EP 80, FONTEDUR HB 80, TEMACOAT GPL, TEMACOAT GS 50, TEMADUR and TEMATHANE.
Application conditions	All surfaces must be dry. The temperature of the ambient air, surface or paint should not fall below +15 °C during application and drying. Relative humidity should not exceed 70 %. The surface temperature of the steel should remain at least 3 °C above the dew point.
Mixing components	First stir base and hardener separately. The correct proportions of base and hardener must be mixed thoroughly before use. Use Temaspeed Squirrel Mixer for mixing.
Application	By airless spray or brush. If necessary, the paint can be thinned maximum 5 %. Airless spray nozzle tip 0.011" - 0.015" and nozzle pressure 140 - 180 bar. Spray angle shall be chosen according to the shape of the object.
Thinner	Water.
Cleaning of equipment	Water or a mixture of water and Thinner 1029, 1:1. The equipment must be cleaned immediately after use before the paint dries.
VOC	The Volatile Organic Compounds amount is 60 g/litre of paint. VOC content of paint mixture (thinned by 10 % by volume) 57 g/l.
HEALTH AND SAFETY	Containers are provided with safety labels, which should be observed. Further information about hazardous influences and protection are detailed in individual health and safety data sheets. A health and safety data sheet is available on request from Tikkurila Oy.

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