

FONTECRYL 10

DESCRIPTION

A waterborne, one component fast drying acrylic based paint which contains active anticorrosive pigments.

PRODUCT FEATURES AND RECOMMENDED USES

- ◆ Used as a primer for interior and exterior steel surfaces.
- ◆ Overcoatable with a wide range of products, also with solvent borne products.
- ◆ Not suitable for immersion or constant humidity.
- ◆ Drying times can be shortened by using higher temperatures.
- ◆ The product has MED (Marine Equipment Directive) certificate no VTT-C-0840-15-06 and is thus accepted for painting surfaces inside the ships.
- ◆ The product has also a U.S. Coast Guard Module B number (164.112 / EC0809) type approval.

TECHNICAL DATA

Volume solids 43 ± 2 %. (ISO 3233)

Weight solids 53 ± 2 %.

Specific gravity 1.2 ± 0.1 kg / l

Product code 213-series.

Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
40 µm	95 µm	10.7 m ² /l
60 µm	140 µm	7.2 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 50 µm	+ 15 °C	+ 23 °C	+ 60 °C
Dust dry, after	30 min	20 min	10 min
Touch dry, after	6 h	1 - 2 h	20 min
Recoatable after min.	24 h	2 - 3 h	1 h
Recoatable with polyurethane paints after min.		6 h	2 h

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

Finish Matt.

Colours TEMASPEED FONTE tinting.

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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>Zinc surfaces:</u> Sweep blast-clean with mineral abrasives, e.g. quartz sand, to an even roughness. (SaS, SFS 5873) If sweep blasting is not possible, the surface should be roughened by hand abrading or washed with FONTECLEAN ZN detergent.</p> <p>Hot dip galvanized surfaces are recommended to be painted with a misty coat (paint thinned 25 - 30 %) before the actual priming.</p> <p><u>Aluminium surfaces:</u> Sweep blast-clean with none-metallic abrasives to an even roughness. (SaS, SFS 5873) If sweep blasting is not possible, the surface should be roughened by hand abrading or washed with FONTECLEAN AL detergent.</p>
Primer	FONTECRYL 10 and TEMAZINC EE.
Finish	<p><u>After 2 - 3 h:</u> FONTECRYL 25, FONTECRYL 50, FONTELAC 90, FONTELAC QD 80, FONTECOAT EP 50, FONTECOAT EP 80, TEMALAC FD 50, TEMALAC FD 80 and TEMALAC ML 90.</p> <p><u>After 6 h:</u> TEMADUR, FONTEDUR 90, FONTEDUR HB 80, DUASOLID, TEMATHANE and TEMACRYL.</p>
Application conditions	All surfaces must be dry. The temperature of the ambient air, surface or paint should not fall below +15 °C during application or drying. Relative humidity should be between 20 - 70 %. The surface temperature of the steel should remain at least 3 °C above the dew point.
Application	By spray or brush. Depending on the application method the paint can be thinned 0 - 10 %. Airless spray nozzle tip 0,011" - 0,015" and nozzle pressure 100 - 160 bar. Spray angle shall be chosen according to the shape of the object.
Thinner	Water.
Cleaning of equipment	Water or FONTECLEAN 1921. The equipment must be cleaned immediately after use before the paint dries.
VOC	The Volatile Organic Compounds amount is 95 g/litre of paint. VOC content of paint (thinned 10 % by volume) is 85 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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