

FONTECRYL 50

DESCRIPTION

A waterborne, one component semigloss acrylic based topcoat.

PRODUCT FEATURES AND RECOMMENDED USES

- ◆ Suitable for use in product painting in metal industry and painting stations.
- ◆ Recommended for topcoating steel frameworks, various machinery and equipment indoors and outdoors.
- ◆ Good gloss and colour retention in climatic stress.
- ◆ Not suitable for immersion or constant humidity.

TECHNICAL DATA

Volume solids 43 ± 2 %. (ISO 3233)

Weight solids 50 ± 2 %.

Specific gravity 1.2 ± 0.1 kg / l

Product code 212-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	20 min	15 min	5 min
Touch dry, after	6 h	1 h	15 min
Recoatible, after	24 h	3 h	2 h

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

Finish Semigloss.

Colours TEMASPEED FONTE tinting.

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APPLICATION DETAILS

Surface preparation	<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)
Primer	FONTECRYL 10, FONTECRYL AP, FONTECRYL 25, TEMAPRIME AB, TEMAPRIME EE, TEMAPRIME EUR, TEMAPRIME GF and TEMAPRIME ML.
Finish	FONTECRYL 50.
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, brush or dipping. Depending on the application method the paint can be thinned 0 - 10 %. Airless spray nozzle tip 0,011" - 0,015" and nozzle pressure 120 - 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 75 g/litre of paint. VOC content of paint (thinned 10 % by volume) is 65 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. For professional use only.

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