

FONTEDUR 90

DESCRIPTION

A waterborne, two component polyurethane finish.

PRODUCT FEATURES AND RECOMMENDED USES

- ◆ Suitable to be used as a glossy topcoat for steel surfaces in epoxy and polyurethane systems.
- ◆ Resistant against moderate mechanical and chemical stress.
- ◆ Good gloss and colour retention in climatic stress.

TECHNICAL DATA

Volume solids 50 ± 2 %. (ISO 3233)

Weight solids 62 ± 2 %.

Specific gravity 1.3 ± 0.1 kg / l (mixed)

Mixing ratio and product codes
Base 5 part by volume 145-series
Hardener 1 part by volume 007 1600

Pot life 1½ hours (23 °C)

Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
40 µm	80 µm	12.5 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 40 µm	+ 15 °C	+ 23 °C	+ 50 °C
Dust dry, after	3 h	1½ h	20 min
Touch dry, after	12 h	6 h	2 h
Recoatible, after	16 h	8 h	3 h
Fully cured, after	14 d	7 d	3 d

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

Finish Glossy.

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	FONTECOAT EP PRIMER, FONTECOAT EP 50, FONTECRYL 10, FONTECRYL AP and TEMACOAT GPL-S PRIMER.
Finish	FONTEDUR 90 and TEMADUR CLEAR.
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 not exceed 80 %. 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 very thoroughly before use. Use Temaspeed Squarrel Mixer for mixing.
Application	By conventional or airless spray or by brush. The paint should be thinned 10 - 20 % after mixing. Components may not be thinned before mixing. Airless spray nozzle tip 0.011" - 0.013" and nozzle pressure 120 - 180 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 85 g/litre of paint. VOC content of paint (thinned 20 % by volume) is 70 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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