

## TEMACOAT GF PRIMER

### DESCRIPTION

A two component, polyamide cured epoxy primer containing zinc phosphate.

### PRODUCT FEATURES AND RECOMMENDED USES

- ◆ Used as a primer for steel, aluminium and zinc surfaces in epoxy and polyurethane systems, when high requirements for the appearance are set.
- ◆ Recommended for agricultural machinery, haulage equipment and other machinery and equipment.

### TECHNICAL DATA

**Volume solids** 55 ± 2 %. (ISO 3233)

**Weight solids** 70 ± 2 %.

**Specific gravity** 1.4 kg / l (mixed)

**Mixing ratio and product codes**  
Base 4 parts by volume 178-series.  
Hardener 1 part by volume 008 5600 or 008 5605 (fast)

**Pot life**  
6 hours (23 °C) with Hardener 008 5600  
3 hours (23 °C) with Hardener 008 5605

### Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
50 µm	90 µm	11.0 m <sup>2</sup> /l
70 µm	130 µm	7.8 m <sup>2</sup> /l

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

### Drying times

DFT 60 µm		0 °C	+ 5 °C	+ 10 °C	+ 23 °C	+ 35 °C
Dust dry, after	with Hardener 008 5600	4 h	2 h	1 h	½ h	15 min
	with Hardener 008 5605	3 h	1½ h	¾ h	½ h	12 min
Touch dry, after	with Hardener 008 5600	22 h	11 h	5 h	2½ h	2 h
	with Hardener 008 5605	12 h	6 h	3½ h	2 h	1½ h
Recoatable with epoxy paints, min. after	with Hardener 008 5600	30 h	20 h	6 h	2 h	1 h
	with Hardener 008 5605	18 h	12 h	4 h	1½ h	¾ h
Recoatable with polyurethane paints, min. after	with Hardener 008 5600	2 d	32 h	18 h	6 h	3 h
	with Hardener 008 5605	1 ½ d	18 h	12 h	4 h	2 h

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

**Finish** Semimatt.

**Colours** Temaspeed Primers colour card. TEMASPEED tinting.

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## APPLICATION DETAILS

<b>Surface preparation</b>	<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 non-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> <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>
<b>Primer</b>	TEMACOAT GF PRIMER, TEMAZINC 77, TEMAZINC 88 and TEMAZINC 99.
<b>Finish</b>	TEMACOAT GPL, TEMACOAT GS 50, TEMACOAT RM 40, TEMACOAT GPL-S MIO, TEMADUR, TEMATHANE and TEMACRYL EA.
<b>Application conditions</b>	All surfaces must be dry. The temperature of the ambient air, surface or paint should not fall below + 5 °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.
<b>Mixing components</b>	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.
<b>Application</b>	<p>By airless or conventional spray or by brush. At airless spray application the paint should be thinned 5 - 25 %. Airless spray nozzle tip 0.011" - 0.017" and nozzle pressure 120 - 180 bar. Spray angle shall be chosen according to the shape of the object.</p> <p>At conventional spray the paint should be thinned 20 - 30 % to a viscosity of 20 - 30 s DIN4.</p> <p>At brush application the paint should be thinned according to the circumstances.</p>
<b>Thinner</b>	Thinner 1031.
<b>Cleaning of equipment</b>	Thinner 1031.
<b>VOC</b>	The Volatile Organic Compounds amount is 420 g/litre of paint mixture. VOC content of paint mixture (thinned 30 % by) volume is 524 g/l.
<b>HEALTH AND SAFETY</b>	<p>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.</p> <p>A health and safety data sheet is available on request from Tikkurila Oy.</p>