

## TEMALAC FD 80

### DESCRIPTION

A fast drying, one component glossy alkyd topcoat.

### PRODUCT FEATURES AND RECOMMENDED USES

- ◆ A glossy, alkyd based topcoat for steel surfaces.
- ◆ Excellent gloss and colour retention when exposed to weathering.
- ◆ Ideal for use in machine shops with fast production cycles and in the field.
- ◆ Suitable also for electrostatic painting.
- ◆ Recommended for steel structures, service platforms and different types of machinery and equipment.

### TECHNICAL DATA

<b>Volume solids</b>	45 ± 2 %. (ISO 3233)
<b>Weight solids</b>	62 ± 2 %.
<b>Specific gravity</b>	1.0 - 1.2 kg / l depending on colour.
<b>Product code</b>	180-series

### Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
40 µm	90 µm	11.1 m <sup>2</sup> /l
60 µm	135 µm	7.4 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 40 µm	+ 10 °C	+ 23 °C	+ 35 °C
Dust dry, after	40 min	15 min	10 min
Touch dry, after	3 h	1½ h	1 h
Recoatible, after	12 d	6 d	4 d
Recoatible, "wet-on-wet", after	1 - 4 h	½ - 2 h	30 min

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

### Finish

Glossy.

### Colours

RAL, NCS, SSG, BS, MONICOLOR NOVA and SYMPHONY colour cards. TEMASPEED tinting.

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## APPLICATION DETAILS

<b>Surface preparation</b>	<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)
<b>Primer</b>	TEMAPRIME EE, TEMAPRIME EUR, TEMAPRIME GF, TEMAPRIME ML and FONTECRYL 10.
<b>Finish</b>	TEMALAC FD 80.
<b>Application conditions</b>	All surfaces must be dry. The temperature of the ambient air, surface and paint should not fall below + 5 °C during application and drying. Relative humidity should not exceed 80 %. The temperature of the substrate should remain at least 3 °C above the dew point.
<b>Application</b>	Airless or conventional spray. Mix the paint thoroughly before use. With airless spray the paint should be thinned 15 - 20 % to a viscosity of 30 - 40 s DIN 4. Airless spray nozzle tip 0.011" - 0.015" and nozzle pressure 120 - 180 bar. Spray angle shall be chosen according to the shape of the object. At conventional spray the paint should be thinned 20 - 30 % to a viscosity of 20 - 25 s DIN 4. "Wet-on-wet" spraying technique is recommended.
<b>Thinner</b>	Thinner 1006. Large surfaces Thinner 1053 (slow).
<b>Cleaning of equipment</b>	Thinner 1006.
<b>VOC</b>	The Volatile Organic Compounds amount is 470 g/litre of paint. Maximum VOC content in ready to use paint (thinned 30 % by volume) is 560 g/l.
<b>HEALTH AND SAFETY</b>	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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