

FONTECOAT EP 50

DESCRIPTION

A two component waterborne epoxy topcoat and a single coat paint.

PRODUCT FEATURES AND RECOMMENDED USES

- ◆ Used as a topcoat or as a single coat paint in epoxy paint systems for steel surfaces.
- ◆ Resistant against modest mechanical and chemical stress.

TECHNICAL DATA

Volume solids 47 ± 2 %. (ISO 3233)

Weight solids 62 ± 2 %.

Specific gravity 1.4 kg / l (mixed)

Mixing ratio and product codes
Base 1 part by volume 168-series
Hardener 1 part by volume 007 1019

Pot life 1½ h (23 °C)

Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
50 µm	105 µm	9.4 m ² /l
80 µm	170 µm	5.9 m ² /l

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

Drying times

DFT 100 µm	+ 15 °C	+ 23 °C	+ 35 °C
Dust dry, after	4 h	2 h	1 h
Touch dry, after	8 h	5 h	2 h
Recoatable by itself, min. after	16 h	6 h	4 h
Recoatable without roughing, max. after	7 d	5 d	2 d
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 Semigloss.

Colours TEMASPEED FONTE tinting.

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APPLICATION DETAILS

Surface preparation	Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4) <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. <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 and TEMACOAT GPL-S PRIMER.
Finish	FONTECOAT EP 50 and FONTEDUR HB 80.
Application conditions	All surfaces must be dry. The temperature of the ambient air, surface or paint should not fall below +15 °C during application and drying. Relative humidity should not exceed 70 %. 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 thoroughly before use. Use Temaspeed Squirrel Mixer for mixing.
Application	By airless spray or brush. If necessary, the paint can be thinned 0 - 10 %. Airless spray nozzle tip 0.011" - 0.015" and nozzle pressure 140 - 180 bar. Spray angle shall be chosen according to the shape of the object.
Thinner	Water.
Cleaning of equipment	Water or a mixture of water and Thinner 1029, 1:1. The equipment must be cleaned immediately after use before the paint dries.
VOC	The Volatile Organic Compounds amount is 60 g/litre of paint mixture. VOC content of paint mixture (thinned by 10 % by volume) 55 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 Coatings Oy.

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