

## Fontedur HB 80

### DESCRIPTION

A two component, waterborne polyurethane topcoat.

### PRODUCT FEATURES AND RECOMMENDED USES

- ◆ A durable, easy to clean and non-chalking topcoat with excellent gloss and colour retention in climatic stress.
- ◆ Suitable to be used as a topcoat for epoxy/polyurethane systems in steel surfaces exposed to weathering, abrasion and chemical stress.
- ◆ Can be cured at higher temperatures.
- ◆ Recommended to be used for agricultural and earth moving machinery, steel framework and other steel structures, machinery and equipment.

### TECHNICAL DATA

**Volume solids** 45 ± 2 %.

**Weight solids** 60 ± 2 %.

**Specific gravity** Approx. 1.3 kg / l mixture

**Mixing ratio and product codes**

Base	2.5 parts by volume	156-series
Hardener	1 part by volume	008 7605

**Pot life** 1 hour (23 °C)

### Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
40 µm	90 µm	11.2 m <sup>2</sup> /l
60 µm	135 µm	7.5 m <sup>2</sup> /l
80 µm	180 µm	5.6 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	+ 15 °C	+ 23 °C	+ 60 °C
Dust dry, after	6 h	1 h	45 min
Touch dry, after	8 h	2 h	1 h
Recoatable , min. after	24 h	2 h	1 h

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 FONTE 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>	Fontecoat EP Primer, Fontecoat EP 50, Fontecryl 10, Fontecryl AP, Fontecryl APS.
<b>Finish</b>	Fontedur HB 80.
<b>Application conditions</b>	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.
<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. Insufficient mixing or incorrect mixing ratio will result in uneven drying of the surface and weaken the properties of the coating.
<b>Application</b>	By air-assisted airless or conventional spray. Depending on the application method the paint can be thinned 0 - 10%. At air-assisted airless spray application the paint should be thinned 0 - 5% with water, nozzle pressure 160 - 200 bar, atomizing pressure 1 - 2 bar, nozzle tip 0.011" - 0.013". Spray angle shall be chosen according to the shape of the object. At conventional spray the paint should be thinned 3 - 10%, atomizing pressure 3 - 4 bar, nozzle 1.4 - 1.8 mm.
<b>Thinner</b>	Water.
<b>Cleaning of equipment</b>	Water or Thinner 1127.
<b>VOC</b>	The Volatile Organic Compounds amount is 155 g/litre of paint. VOC content in paint (mixed 10 % of water) is 145 g/litre of paint. Only for industrial and professional use.
<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 Oyj.

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