

TF27

FONTECOAT EP 50

The waterborne epoxy systems TF27 are suitable for steel constructions exposed to mechanical and chemical stress, not for immersion. FONTECOAT EP 50 is an anti-corrosive pigmented epoxy paint, can also be used as a single coat paint. Because the paint is waterborne the use does not cause danger of fire or harm of solvents in the application spaces.

Corrosivity categories/durability according to ISO 12944	Tikkurila Oy code	Treatment
Steel surfaces		
Corrosivity categories/durability C1, C2 Steel surfaces in cold indoor spaces in clean rural environment. E.g. framework and service platforms in factories. A single coat system. According to SFS 5873, system F20.04	TF27 FONTECOAT EP 50	EP100/1-FeSa2½ DFT <u>100 µm</u> 100 µm
A1.16, A2.07, A3.08 Corrosivity categories/durability C2-H, C3-M Steel surfaces in urban and industrial environment exposed to abrasion. E.g. framework and service platforms in factories.	TF27 FONTECOAT EP 50	EP160/2-FeSa2½ DFT <u>2 x 80 µm</u> 160 µm
A4.08 Corrosivity categories/durability C3-H, C4-M Steel constructions, machines and equipment in pulp and paper industry exposed to severe splashes, chemical dust and abrasion.	TF27 FONTECOAT EP 50	EP240/3-FeSa2½ DFT <u>3 x 80 µm</u> 240 µm

Marking of paint systems: TF27-SFS EN ISO 12944-5/ A3.08 (EP160/2-FeSa2½)

COLOURS

The product is tintable with TEMASPEED FONTE colorants, thus ensuring the possibility to get shades from RAL-, BS-, NCS- and other colour cards.

SUITABLE SHOP PRIMERS

TEMABLAST EV 110, epoxy.
 TEMAWELD ZSM, zinc silicate

SURFACE PREPARATION	<p>Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4)</p> <p>Steel surfaces: 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>
APPLICATION CONDITIONS	<p>The surface must be clean and dry and the surface temperature should remain at least 3 °C above the dew point. During application and drying the temperature of the air, paint and surface should be at least of +15 °C. The relative humidity should not exceed 70 %.</p>
APPLICATION	<p>The paint should be mixed thoroughly before application and then applied in an even coat on the dry and clean surface. Application with airless or conventional spray, brush or roller. Stripe coating of sharp edges, welding seams etc. should be done by brush or roller.</p>
MAINTENANCE PAINTING	<p>Maintenance Touch-up painting is sufficient for maintenance when the rust grade is Ri1 - Ri3. (ISO 4628-3) Damages caused by transport or installation may also be repaired by touch-up painting. Remove all loose paint, clean rusty areas according to system demands. On steel surfaces small areas can be grinded or wire brushed to preparation grade St2. (SFS-ISO 8501-1) Level off the edges between the old paint film and the cleaned up areas. When using blast cleaning, be sure that there are no cracks in the remaining paint film. If the entire surface has to be overcoated, abrade the old topcoat to a rough finish. Remove all dust and other cleaning residues. Apply primers and finish according to the original paint system, qualities and film thicknesses.</p> <p>Repainting When the rust grade is Ri4 or Ri5, the entire coating must be renewed. Remove the old paint film and clean the surfaces to preparation grade Sa2½. Recoat in accordance with the original paint system.</p>
PRODUCT INFORMATION	<p>More detailed product information is available in respective data sheets.</p>

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