



# Fontedur HB 80

## DESCRIPTION

A two-component, water-borne 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

Base 2.5 parts by volume Fontedur HB 80  
Hardener 1 part by volume 008 7605

### Pot life (+23°C)

1 hour

### Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
wet	dry	
90µm	40µm	11.2 m <sup>2</sup> /l
135µm	60µm	7.5 m <sup>2</sup> /l
180µm	80µm	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 time

DFT 40µm	+15°C	+23°C	+60°C
Dust dry, after	6h	1h	45min
Touch dry, after	8h	2h	1h
Recoatable, min. after	24h	2h	1h

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

### Gloss

Gloss.

### Color shades

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

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## APPLICATION INSTRUCTIONS

<b>Surface preparation</b>	Primed surfaces: 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>Recommended primers</b>	Fontecoat EP 50, Fontecryl 10, Fontecryl AP.
<b>Recommended topcoats</b>	Fontedur HB 80.
<b>Application conditions</b>	All surfaces must be clean, dry and free from contamination. The temperature of the ambient air, surface and paint should not fall below +15°C during application and drying. Relative humidity of the air should not exceed 80% during application and drying. The surface temperature of steel should remain at least 3°C above the dew point. Good ventilation and sufficient air movement is required in confined areas during application and drying.
<b>Mixing components</b>	First stir base and hardener separately. The correct proportions of base and hardener must be mixed thoroughly before use. Use power 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>	<p>For air-assisted airless spraying, the product is thinned approximately 0–5%. Recommended nozzle tip is 0.011"–0.013" and pressure 160–200 bar. Atomising air pressure should be 1–2 bar. Spray angle shall be chosen according to the shape of the object.</p> <p>For conventional spraying, the product is thinned approximately 3–10%. Recommended nozzle tip is 1.4–1.8 mm. Atomising air pressure should be 3–4 bar.</p>
<b>Thinners</b>	Water
<b>Cleaning of equipment</b>	<p>Clean the spraying equipment immediately after use as follows:</p> <ol style="list-style-type: none"><li>1. Run the equipment with water to remove excess paint from the equipment.</li><li>2. Run the equipment with a mixture of approx 20% Thinner 1109 in clean water, at least two times.</li><li>3. Finally wash with undiluted Thinner 1109.</li></ol> <p>Wash the equipment with water before starting to paint again. Unwashed equipment can cause serious surface defects.</p> <p>Contact Tikkurila Technical Service for detailed instructions for cleaning 2-component application equipment.</p>
<b>VOC</b>	<p>The Volatile Organic Compounds amount is 155 g/litre of paint.</p> <p>VOC content in paint (mixed 10% of water) is 145 g/litre of paint.</p>
<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 Oyj.</p> <p><b>For industrial use only.</b></p>



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The above information is not intended to be exhaustive or complete. The information is based on laboratory tests and practical experience, and it is given to the best of our knowledge. The quality of the product is ensured by our operational system, based on the requirements of ISO 9001 and ISO 14001. As manufacturer we cannot control the conditions under which the product is being used or the many factors that have an effect on the use and application of the product. We disclaim liability for any damages caused by using the product against our instructions or for inappropriate purposes. We reserve the right to change the given information unilaterally without notice.

The product is intended for professional use only and shall only be used by professionals who have sufficient knowledge and expertise on the proper use of the product. The information above is advisory only. To the extent permitted by applicable law, we shall not approve of any liability for the conditions under which the product is being used or for the use or application of the product.

In case you intend to use the product for any other purpose than that recommended in this document without first getting our written confirmation on the suitability for the intended use, such use takes place at your own risk.