Temadur SC-F 20

DESCRIPTION
A two-component fast-drying semi-matt polyurethane paint, containing anti-corrosive pigments, hardener aliphatic isocyanate.

PRODUCT FEATURES AND RECOMMENDED USES
- Active anti-corrosive pigments ensure corrosion resistance even in severe climatic conditions
- Can help speeding up the painting process and decrease the overall costs of the painting system
- A good gloss and color retention, due to polyurethane resin. It forms durable, easy-to-clean, non-chalking finish
- Excellent weathering and abrasion resistance
- Recommended especially to be used as a single coat finish for agricultural and earth moving machinery and other machinery and equipment

TECHNICAL DATA

| Volume solids | 62±2% (ISO 3233) |
| Weight solids | 74±2% |
| Specific gravity | 1.3±0.1 kg / l (mixed) |
| Mixing ratio | Base 4 parts by volume, Temadur SC-F 20 Hardener 1 part by volume 008 7640 |
| Pot life (+23°C) | app. 1 hour |

<table>
<thead>
<tr>
<th>Recommended film thicknesses and theoretical coverage</th>
<th>Recommended film thicknesses/one coat application</th>
<th>Theoretical coverage</th>
</tr>
</thead>
<tbody>
<tr>
<td>wet</td>
<td>dry</td>
<td></td>
</tr>
<tr>
<td>130µm</td>
<td>80µm</td>
<td>7.8 m²/l</td>
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<tr>
<td>200µm</td>
<td>120µm</td>
<td>5.2 m²/l</td>
</tr>
</tbody>
</table>

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

<table>
<thead>
<tr>
<th>Drying time</th>
<th>DFT 60µm</th>
<th>+5°C</th>
<th>+10°C</th>
<th>+23°C</th>
<th>+35°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dust dry, after</td>
<td>2h</td>
<td>1½h</td>
<td>30min</td>
<td>20min</td>
<td></td>
</tr>
<tr>
<td>Touch dry, after</td>
<td>8h</td>
<td>4h</td>
<td>2h</td>
<td>1h</td>
<td></td>
</tr>
<tr>
<td>Recoatable, after</td>
<td></td>
<td></td>
<td>No limitations</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation. When forced drying in temperatures +50−100°C, use flash-off time between 5−30 minutes, depending on the wet film thickness and the actual temperature.

Gloss
Semi-matt.

Color shades
RAL, NCS, SSG, BS, MONICOLOR NOVA and SYMPHONY colour cards. Temaspeed Premium tinting
Temadur SC-F 20

APPLICATION INSTRUCTIONS

Surface preparation

Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4)

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.

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)

Recommended primers

Temadur 20, Temacoat GPL-S Primer, Temacoat GPL-S MIO, Temabond ST 200, Temabond ST 300, Temacoat Primer, Temanyl PVB, Temazinc 77.

Recommended topcoats

Temadur 50, Temadur 90, Temadur Clear, Temadur HB 50, Temadur HB 80, Temadur HS 90, Temadur SC-F 20, Temadur SC-F 50, Temadur SC-F 80, Temathane 50, Temathane PC 50, Temathane PC 80.

Application conditions

All surfaces must be clean, dry and free from contamination. The temperature of the ambient air, surface and paint should not fall below +5°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.

Mixing components

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.

Application

For airless spraying, the product is thinned depending on the temperature of the components and shape of the object approximately 0–15%. Recommended nozzle tip is 0.011”–0.015” and pressure 160–200 bar. Spray angle shall be chosen according to the shape of the object. In order to reach thicker coats (over 100µm DFT) use always “wet-in-wet” technique.

For conventional spraying, the product is thinned approximately 10–15% to the viscosity 20–25s (DIN4). Recommended nozzle tip is 1.6–1.8 mm and pressure 3–4 bar.

Thinners

Thinner 1048, Thinner 1067

Cleaning of equipment

Thinner 1067 or Thinner 1048.

VOC

The Volatile Organic Compounds amount (ISO 11890) is 350 g/litre of paint mixture.

VOC content in paint mixture (thinned 15% by volume) is 440 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 Oyj.

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