**Fontecoat FD 20**

**DESCRIPTION**
A two-component, semi-matt water-borne epoxy direct-to-metal paint.

**PRODUCT FEATURES AND RECOMMENDED USES**
- Very fast curing. May help speeding up the painting process and decrease the overall costs of the painting system. Less downtime is a remarkable benefit
- Self-priming. Fontecoat FD 20 has been especially developed for use as single-coat paint. Due to its highly developed anti-corrosive properties, the product provides long-term protection for steel constructions, machinery and equipment in process and other industries
- Easy to apply. Can be applied in thick layers, thus enabling a faster painting process. Good hiding power simplifies painting of welding seams. Dust-free spraying makes this water-borne product even more user-friendly
- Used as a topcoat or as a single coat paint in epoxy paint systems for steel surfaces
- Excellent adhesion and surface tolerance when used with Temakeep adhesion primer, allowing extremely fast cycle times
- Can also be used as a primer or intermediate coat in epoxy / polyurethane systems
- Very good resistance against mechanical and chemical stress
- Recommended for framework, service platforms, conveyors and other steelwork, machinery and equipment

**TECHNICAL DATA**

<table>
<thead>
<tr>
<th>Volume solids</th>
<th>44±2%. (ISO 3233)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Weight solids</td>
<td>61±2%.</td>
</tr>
<tr>
<td>Specific gravity</td>
<td>1.4 kg / l (mixed)</td>
</tr>
</tbody>
</table>

**Mixing ratio**
Base 1 part by volume  Fontecoat FD 20  
Hardener 1 part by volume  Hardener 007 1021

**Pot life (+23°C)**
1h

**Recommended film thicknesses and theoretical coverage**

<table>
<thead>
<tr>
<th>Recommended film thicknesses</th>
<th>Theoretical coverage</th>
</tr>
</thead>
<tbody>
<tr>
<td>wet</td>
<td>dry</td>
</tr>
<tr>
<td>150µm</td>
<td>60µm</td>
</tr>
<tr>
<td>225µm</td>
<td>100µm</td>
</tr>
<tr>
<td>275µm</td>
<td>120µm</td>
</tr>
</tbody>
</table>

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

**Drying time**

<table>
<thead>
<tr>
<th>DFT 100µm</th>
<th>+15°C</th>
<th>+23°C</th>
<th>+35°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dust dry, after</td>
<td>3h</td>
<td>&lt; 1 h</td>
<td>0.5h</td>
</tr>
<tr>
<td>Touch dry, after</td>
<td>6h</td>
<td>2h</td>
<td>1h</td>
</tr>
<tr>
<td>Recoatable without roughing, max. after</td>
<td>7d</td>
<td>5d</td>
<td>2d</td>
</tr>
<tr>
<td>Fully cured, after</td>
<td>14d</td>
<td>7d</td>
<td>3d</td>
</tr>
</tbody>
</table>

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

**Gloss**
Semi-matt.
Fontecoat FD 20

**Color shades**

RAL, NCS, SSG, BS, MONICOLOR NOVA and SYMPHONY color cards. Temaspeed Fonte tinting.

Note! Temakeep Grey: overcoating on touch dry surface


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 70% 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.

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.

To obtain the best possible result air-assisted airless spraying is recommended.

For air-assisted airless spraying, the product is thinned max 10% if needed. Recommended nozzle tip is 0.011”–0.017” and pressure 140–200 bar. Atomising air pressure should be 1–2 bar. Spray angle shall be chosen according to the shape of the object.

For airless spraying, the product is thinned max 10% if needed. Recommended nozzle tip is 0.011”–0.017” and pressure 140–200 bar. Spray angle shall be chosen according to the shape of the object. 160μm DFT should not be exceeded.

For brush application product should be thinned according to the circumstances.

Separate application instructions are available on request.

Thinners

Water

Cleaning of equipment

Clean the spraying equipment immediately after use as follows:
1. Run the equipment with water to remove excess paint from the equipment.
2. Run the equipment with a mixture of approx 20% Thinner 1109 in clean water, at least two times.
3. Finally wash with undiluted Thinner 1109.

Wash the equipment with water before starting to paint again. Unwashed equipment can cause serious surface defects.

Contact Tikkurila Technical Service for detailed instructions for cleaning 2-component application equipment.
The Volatile Organic Compounds amount is 65g/litre of paint mixture.
VOC content of paint mixture (thinned by 10% by volume) 60g/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.

For industrial and professional use only.

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.