

TE18
**TEMACOAT SPA MIO
TEMACOAT GPL**

The epoxy systems TE18 are recommended for steel, stainless steel, aluminium and zinc surfaces exposed to abrasion, chemicals and other special stress. Resistance to chemicals of TEMACOAT GPL in a separate table.

| Corrosivity categories/durability according to ISO 12944 | Tikkurila Coatings code | Treatment |
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| Steel surfaces | | |
| A4.08 Corrosivity categories/durability C3-H, C4-M Steelwork exposed to severe climatic conditions, where the humidity and salinity are moderate. | TE18 TEMACOAT SPA MIO TEMACOAT GPL DFT | EP240/3-FeSa2½ 2 x 80 µm <u>80 µm</u> 240 µm |
| A1.21, A4.09 Corrosivity categories/durability C4-H Steelwork and equipment exposed to gases and chemically active dust. E.g. tubular bridges and platforms. | TE18 TEMACOAT SPA MIO TEMACOAT SPA MIO TEMACOAT GPL DFT | EP280/3-FeSa2½ 80 µm 120 µm <u>80 µm</u> 280 µm |
| A1.24, A5I.02, A5M.02 Corrosivity categories/durability C4-H, C5-I-H; C5-M-H Steelwork, machinery and equipment in process industry exposed to severe chemically active dust and splashes. | TE18 TEMACOAT SPA MIO TEMACOAT GPL DFT | EP320/4-FeSa2½ 3 x 80 µm <u>80 µm</u> 320 µm |

Marking of paint systems: TE18-SFS EN ISO 12944-5/A4.08 (EP240/3-FeSa2½)
Aluminium surfaces

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| Corrosivity categories C2, C3, C4 Aluminium surfaces indoors exposed to mechanical abrasion and mild or moderate gas and chemically active dust. According to SFS 5873, system F40.05. | TE18 TEMACOAT SPA MIO TEMACOAT GPL DFT | EP120/2-AISaS 60 µm <u>60 µm</u> 120 µm |
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Zinc surfaces

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| A7.11 Corrosivity categories/durability C4-H, C5-I-M, C5-M-M Zinc surfaces indoors exposed to mechanical abrasion and mild or moderate gas and chemically active dust. | TE18 TEMACOAT SPA MIO TEMACOAT GPL DFT | EP160/2-ZnSaS 80 µm <u>80 µm</u> 160 µm |
| A7.12 Corrosivity categories/durability C4-H, C5-I-M, C5-M-M Zinc surfaces indoors exposed to mechanical abrasion and mild or moderate gas and chemically active dust. According to SFS 5873, system F30.07 | TE18 TEMACOAT SPA MIO TEMACOAT GPL DFT | EP240/3-ZnSaS 2 x 80 µm <u>80 µm</u> 240 µm |

COLOURS

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

SUITABLE SHOP PRIMERS

TEMABLAST EV 110, epoxy shop primer.
TEMAWELD ZSM, zinc silicate.

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| 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> <p>Zinc surfaces: Sweep blast-clean with mineral abrasives, e.g. quartz sand, to an even roughness. (SaS, SFS 5873) If sweep blasting is not possible, the surface should be roughened by hand abrading or washed with PANSSARIPESU detergent.</p> <p>Hot dip galvanized surfaces are recommended to be painted with a misty coat (paint thinned 25 - 30 %) before the actual priming. Damages in the zinc coating have to be repaired with TEMAZINC 99, a zinc rich epoxy paint. Before painting, clean the surfaces thoroughly (Sa2½/St3) and level off the edges around the cleaned areas.</p> <p>Stainless steel: Roughen the surface by grinding or sweep blasting using mineral abrasives.</p> <p>Aluminium surfaces: Sweep blast-clean with none-metallic abrasives to an even roughness. (SaS, SFS 5873) If sweep blasting is not possible, the surface should be roughened by hand abrading or washed with MAALIPESU detergent.</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 a minimum of + 10 °C. The relative humidity should not exceed 80 %.</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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