

TX12
TEMAL 600
TX21
TEMAL 600 HB
TX23
TEMAL 400

Corrosivity categories/durability according to ISO 12944	Tikkurila Coatings code	Treatment
Steel surfaces		
Exposed to heat Steel surfaces exposed to heat. The system withstands + 650 °C. TEMAL 600 , aluminium.	TX12 TEMAL 600	SI30/1-FeSa2½ DFT <u>30 µm</u> 30 µm
Exposed to heat Steel surfaces exposed to heat. The system withstands + 650 °C. TEMAL 600 HB, aluminium.	TX21 TEMAL 600 HB	SI30/1-FeSa2½ DFT <u>30 µm</u> 30 µm
Exposed to heat Steel surfaces exposed to heat. The system withstands + 400 °C. TEMAL 400, black.	TX23 TEMAL 400	SI20/1-FeSa2½ DFT <u>20 µm</u> 20 µm

Marking of paint systems: TX21-SI30/1-FeSa2½

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.
APPLICATION CONDITIONS	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 + 5 °C, the relative humidity should not exceed 80 %.
APPLICATION	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.
MAINTENANCE PAINTING	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. 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.
PRODUCT INFORMATION	More detailed product information is available in respective data sheets.

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