

## TO1

### Duasolid 50

The oxirane ester systems TO1 are suitable for steel surfaces exposed to mild climatic conditions. Duasolid 50 forms an easy to clean finish with good gloss and colour retention properties. The systems are suitable for application both in the field and in painting shops.

Corrosivity categories/durability according to ISO 12944	Tikkurila Oy code	Treatment
<b>Steel surfaces</b>		
<b>Corrosivity categories/durability C1, C2</b> Steel structures, machines and equipment exposed to mild stress with high demands on aesthetics and resistance. According to SFS 5873, system F20.07 but with surface preparation grade FeSa2.	<b>TO1</b> Duasolid 50	<b>OX100/1-FeSa2½</b> DFT <span style="float: right;"><u>100 µm</u> 100 µm</span>
The systems can be used for maintenance painting according to SFS 5873/R25.11 with surface preparation grade FeSt2.		
<b>Corrosivity categories/durability C3-L</b> Steel constructions, machinery and equipment in cold indoors spaces and outdoors in clean rural environment.	<b>T01</b> Duasolid 50	<b>OX120/1-FeSa2½</b> DFT <span style="float: right;"><u>1 x 120 µm</u> 120 µm</span>
<b>Marking of paint systems: TO1-OX100/1-FeSa2½</b>		

## 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.

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<b>SURFACE PREPARATION</b>	<p>Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4)</p> <p><u>Steel surfaces:</u> 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><u>Primed surfaces:</u> 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)</p>
<b>APPLICATION CONDITIONS</b>	<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 at least + 10 °C. The relative humidity should not exceed 80 %.</p>
<b>APPLICATION</b>	<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>
<b>MAINTENANCE PAINTING</b>	<p><b>Maintenance</b> 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><b>Repainting</b> 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>
<b>PRODUCT INFORMATION</b>	<p>More detailed product information is available in respective data sheets.</p>

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