

TE28

Temacoat SPA 50

The epoxy systems TE28 are recommended for steel, aluminium, zinc and concrete surfaces exposed to abrasion, chemicals, high humidity and climate in indoor and outdoor applications, also for submerged and underground constructions.

Temacoat SPA 50 is available in many colours, also light ones, which makes it easier to follow up the condition of the coating.

Corrosivity categories/durability according to ISO 12944	Tikkurila Oy code	Treatment
Steel surfaces		
Corrosivity categories C3-M Steel constructions exposed to mild condensation in cold indoor spaces and outdoors in clean rural environment.	TE28 Temacoat SPA 50	EP80/1-FeSa2½ DFT <u>80 µm</u> 80 µm
Corrosivity categories C3-H Steel constructions exposed to mild condensation in cold indoor spaces and outdoors in clean rural environment. According to SFS 5873, system F20.04. (C1, C2) but with surface preparation grade FeSa2.	TE28 Temacoat SPA 50	EP100/1-FeSa2½ DFT <u>100 µm</u> 100 µm
A1.16, A2.07, A3.08 Corrosivity categories/durability C2-H, C3-M Steel constructions exposed to mild condensation in cold indoor spaces and outdoors in clean rural environment.	TE28 Temacoat SPA 50	EP160/2-FeSa2½ DFT <u>2 x 80 µm</u> 160 µm
A4.08 Corrosivity categories/durability C3-H, C4-M Steel structures in damp environment.	TE28 Temacoat SPA 50	EP240/3-FeSa2½ DFT <u>3 x 80 µm</u> 240 µm

Marking of paint systems: TE28-SFS EN ISO 12944-5/ A4.08 (EP240/3-FeSa2½)

Aluminium surfaces

Corrosivity categories C1, C2 Aluminium surfaces indoors exposed to mechanical abrasion. According to SFS 5873, system F40.02	TE28 Temacoat SPA 50	EP100/1-AISaS DFT <u>100 µm</u> 100 µm
Corrosivity categories C2, C3, C4 Aluminium surfaces indoors exposed to mechanical abrasion and mild or modest gas and chemically active dust. According to SFS 5873, system F40.05	TE28 Temacoat SPA 50	EP120/2-AISaS DFT <u>2 x 60 µm</u> 120 µm

Zinc surfaces

A7.09 Corrosivity categories/durability C2-H, C3-M Zinc surfaces, indoors and outdoors, exposed to mild stress.	TE28 Temacoat SPA 50	EP80/1-ZnSaS DFT <u>80 µm</u> 80 µm
A7.11 Corrosivity categories/durability C4-H, C5-I-M, C5-M-M Zinc surfaces indoors exposed to mechanical abrasion and outdoors exposed to moderate climatic conditions.	TE28 Temacoat SPA 50	EP160/2-ZnSaS DFT <u>2 x 80 µm</u> 160 µm
A7.13 Corrosivity categories/durability C4-H, C5-I-H, C5-M-H Zinc surfaces outdoors in urban, maritime and industrial environment with high demands on aesthetics and resistance.	TE28 Temacoat SPA 50 Temacoat SPA 50	EP320/3-ZnSaS DFT 1 x 80 µm <u>2 x 120 µm</u> 320 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

SURFACE PREPARATION	<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>Zinc surfaces:</u> 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 mist coat (paint thinned 25 - 30 %) before the actual priming.</p> <p><u>Aluminium surfaces:</u> Sweep blast-clean with non-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> <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>
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</p> <p>Touch-up painting is sufficient for maintenance when the rust grade is Ri1 - Ri3. (ISO 4628-3)</p> <p>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)</p> <p>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</p> <p>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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