Fontecoat EP 50 Beige

DESCRIPTION

A two-component water-borne epoxy primer.

PRODUCT FEATURES AND RECOMMENDED USES

- An epoxy primer for steel in highly corrosive environments. Due to its good adhesion to the substrate and the subsequent coat, the primer ensures high mechanical and chemical resistance of the paint system.
- Used as an intermediate coat in the NORSOK approved paint system. The approval indicates the paint system's ability to function in off-shore environments.
- Can also be recoated with solvent-borne topcoats. The paint can be used in hybrid systems to replace solvent-borne primer and/or intermediate coating.
- Used as a primer or an intermediate coat in epoxy / polyurethane systems.
- Can also be used as a topcoat or as a single coat paint in epoxy paint systems for steel surfaces.
- Resistant to diesel and biodiesel (RME) fuel.
- Recommended for framework, service platforms, conveyors and other steelwork, machinery and equipment.

TECHNICAL DATA

Volume solids

47±2% (mixture, ISO 3233)

Weight solids

62±2% (mixture)

Specific gravity

1.4 kg / l (mixture)

Mixing ratio

Base	1 part by volume	Fontecoat EP 50 Beige
Hardener	1 part by volume	007 1019

Pot life (+23°C)

1½ h

Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
wet	dry	
130µm	60µm	7.7 m²/l
210µm	100µm	4.8 m²/l
300µm	140µm	3.3 m²/l

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

Note! The painting work should be performed and supervised according to 12944-7 if not otherwise stated in the respective technical data sheet. Excessive film thickness may result e.g. in cracking, sagging, prolonged drying time, soft film, less chemical resistance, gloss deviation, adhesion and intercoat functionality. In case the product is used otherwise than stated in the standard a written approval from Tikkurila is required.

Drying time

DFT 100 µm	+ 15 °C	+ 23 °C	+ 35 °C
Dust dry, after	4 h	2 h	1 h
Touch dry, after	8 h	5 h	2 h
Recoatable by itself, min. after	16 h	6 h	4 h
Fully cured, after	14 d	7 d	3 d

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

Water-borne paints and coatings are sensitive to moisture and cold before they are completely dry. Painted surfaces must be stored indoors at a temperature of min. +20°C for at least 40 hours before exposed to weather conditions. Forced drying may shorten the time before exposing the painted objects to outdoors. Please consult Tikkurila Technical Service for more information.

Gloss	Semi-gloss.
Color shades	Beige

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APPLICATION INSTRUCTIONS

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.

Primed surfaces: 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)

Recommended primers

Fontecryl AP, Fontecryl PP, Fontezinc 85, Fontecoat EP 50, Temazinc 77, Temazinc 88, Temazinc 99, Temakeep, Temacoat GPL-S Primer.

Recommended topcoats

Fontecoat EP 50, Fontedur HB 80, Temasolid SC 60, Temadur 50, Temacryl EA 50.

Application conditions

All surfaces must be clean, dry and free from contamination. The temperature of the ambient air, surface and paint should not fall below +15ºC during application and drying. If the ambient relative humidity is 70% or higher, appropriate measures must be taken to reduce the relative humidity in the drying stage (forced drying or dehumidifier). 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.

Note! There is a natural tendency of this coating to chalk, discolor or yellow unevenly. It is recommended to use polyurethane topcoat when there are high aesthetical requirements on color appearance.

Mixing components

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.

Application

For airless spraying, the product is thinned approximately 0–10%. Recommended nozzle tip is 0.013"–0.023" and pressure 140–200 bar. Spray angle shall be chosen according to the shape of the object.

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

For large flat surfaces, and for nozzle tip above 0,015", 40° or higher spray angle is recommended. Forced drying must be used when nominal dry film thickness (NDFT) is above 140 µm. Forced drying can be used up to 450 µm wet film thickness. 200 µm dry film thickness should not be exceeded.

For aluminium and zinc substrates and when applied on zinc rich primer it is recommendable to apply a mist coat: first a thin layer, then let the water evaporate for 5–10 minutes and then apply the full coat.

Thinners

Water

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Cleaning of equipment

Thinner 1109

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 Thinner 1109, at least two times.

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.

VOC

The Volatile Organic Compounds amount is 55 g/litre of paint mixture.
VOC content of paint mixture (thinned by 10% by volume) 50 g/l.
VOC 2004/42/EC (cat A/j) 140 g/l (2010)

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.

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