

TEMACOAT GS 50

DESCRIPTION

A two component, polyamide-cured high build epoxy finishing and intermediate coat.

PRODUCT FEATURES AND RECOMMENDED USES

- Used as a finishing or intermediate coat in epoxy and polyurethane systems exposed to abrasion and mechanical and/or chemical attack.
- Can also be applied direct to zinc and aluminium surfaces.
- Recommended as a sealer on hot dip galvanized surfaces when thinned 20 30 %.
- Rapidly recoatable and ready to handle.
- ♦ Recommended for haulage equipment, steel frameworks, conveyors, tubular bridges and other steel structures.

TECHNICAL DATA

Volume solids $57 \pm 2 \%$. (ISO 3233)

Weight solids $71 \pm 2 \%$.

Specific gravity 1.3 - 1.4 kg / I (mixed)

Mixing ratio and product codes

Base 4 parts by volume 172-series.

Hardener 1 part by volume 008 5600 or 008 5605 (fast)

Pot life 6 hours (23 °C / 74 °F) with Hardener 008 5600

3 hours (23 °C / 74 °F) with Hardener 008 5605

Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage		
dry	wet			
60 µm	105 μm	9.5 m ² /l		
100 μm	175 μm	5.7 m ² /l		

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

Drying times

DFT 70 μm		+ 5 °C	+ 10 °C	+ 23 °C	+ 35 °C
Dust dry, after	with Hardener 008 5600	3 h	1 h	½ h	15 min
	with Hardener 008 5605	2 h	³⁄₄ h	½ h	12 min
Touch dry, after	with Hardener 008 5600	14 h	10 h	4½ h	2½ h
	with Hardener 008 5605	8 h	6 h	3½ h	2 h
Recoatable, min., with epoxy paints	with Hardener 008 5600	24 h	6 h	2 h	1 h
	with Hardener 008 5605	14 h	4 h	1½ h	¾ h
Recoatable, min., with polyurethane paints	with Hardener 008 5600	36 h	20 h	8 h	4 h
	with Hardener 008 5605	24 h	12 h	6 h	3 h

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

Finish Semigloss.

Colours RAL, NCS, SSG, BS, MONICOLOR NOVA and SYMPHONY colour cards.

TEMASPEED tinting.

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APPLICATION DETAILS

Surface preparation

<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)

<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.

Hot dip galvanized surfaces are recommended to be painted with a mist coat (paint thinned 25 - 30 % or with separate TEMACOAT SEALER before the actual priming).

<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.

Primer TEMACOAT GPL-S PRIMER, TEMACOAT HB PRIMER, TEMACOAT HS PRIMER,

TEMACOAT PM PRIMER, TEMACOAT GPL-S MIO, TEMACOAT SPA, TEMABOND

and FONTECOAT EP PRIMER.

Finish TEMACOAT GPL, TEMACOAT GS 50, TEMADUR and TEMATHANE.

Application conditions All surfaces must be dry. The temperature of the ambient air, surface or paint should

not fall below + 5 °C / 41 °F during application or drying. Relative humidity should not exceed 80 %. The surface temperature of the steel should remain at least 3 °C / 38 °F

above the dew point.

Mixing components First stir base and hardener separately. The correct proportions of base and hardener

must be mixed thoroughly before use. Use a mechanical agitator for mixing.

Application By airless or conventional spray or by brush. At airless spray application the paint

should be thinned 5 - 25 % by volume. Airless spray nozzle tip 0.011" - 0.017"; nozzle pressure 120 - 160 bar, spray angle shall be chosen according to the shape of the

object.

At conventional spray the paint should be thinned 20 - 30 % to a viscosity of

20 - 30 s DIN4.

At brush application the paint should be thinned according to the circumstancies.

Thinner Thinner 1031.

Cleaning of equipment Thinner 1031.

VOC The Volatile Organic Compounds amount to 370 ± 20 g/litre of paint.

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 Coatings Oy.

For professional use only.

RJH250204/tmk030204/172-s, 008 5600, 5605