

TEMACOAT HS PRIMER

DESCRIPTION

A two component, polyamide-cured high build epoxy primer.

PRODUCT FEATURES AND RECOMMENDED USES

- ◆ Good adhesion to steel, zinc and aluminium surfaces.
- ◆ Rapidly recoatable.
- ◆ Rapidly ready to handle.
- ◆ Used as a primer and an intermediate coat in epoxy and polyurethane systems exposed to abrasion and/or chemical attack.
- ◆ Recommended for bridges, haulage equipment, cranes, steel masts, conveyors and other steelwork, machinery and equipment.

TECHNICAL DATA

Volume solids 67 ± 2 %. (ISO 3233)

Weight solids 80 ± 2 %.

Specific gravity 1.6 kg / l (mixed)

Mixing ratio and product codes

Base	3 parts by volume	159 4000, 4001
Hardener	1 part by volume	008 5603

Pot life 3 hours (23 °C / 74 °F)

Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
80 µm	120 µm	8.4 m ² /l
200 µm	300 µm	3.3 m ² /l

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

Drying time

DFT 100 µm	0 °C	+ 5 °C	+ 10 °C	+ 23 °C	+ 35 °C
Dust dry	8 h	6 h	4 h	1 h	½ h
Touch dry	10 h	8 h	5 h	1½ h	1 h
Recoatable, min., with epoxy paints	12 h	10 h	6 h	1 h	1 h
Recoatable, min., with polyurethane paints	14 h	12 h	8 h	1 h	1 h

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

Finish Semigloss.

Colours Standard colours reddish brown and grey.

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APPLICATION DETAILS

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 misty coat (paint thinned 25 - 30 % or with separate TEMACOAT SEALER primer before the actual priming).</p> <p><u>Aluminium surfaces:</u> Sweep blast-clean with none-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>Stainless steel:</u> Roughen the surface by grinding or sweep blasting using mineral abrasives.</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>
Primer	TEMACOAT HS PRIMER and GPL-S PRIMER, TEMABOND, TEMASIL 90, TEMAZINC 77 and 99.
Finish	TEMACOAT GPL, GS 50, RM 40, HS 40 and GPL-S MIO, TEMADUR and TEMATHANE.
Application conditions	All surfaces must be dry. The temperature of the ambient air and surface should not fall below + 0 °C / 32 °F and the temperature of the paint below 15 °C / 59 °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 spray. If necessary, the paint can be thinned 0 - 10 %. Airless spray nozzle tip 0.013" - 0.021"; the nozzle pressure 120 - 180 bar, spray angle shall be chosen according to the shape of the object.
Thinner	Thinner 1031.
Cleaning of equipment	Thinner 1031.
VOC	The Volatile Organic Compounds amount to 320 ± 20 g/litre of paint.
HEALTH AND SAFETY	<p>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.</p> <p>A health and safety data sheet is available on request from Tikkurila Coatings Oy.</p> <p>For professional use only.</p>

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