

## **TEMALINE EP 500**

**DESCRIPTION** A two component, solvent free epoxy coating.

PRODUCT FEATURES AND RECOMMENDED USES

- Excellent resistance to abrasion.
- Good adhesion to blasted substrate.
- Especially suitable for navigation markers and hulls of ice-going ships.
- ♦ Suitable for sluices, interiors of coal, wood chip and peat containers and other surfaces exposed to heavy mechanical abrasion.
- High film build properties, up to 500 μm in one coat.

## **TECHNICAL DATA**

**Volume solids**  $\approx 100 \%$ . (ISO 3233)

Weight solids  $\approx 100 \%$ .

Specific gravity 1.4 kg / I (mixed)

Mixing ratio and<br/>product codesBase<br/>Hardener2 parts by volume1 part by volume

Pot life ½ hour (23 °C / 74 °F)

Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage	
dry	wet		
350 µm	350 μm	2.9 m <sup>2</sup> /l	
700 μm	700 μm	1.4 m <sup>2</sup> /l	

368-series

008 6890

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

**Drying time** 

DFT 500 μm	+ 5 °C	+ 10 °C	+ 23 °C	+ 35 °C
Dust dry	22 h	18 h	12 h	6 h
Recoatable, without sanding	16 - 72 h	8 - 48 h	4 - 24 h	2 - 12 h
Fully cured (max. mechanical resistance)	21 d	14 d	7 d	3 d

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

Finish Glossy.

**Colours** White, black, grey and colour range of MKL. Other colours on request.

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## **APPLICATION DETAILS**

Surface preparation Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4)

Steel surfaces: Blast clean to grade Sa2½ - 3. (ISO 8501-1).

Primer TEMALINE EP 500.

**Finish** TEMALINE EP 500 and antifouling paints.

Application conditions All surfaces must be dry. The temperature of the paint should exceed +15 °C / 59 °F

and the temperature of the ambient air and surface should not fall below + 5  $^{\circ}$ C / 41  $^{\circ}$ F during application and drying. Relative humidity should not exceed 80  $^{\circ}$ C. The surface temperature of the steel should remain at least 3  $^{\circ}$ C / 38  $^{\circ}$ 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** It is recommended to use the product unthinned but if necessary it may be thinned

1 - 2 % by volume. Application with airless spray equipment, pressure ratio at least 1:60. Also application with a dual feed hot airless spray equipment, hose warming can be used. Airless spray nozzle tip 0.017" - 0.021"; spray angle shall be chosen according to the shape of the object. It is recommendable to use a reverse nozzle. Sharp edges, corners, weld seams and other areas difficult to paint should be painted

by brush prior to spray application.

Note! Pot life of the mixture is about 30 min. at + 23 °C / 74 °F. Avoid to let the mixture

cure in hoses, pump or spray gun.

**Thinner** Should not be thinned.

Cleaning of equipment Thinner 1031.

**VOC** Does not contain Volatile Organic Compounds.

**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.

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