

TF28

FONTECOAT EP PRIMER FONTECOAT EP 80

The waterborne epoxy systems TF28 are recommended for steel surfaces exposed to chemical and other special stress.

Corrosivity categories/durability according to ISO 12944

Tikkurila Coatings code

Treatment

Steel surfaces

S1.27, S2.15, S3.16

Corrosivity categories/durability C2-H, C3-L

Steel constructions in cold indoor spaces and outdoors in clean rural environment. E.g. framwork and service platforms in factories.

TF28 EP120/2-FeSa21/2

FONTECOAT EP PRIMER 80 µm FONTECOAT EP 80 40 µm

DFT 120 µm

S1.28, S2.16, S3.17

Corrosivity categories/durability C2-H, C3-M

Steel surfaces exposed to abrasion. According to SFS 5873, system S3.17 TF28 EP160/2-FeSa2½

FONTECOAT EP PRIMER 80 μ m FONTECOAT EP 80 80 μ m

DFT 160 μm

S1.34, S3.19, S4.13

Corrosivity categories/durability C3-H, C4-M

Steel constructions, machines and equipment in pulp and paper industry, exposed to severe splashes and chemical dust.

TF28 EP240/3-FeSa2½

FONTECOAT EP PRIMER 2 x 80 µm

FONTECOAT EP 80 <u>80 μm</u>

DFT $240 \mu m$

Marking of paint systems: TF28-SFS EN ISO 12944-5/S3.17 (EP160/2-FeSa21/2)

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. SD ZINC 1000 HA, zinc silicate

SURFACE PREPARATION

Remove firm contaminations in order to make the cleaning easier. Remove salts, grease and oil with a suitable detergent. Rinse the surfaces thoroughly with water. (ISO 12944)

Steel surfaces:

Blast clean steel surfaces to preparation grade Sa21/2. (ISO 8501 - 1)

APPLICATION CONDITIONS

The surface must clean and dry and the surface temperature should remain at least 3 $^{\circ}$ C/5 $^{\circ}$ F above the dew point. During application and drying the temperature of the air, paint and surface should be at least of +15 $^{\circ}$ C. The relative humidity should not exceed 80 $^{\circ}$ C.

APPLICATION

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.

MAINTENANCE PAINTING

Maintenance

Touch-up painting is sufficient for maintenance when the rust grade is Ri1 - Ri3. (ISO 4628-3)

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)

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.

Repainting

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 Sa 2½. Recoat in accordance with the original paint system.

PRODUCT INFORMATION

More detailed product information is available in respective data sheets.

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