

## TEMATHERM AA 30

**DESCRIPTION** An alkyd amino resin based stoving enamel.

**PRODUCT FEATURES AND RECOMMENDED USES**

- ∅ A stoving enamel for the metal industry.
- ∅ Suitable for exterior and interior steel and aluminium surfaces and zinc surfaces in dry interior premises.
- ∅ Good gloss and colour retention when exposed to exterior weathering.
- ∅ Used for painting lighting fixtures, metal furniture, household appliances and other equipment and machines.

### TECHNICAL DATA

**Volume solids** 54 ± 2%.

**Density** 1.0 - 1.4 kg / litre dependent on colour.

**Product code** 790 - series.

**Film thicknesses and theoretical coverage**

	Film thickness		Theoretical coverage
	wet	dry	
application range	55 - 75 µm	30 - 40 µm	18.0 - 13.5 m <sup>2</sup> /l

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

**Drying time**

DFT 40 µm	+ 150 °C	+ 180 °C
Dry	30 min	15 min

In an IR-radiation oven 3 - 10 minutes.

**Thinner** Thinner 1024 (slow), Thinner 1023 (fast).

**Cleaning of equipment** Thinner 1024 or 1023.

**Finish** Semi-gloss.

**Colours** RAL, BS, SSG, NCS and TVT colours.  
TEMASPEED tinting.

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## APPLICATION DETAILS

### 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 12944-4)

Phosphating improves adhesion and reduces corrosion under the paint film.

Steelsurfaces: Iron or zinc phosphating.

Zinc surfaces: Zinc phosphating.

Aluminium surfaces: Electroplating with chromium.

### Application

By spray, dip or flow coating. Stirr the paint thoroughly before use.

For cold airless spraying, conventional spraying and dip or flow coating, the paint should be thinned to a viscosity of approx. 20-25 s DIN 4/20°C. Dicco Thinner 1020 can be used in conventional spraying. For hot airless spraying, the paint should be thinned to a viscosity of approx. 70 s DIN 4/20°C.

Airless spray nozzle tip 0.009"-0.013"; spray angle shall be chosen according to the shape of the object.

### Stoving

The solvents should be allowed to flash off for a minimum of 10 minutes before stoving. Minimum stoving temperature is 150°C/250°F. Recommended stoving time, see overleaf. Stoving time is dependent on the metal thickness, especially in convection ovens. The optimum stoving time and temperature for each oven and product can only be determined through experimentation.

### VOC

The Volatile Organic Compounds amount to 410 ± 20 g/litre of paint.

## HEALTH AND SAFETY

At all times observe precautionary notices on containers. Further information about hazardous influences and protection against those are described in Safety Data Sheet.

A health and safety data sheet is available on request from Tikkurila Coatings OY.

As a general rule, avoid inhalation and skin contact and provide sufficient ventilation. Splashes on skin have to be washed off immediately. Splashes in eyes, rinse with plenty of water and consult a medical centre if the irritation continues.

**For professional use only.**