

Temacoat SPA 50

TYPE	A two component resin modified epoxy paint.
SUITABILITY	Good adhesion to steel, zinc and aluminium surfaces. Used as a primer, intermediate or finish coat on surfaces exposed to climatic, mechanical and chemical stress. Also suitable as a single coat system.
EXAMPLES OF USE	Recommended for building frameworks, tubular bridges, conveyors and other steelwork and equipment.

TECHNICAL DATA

Colour Cards RAL, NCS, SSG, BS, MONICOLOR NOVA and SYMPHONY colour cards. TEMASPEED tinting.

Gloss groups Semi-gloss

Coverage	Recommended film thicknesses		Theoretical coverage
	dry	wet	
	80 µm	110 µm	9.0 m ² /l
	150 µm	210 µm	4.8 m ² /l

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

Thinner 1031

Mixing ratio Base 4 parts by volume 158-series
Hardener 1 part by volume 008 5607 or 008 5601

Application method By airless spray or brush.

Pot-life (+23°C) 6 hours

Drying times	0 °C	+ 10 °C	+ 23 °C	+ 35 °C
DFT 100 µm				
Dust dry, after	16 h	4 h	2 h	1 h
Touch dry, after	24 h	10 h	4 h	2 h
Recoatible, min. after	24 h	3 h	1 h	½ h
Recoatible, surfaces to be submerged, min. after	4 d	28 h	12 h	6 h
Recoatible with polyurethane paints, min. after	1 d	5 h	2 h	1 h

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

Solids volume 69 ± 2 volume % with Hardener 008 5607, 66 ± 2 volume % with Hardener 008 5601. (ISO 3233)
85 ± 2 weight %

Product code 158-series

INSTRUCTIONS FOR USE

Application conditions All surfaces must be clean and dry and free from contamination. The temperature of the substrate should be minimum 0 °C and at least 3 °C above the dew point of the air. The product should not be applied at temperatures below 0 °C where there is a possibility of ice formation on the substrate. The temperature of paint itself should be above + 15 °C for proper application. Good ventilation is required in confined areas during application and drying.

Note! There is a natural tendency of epoxy coatings to chalk and discolor on exterior exposure.

Preparation	<p>Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4)</p> <p>Steel surfaces: 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>Zinc surfaces: 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 mist coat (paint thinned 25 - 30 %) before the actual priming.</p> <p>Aluminium surfaces: 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.</p> <p>Primed surfaces: 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>
Priming	TEMACOAT SPA PRIMER, TEMAZINC 77, TEMAZINC 88 and TEMAZINC 99.
Finishing	TEMACOAT HB 30, TEMACOAT GPL, TEMACOAT GS 50, TEMACOAT GPL-S MIO, TEMACOAT SPA 50, TEMADUR and TEMATHANE.
Painting	By airless spray or brush. At spray application the paint should be thinned 0 - 10 % by volume. Airless spray nozzle tip 0.015" - 0.021" and nozzle pressure 120 - 180 bar. Spray angle shall be chosen according to the shape of the object. At brush application the paint should be thinned according to the circumstances.
Mixing of components	First stir base and hardener separately. The correct proportions of base and hardener must be mixed thoroughly before use. Use Temaspeed Squirrel Mixer for mixing.
Cleaning of tools	Thinner 1031.
EU VOC 2004/42/ EC-limit value	The Volatile Organic Compounds amount is 270 g/litre of paint mixture. VOC content of the paint mixture (thinned 30 % by volume) is 470 g/l.

HEALTH AND SAFETY CLASSIFICATION

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 Oy.

The above information, based on laboratory tests and practical experience, has been proved valid at the date marked on the product data sheet. The quality of the product is ensured by our operational system, based on the requirements of ISO 9001 and ISO 14001. As a manufacturer we cannot be responsible for any damages caused by using the product against our instructions or for inappropriate purposes.

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