

Temacoat SPA MIO

DESCRIPTION A two component, polyamide-cured epoxy paint, pigmented with aluminium, micaceous iron oxide and zinc phosphate.

PRODUCT FEATURES Good adhesion to steel, zinc and aluminium surfaces. Used as a primer or as an intermediate coat in epoxy and polyurethane systems exposed to severe climatic conditions, abrasion, splashes and chemical dust. Can be used as an intermediate coat on zinc-rich epoxy and zinc silicate paints.

RECOMMENDED USES Recommended for exteriors of tanks, tubular bridges, conveyors and other steelwork, machinery and equipment.

TECHNICAL DATA

Features Forms a very strong and durable coat due to the special pigments. Low solvent content, lower solvent emissions than with traditional epoxy paints. High film build properties.

Colour Range Grey and light reddish brown.

Coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
100 µm	155 µm	6.5 m ² /l
200 µm	310 µm	3.2 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

Application method By airless spray or brush.

Pot-life (+23°C) 4 hours

Open time Base 4 parts by volume 008 7270-2
Hardener 1 part by volume 008 5459

Drying times

DFT 150 µm	+ 10 °C	+ 23 °C	+ 35 °C
Dust dry, after	2 h	1 h	½ h
Touch dry, after	10 h	5 h	2½ h
Recoatible, min. after	12 h	6 h	3 h
Fully cured, after	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.

Solids volume 65 ± 2 % (ISO 3233)
77 ± 2 %

Product code 008 7270-2

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APPLICATION DETAILS

Application conditions	All surfaces must be dry. The temperature of the ambient air, surface or paint should not fall below +10 °C during application or drying. Relative humidity should not exceed 80 %. The surface temperature of the steel should remain at least 3 °C above the dew point.
Preparation	Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4) 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. 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. Hot dip galvanized surfaces are recommended to be painted with a mist coat (paint thinned 25 - 30 %) before the actual priming. 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 FONTECLEAN AL detergent. 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)
Priming	TEMACOAT SPA MIO, TEMACOAT GPL-S PRIMER, TEMACOAT GF PRIMER, TEMAZINC 77, TEMAZINC 88 and TEMAZINC 99.
Finishing	TEMACOAT GPL, TEMACOAT GS 50, TEMACOAT RM 40, TEMACOAT HB 30, TEMADUR, TEMATHANE and TEMACRYL EA.
Painting	By airless spray or brush. At spray application the paint can be thinned 0 - 10 %. 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 320 g/litre of paint mixture. VOC content of the paint mixture (thinned 30 % by volume) is 460 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.