

Fontecoat EP Primer



TYPE A two component waterborne epoxy primer.

SUITABILITY Used as a primer for steel surfaces in epoxy and polyurethane paint systems. Can be used on ships for surfaces above water line. Can also be applied onto concrete substrate e.g. walls, plasterboard etc.

EXAMPLES OF USE Recommended as a primer for haulage equipment, cranes, steel masts, conveyors and other steelwork, machinery and equipment.

TECHNICAL DATA

Colour Range Red TVT 4000, grey TVT 4004 etc.

Gloss groups Semi-gloss

Coverage	Recommended film thicknesses		Theoretical coverage
	dry	wet	
	50 µm	105 µm	9.4 m ² /l
	70 µm	150 µm	6.7 m ² /l

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

Thinner Water

Mixing ratio Base 1 part by volume 007 1001-5
Hardener 1 part by volume 007 1019

Application method By airless spray or brush.

Pot-life (+23°C) 1½ h

Drying times	+ 15 °C	+ 23 °C	+ 35 °C
DFT 60 µm			
Dust dry, after	4 h	2 h	1 h
Touch dry, after	8 h	4 h	2 h
Recoat by itself, after	12 h	6 h	3 h
Recoat by solvent borne paints, after	48 h	24 h	12 h

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

Solids volume 47 ± 2 volume % (ISO 3233)
60 ± 2 weight %

Density 1.3 kg / l (mixed)

Product code 007 1001-5

INSTRUCTIONS FOR USE

Application conditions All surfaces must be dry. The temperature of the ambient air, surface or paint should not fall below +15 °C during application and drying. Relative humidity should not exceed 70 %. 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. 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	FONTECOAT EP PRIMER and TEMACOAT GPL-S PRIMER.
Finishing	FONTECOAT EP 50, FONTECOAT EP 80, FONTEDUR 90, TEMACOAT GPL, TEMACOAT GS 50, TEMADUR and TEMATHANE.
Painting	By airless spray or brush. If necessary, the paint can be thinned maximum 5 %. Airless spray nozzle tip 0.011" - 0.015" and nozzle pressure 140 - 180 bar. Spray angle shall be chosen according to the shape of the object.
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	Water or a mixture of water and Thinner 1029, 1:1. The equipment must be cleaned immediately after use before the paint dries.
EU VOC 2004/42/EC-limit value	The Volatile Organic Compounds amount is 60 g/litre of paint. VOC content of paint mixture (thinned by 10 % by volume) 57 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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