

Fontecryl 10 Dipp

TYPE	A waterborne, one component fast drying acrylic based paint which contains active anticorrosive pigments.
SUITABILITY	Suitable for dipping, flow coating and conventional spray application. Overcoatable with a wide range of products, also with solventborne products. Not suitable for immersion or constant humidity. Drying times can be shortened by using higher temperatures.
EXAMPLES OF USE	Steel surfaces.

TECHNICAL DATA

Colour Range Green RAL 6029, red TVT 4000, black TVT 4003 and brown RAL 8019.

Gloss groups Matt

Coverage	Recommended film thicknesses		Theoretical coverage
	dry	wet	
	30 µm	70 µm	14.0 m ² /l
	50 µm	120 µm	8.4 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

Application method Dip, flow coating or conventional spray.

Drying times	DFT 40 µm	+ 15 °C	+ 23 °C	+ 35 °C
	Dust dry, after	30 min	20 min	10 min
	Touch dry, after	6 h	1 - 2 h	20 min
	Recoatable, after	24 h	2 - 3 h	1 h
	Recoatable with solvent borne polyurethane paints, after		6 h	4 h

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

Solids volume 42 ± 2 % volume (ISO 3233)
52 ± 2 % weight

Density 1.2 - 1.3. kg / l depending on colour.

Product code 960 2438, 960 1825, 960 1836, 960 2177

MED Certificate  [VTT C 0840 15 06 Fontecryl10](#)

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 or drying. Relative humidity should be between 20 - 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.

Priming	FONTECRYL 10 DIPP.
Overcoating	After 2 - 3 hours: FONTECRYL 25, FONTECRYL 50, FONTELAC 90, FONTELAC QD 80, FONTECOAT EP 50, FONTECOAT EP 80, FONTEDUR 90, TEMALAC FD 50, TEMALAC FD 80 and TEMALAC ML 90. After 6 hours: TEMADUR, TEMALUX, TEMATHANE and TEMACRYL.
Painting	Dip, flow coating or conventional spray application. Depending on the application method the paint can be thinned 0 - 5 %.
Cleaning of tools	Water or FONTECLEAN 1921. 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 100 g/litre of paint. VOC content of paint (thinned 5 % by volume) is 95 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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