

Fontecryl 25

TYPE A waterborne, one component fast drying acrylic based paint which contains active anticorrosive pigments.

SUITABILITY Suitable for product painting in metal industry and painting stations. Recommended especially as a single coat paint system for steel structures indoors and outdoors. Not suitable for immersion or constant humidity. Drying times can be shortened by using higher temperatures.

EXAMPLES OF USE Typical uses are e.g. steel frameworks, machinery and equipment.

TECHNICAL DATA

Colour Cards TEMASPEED FONTE tinting.

Gloss groups Semi-matt

Coverage	Recommended film thicknesses		Theoretical coverage
	dry	wet	
	40 µm	100 µm	10.5 m ² /l
	60 µm	145 µm	7.0 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 By spray, brush or dipping.

Drying times	+ 15 °C	+ 23 °C	+ 35 °C
DFT 50 µm			
Dust dry, after	20 min	15 min	5 min
Touch dry, after	6 h	1 h	15 min
Recoatable, after	20 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 42 ± 2 % volume (ISO 3233)
53 ± 2 % weight

Density 1.2 ± 0.1 kg / l

Product code 214-series

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.

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 FONTECLEAN ZN detergent.

Hot dip galvanized surfaces are recommended to be painted with a misty coat (paint thinned 25 - 30 %) before the actual priming.

Aluminium surfaces: Sweep blast clean with none-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	FONTECRYL 25, FONTECRYL 10, TEMAPRIME AB and TEMAPRIME EE.
Finishing	FONTECRYL 25, FONTECRYL 50, FONTECEDUR 90 and FONTELAC QD 80.
Painting	By spray, brush or dipping. Depending on the application method the paint can be thinned 0 - 5 %. Airless spray nozzle tip 0.011" - 0.015" and nozzle pressure 120 - 160 bar. Spray angle shall be chosen according to the shape of the object.
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 75 g/litre of paint. VOC content in paint (thinned 5 % by volume) is 65 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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