

Fontecryl 50



TYPE A waterborne, one component semigloss acrylic based topcoat.

SUITABILITY Suitable for use in product painting in metal industry and painting stations. Good gloss and colour retention in climatic stress. Not suitable for immersion or constant humidity.

EXAMPLES OF USE Recommended for topcoating steel frameworks, various machinery and equipment indoors and outdoors.

TECHNICAL DATA

Colour Cards TEMASPEED FONTE tinting.

Gloss groups Semi-gloss

Coverage	Recommended film thicknesses		Theoretical coverage
	dry	wet	
	40 µm	95 µm	10.7 m ² /l
	60 µm	140 µm	7.2 m ² /l

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

Thinner Water

Application method By spray, brush or dipping.

Drying times	DFT 50 µm	+ 15 °C	+ 23 °C	+ 60 °C
Dust dry, after		20 min	15 min	5 min
Touch dry, after		6 h	1 h	15 min
Recoatable, after		24 h	3 h	2 h

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

Solids volume 43 ± 2 volume % (ISO 3233)
50 ± 2 weight %

Density 1,2 ± 0,1 kg/l .

Product code 212-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 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 10, FONTECRYL AP, FONTECRYL 25, TEMAPRIME AB, TEMAPRIME EE, TEMAPRIME EUR, TEMAPRIME GF and TEMAPRIME ML.

Finishing FONTECRYL 50.

Painting	By spray, brush or dipping. Depending on the application method the paint can be thinned 0 - 10 %. 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 of paint (thinned 10 % 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. For professional use only.

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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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