

FONTEDUR CLEAR

DESCRIPTION

A waterborne, two component polyurethane lacquer.

PRODUCT FEATURES AND RECOMMENDED USES

- ◆ Suitable to be used as a glossy lacquer in polyurethane systems.
- ◆ Resistant against moderate mechanical and chemical stress.
- ◆ Good gloss and colour retention in climatic stress.

TECHNICAL DATA

Volume solids 49 ± 2 %. (ISO 3233)

Weight solids 54 ± 2 %.

Specific gravity 1.1 ± 0.1 kg / l (mixed)

Mixing ratio and product codes
Base 5 parts by volume 005 5640
Hardener 2 parts by volume 007 1601

Note: a special thinner 006 1142 **must be added**, see mixing components.

Pot life 1½ hours (23 °C)

Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
30 µm	60 µm	16.7 m ² /l

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

Drying times

DFT 30 µm	+ 15 °C	+ 23 °C	+ 35 °C
Dust dry, after	4 h	2 h	1 h
Touch dry, after	12 h	6 h	3 h
Fully cured, after	14 d	7 d	3 d

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

Finish Glossy.

Colours Clear.

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APPLICATION DETAILS

Surface preparation	<u>Primed surfaces:</u> 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)
Primer	FONTEDUR and TEMADUR.
Finish	FONTEDUR CLEAR.
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 not exceed 80 %. The surface temperature of the steel should remain at least 3 °C above the dew point.
Mixing components	First mix base and hardener and stir thoroughly. Then add 20 vol-% Thinner 006 1142 and stir again carefully. The correct proportions of base, hardener and thinner must be mixed very thoroughly before use. Use Temaspeed Squirrel Mixer for mixing.
Application	By conventional spray. The base/hardener/thinner mix should be thinned 15 - 20 vol-% (DIN4/15 - 25 s) with water. Temaspeed Squirrel Mixer is recommended. Components may not be thinned before mixing.
Thinner	Water.
Cleaning of equipment	Water or FONTECLEAN 1921. The equipment must be cleaned immediately after use before the lacquer dries.
VOC	The Volatile Organic Compounds amount is 90 g/litre of lacquer. VOC content of lacquer (thinned 20 % with Thinner 006 1142 and 20 % with water) is 180 g/l.
HEALTH AND SAFETY	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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