

Fontedur 90



TYPE A waterborne, two component polyurethane finish.

SUITABILITY Suitable to be used as a glossy topcoat for steel surfaces in epoxy and polyurethane systems.

EXAMPLES OF USE Steel surfaces.

TECHNICAL DATA

Features Resistant against moderate mechanical and chemical stress. Good gloss and colour retention in climatic stress.

Colour Cards TEMASPEED FONTE tinting.

Gloss groups Gloss

Coverage	Recommended film thicknesses		Theoretical coverage
	dry	wet	
	40 µm	80 µm	12.5 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 5 part by volume 145-series
Hardener 1 part by volume 007 1600

Application method By conventional or airless spray or by brush.

Pot-life (+23°C) 1½ h

Drying times	DFT 40 µm	+ 15 °C	+ 23 °C	+ 50 °C
		Dust dry, after	3 h	1½ h
Touch dry, after	12 h	6 h	2 h	
Recoatable, after	16 h	8 h	3 h	
Fully cured, after	14 d	7 d	3 d	

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

Solids volume 50 ± 2 volume % (ISO 3233)
62 ± 2 weight %

Density 1.3 ± 0.1 kg / l (mixed)

Product code 145-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 not exceed 80 %. 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	FONTECOAT EP PRIMER, FONTECOAT EP 50, FONTECRYL 10, FONTECRYL AP and TEMACOAT GPL-S PRIMER.
Finishing	FONTECOAT 90 and TEMADUR CLEAR.
Painting	By conventional or airless spray or by brush. The paint should be thinned 10 - 20 % after mixing. Components may not be thinned before mixing. Airless spray nozzle tip 0.011" - 0.013" and nozzle pressure 120 - 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 very thoroughly before use. Use Temaspeed Squarrel Mixer for mixing.
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 85 g/litre of paint. VOC content of paint (thinned 20 % by volume) is 70 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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