

**TE18**
**TEMACOAT SPA  
TEMACOAT GPL**

The epoxy systems TE18 are recommended for steel, stainless steel, aluminium and zinc surfaces exposed to abrasion, chemicals and climate in indoors and outdoors applications. Resistance to chemicals in a separate table.

Corrosivity categories/durability according to ISO 12944	Tikkurila Coatings code	Treatment
<b>Steel surfaces</b>		
<b>S1.34, S3.19, S4.13</b>	<b>TE18</b>	<b>EP240/3-FeSa2½</b>
<b>Corrosivity categories/durability C3-H, C4-M</b>	TEMACOAT SPA	2 x 80 µm
Steelwork exposed to severe climatic conditions, where the humidity and salinity are high.	TEMACOAT GPL	<u>80 µm</u>
		DFT
		240 µm
<b>S1.37, S4.14</b>	<b>TE18</b>	<b>EP280/3-FeSa2½</b>
<b>Corrosivity categories/durability C4-H</b>	TEMACOAT SPA	80 µm
Steelwork and equipment exposed to gases and chemically active dust in industrial environment.	TEMACOAT SPA	120 µm
	TEMACOAT GPL	<u>80 µm</u>
		DFT
		280 µm
<b>S1.40, S4.15, S5.15, S6.04, S7.04</b>	<b>TE18</b>	<b>EP320/4-FeSa2½</b>
<b>Corrosivity categories/durability C4-H, C5-M-H, C5-I-H</b>	TEMACOAT SPA	3 x 80 µm
Steelwork, machinery and equipment in wood and chemical industries exposed to splashes and chemically active dust.	TEMACOAT GPL	<u>80 µm</u>
		DFT
		320 µm
<b>Marking of paint systems: TE18-SFS EN ISO 12944-5/S4.14 (EP280/3-FeSa2½)</b>		

**Aluminium surfaces**

<b>Corrosivity categories C2, C3, C4</b>	<b>TE18</b>	<b>EP120/2-AISaS</b>
Aluminium surfaces, indoors and outdoors, exposed to mechanical abrasion and mild or modest gas and chemically active dust.	TEMACOAT SPA	60 µm
According to SFS 5873, system F40.05	TEMACOAT GPL	<u>60 µm</u>
		DFT
		120 µm

**Zinc surfaces (hot-dip galvanized)**

<b>S9.11</b>	<b>TE18</b>	<b>EP160/2-ZnSaS</b>
<b>Corrosivity categories/durability C4-H, C5-I-L, C5-M-M</b>	TEMACOAT SPA	80 µm
Zinc surfaces, indoors and outdoors, exposed to mechanical abrasion and mild or modest gas and chemically active dust.	TEMACOAT GPL	<u>80 µm</u>
		DFT
		160 µm
<b>S9.12</b>	<b>TE18</b>	<b>EP240/3-ZnSaS</b>
<b>Corrosivity categories/durability C4-H, C5-I-M, C5-M-M</b>	TEMACOAT SPA	2 x 80 µm
Zinc surfaces, indoors and outdoors, exposed to mechanical abrasion and mild or modest gas and chemically active dust.	TEMACOAT GPL	<u>80 µm</u>
According to SFS 5873, system F30.07		DFT
		240 µm

**COLOURS**

The product is tintable with TEMASPEED colorants, thus ensuring the possibility to get shades from RAL-, BS-, NCS- and other colour cards.

**SUITABLE SHOP PRIMERS**

TEMABLAST EV 110, epoxy shop primer.  
SD ZINC 1000 HA, zinc silicate

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**SURFACE PREPARATION**

Remove firm contaminations in order to make the cleaning easier. Remove salts, grease and oil with a suitable detergent. Rinse the surfaces thoroughly with water. ( ISO 12944 )

**Steel surfaces:**

Blast clean steel surfaces to preparation grade Sa2½. ( ISO 8501 - 1 )

**Zinc surfaces:**

Sweep blast-clean with mineral abrasives, e.g. quartz sand, to grade SaS. (SFS 5873). If blast cleaning isn't possible, the surfaces should be roughened by grinding or washed with PANSSARIPESU detergent. In these cases the adhesion of the paint to the substrate should be confirmed.

Damages in the zinc coating have to be repaired with TEMAZINC 99, a zinc rich epoxy paint. Before painting, clean the surfaces thoroughly (Sa2½/St3) and level off the edges around the cleaned areas.

**Aluminium surfaces:**

Sweep blast-clean with none-metallic abrasives to grade SaS. (SFS 5873). If blast cleaning isn't possible, the surfaces should be roughened by grinding or washed with MAALIPESU detergent. In these cases the adhesion of the paint to the substrate should be confirmed.

**APPLICATION CONDITIONS**

The surface must clean and dry and the surface temperature should remain at least 3 °C above the dew point. During application and drying the temperature of the air, paint and surface should be a minimum of + 10 °C. The relative humidity should not exceed 80 %.

**APPLICATION**

The paint should be mixed thoroughly before application and then applied in an even coat on the dry and clean surface. Application with airless or conventional spray, brush or roller. Stripe coating of sharp edges, welding seams etc. should be done by brush or roller.

**MAINTENANCE PAINTING****Maintenance**

Touch-up painting is sufficient for maintenance when the rust grade is Ri1 - Ri3. ( ISO 4628-3 )

Damages caused by transport or installation may also be repaired by touch-up painting. Remove all loose paint, clean rusty areas according to system demands. On steel surfaces small areas can be grinded or wire brushed to preparation grade St2 (SFS-ISO 8501-1).

Level off the edges between the old paint film and the cleaned up areas. When using blast cleaning, be sure that there are no cracks in the remaining paint film. If the entire surface has to be overcoated, abrade the old topcoat to a rough finish. Remove all dust and other cleaning residues. Apply primers and finish according to the original paint system, qualities and film thicknesses.

**Repainting**

When the rust grade is Ri4 or Ri5, the entire coating must be renewed. Remove the old paint film and clean the surfaces to preparation grade Sa 2½. Recoat in accordance with the original paint system.

**PRODUCT INFORMATION**

More detailed product information is available in respective data sheets.