

**TE68**
**TEMABOND ST 200**
**TEMACOAT HB 30**

The epoxy systems TE68 are recommended for steel constructions when blast cleaning is not achievable. The primer, TEMABOND ST 200 forms a very tight, abrasion and chemically resistant coat due to the aluminium pigments. Maintenance painting systems.

Corrosivity categories/durability according to ISO 12944	Tikkurila Coatings code	Treatment
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**Steel surfaces**
**Corrosivity categories/durability C2, C3**

Steel surfaces in environment where the humidity and salinity are moderate.

According to SFS 5873, system R25.06

<b>TE68</b>	<b>EP160/2-FeSt2</b>	
TEMABOND ST 200		100 µm
TEMACOAT HB 30		<u>60 µm</u>
	DFT	160 µm

**Corrosivity categories/durability C3-H, C4-M**

Steel constructions, machines and equipment in industrial environment, exposed severe splashing and dust.

According to SFS 5873, system R25.08

<b>TE68</b>	<b>EP240/2-FeSt2</b>	
TEMABOND ST 200		120 µm
TEMACOAT HB 30		<u>120 µm</u>
	DFT	240 µm

**Corrosivity categories/durability C3, C5-I, C5-M**

Steel constructions and equipment, which are exposed to gas and chemical dust. E.g. framework for pipe lines and service platforms.

According to SFS 5873, system R25.10

<b>TE68</b>	<b>EP300/3-FeSt2</b>	
TEMABOND ST 200		150 µm
TEMACOAT HB 30		<u>150 µm</u>
	DFT	300 µm

**Marking of paint systems: TE68-SFS 5873/R25.10 (EP300/2-FeSt2)**
**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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<b>SURFACE PREPARATION</b>	<p>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 )</p> <p><b>Steel surfaces:</b> Power tool or wirebrush cleaning of steel surfaces to at least preparation grade St2, the best result is achieved by blast cleaning. ( ISO 8501 - 1 ).</p>
<b>APPLICATION CONDITIONS</b>	<p>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 %.</p>
<b>APPLICATION</b>	<p>The paint should be mixed thoroughly before application and then applied in an even coat on the dry and clean surface. Stripe coating of sharp edges, welding seams etc. should be done by brush or roller.</p>
<b>MAINTENANCE PAINTING</b>	<p><b>Maintenance</b> 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.</p> <p><b>Repainting</b> 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.</p>
<b>PRODUCT INFORMATION</b>	<p>More detailed product information is available in respective data sheets.</p>

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