

TEMABOND ST 300

DESCRIPTION

A two component high-solids, modified epoxy paint.

PRODUCT FEATURES AND RECOMMENDED USES

- ◆ Forms a tight coat with good chemical and abrasion resistance.
- ◆ Especially used as a primer for steel surfaces difficult to clean in process and chemical industry and in water immersion.
- ◆ High film build properties, also by brush.
- ◆ Very good adhesion to blast cleaned or hand prepared steel.
- ◆ Low solvent content, lower solvent emissions than with traditional epoxy paints.
- ◆ Recommended for repairing of damages caused by transport or installation.
- ◆ Can also be applied on old alkyd paint surfaces.
- ◆ Can be used as a single coat paint.

TECHNICAL DATA

Volume solids 80 ± 2 %. (ISO 3233)

Weight solids 88 ± 2 %.

Specific gravity 1.5 kg / l (mixed)

Mixing ratio and product codes

Base	1 part by volume	162-series
Hardener	1 part by volume	008 7501

Pot life 1½ hours (23 °C / 74 °F)

Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
100 µm	125 µm	8.0 m ² /l
200 µm	250 µm	4.0 m ² /l

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

Drying time

DFT 150 µm	+ 10 °C	+ 23 °C	+ 35 °C
Dust dry	6 h	3 h	1½ h
Touch dry	14 h	5½ h	3½ h
Recoatible with polyurethane, epoxy	30 h	8 h	5 h
Recoatible, max. without sanding	2 months	1 month	7 d

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

Finish

Glossy.

Colours

Reddish brown (0284) and grey (RAL 7032). TEMASPEED tinting.

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APPLICATION DETAILS

Surface preparation	Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4) <u>Steel surfaces:</u> Remove rust by tool cleaning to minimum St2 or blast clean to Sa2½ . Blast clean to grade Sa2½ for immersion. (ISO 8501-1). <u>Earlier painted surfaces:</u> Roughen old paint surfaces using e.g. abrasive wheel, sand paper or blast cleaning.
Primer	TEMABOND ST 200 and ST 300, TEMAZINC 77 and 99, FONTECOAT EP PRIMER.
Finish	TEMACOAT GPL, TEMACOAT GPL-S MIO, TEMACOAT GPL-S PRIMER, TEMACOAT GS 50, TEMACOAT RM 40, TEMACOAT HS 40, TEMABOND ST 300, TEMADUR, TEMATHANE and TEMACRYL EA.
Application conditions	All surfaces must be dry. The temperature of the ambient air, surface or paint should not fall below +10 °C / 50 °F during application and drying. Relative humidity should not exceed 80 %. The surface temperature of the steel should remain at least 3 °C / 38 °F above the dew point.
Mixing components	First stir base and hardener separately. The correct proportions of base and hardener must be mixed thoroughly before use. Use a mechanical agitator for mixing.
Application	By airless spray or brush. Depending on the temperature of the components the paint can be thinned 0 - 10 %. Airless spray nozzle tip 0.013" - 0.019"; nozzle pressure 120 - 180 bar, spray angle shall be chosen according to the shape of the object. At brush application the paint should be thinned according to the circumstances.
Thinner	Thinner 1031.
Cleaning of equipment	Thinner 1031.
VOC	The Volatile Organic Compounds amount to 220 ± 20 g/litre of paint.
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 Coatings Oy. For professional use only.

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