

TEMACOAT GF PRIMER

DESCRIPTION

A two component, polyamide cured epoxy primer containing zinc phosphate.

PRODUCT FEATURES AND RECOMMENDED USES

- ◆ Used as a primer for steel, aluminium and zinc surfaces in epoxy and polyurethane systems, when high requirements for the appearance are set.
- ◆ Recommended for agricultural machinery, haulage equipment and other machinery and equipment.

TECHNICAL DATA

Volume solids 55 ± 2 %. (ISO 3233)

Weight solids 70 ± 2 %.

Specific gravity 1.4 kg / l (mixed)

Mixing ratio and product codes
Base 4 parts by volume 178-series.
Hardener 1 part by volume 008 5600 or 008 5605 (fast)

Pot life
6 hours (23 °C / 74 °F) with Hardener 008 5600
3 hours (23 °C / 74 °F) with Hardener 008 5605

Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
50 µm	90 µm	11.0 m ² /l
70 µm	130 µm	7.8 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 60 µm		+ 5 °C	+ 10 °C	+ 23 °C	+ 35 °C
Dust dry, after	with Hardener 008 5600	2 h	1 h	½ h	15 min
	with Hardener 008 5605	1½ h	¾ h	½ h	12 min
Touch dry, after	with Hardener 008 5600	11 h	5 h	2½ h	2 h
	with Hardener 008 5605	6 h	3½ h	2 h	1½ h
Recoatable, min., with epoxy paints	with Hardener 008 5600	20 h	6 h	2 h	1 h
	with Hardener 008 5605	12 h	4 h	1½ h	¾ h
Recoatable, min., with polyurethane paints	with Hardener 008 5600	32 h	18 h	6 h	3 h
	with Hardener 008 5605	18 h	12 h	4 h	2 h

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

Finish Semimatt.

Colours Temaspeed Primers colour card. TEMASPEED tinting.

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APPLICATION DETAILS

Surface preparation	<p>Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4)</p> <p><u>Steel surfaces:</u> Blast clean to grade Sa2½. (ISO 8501-1) If blast cleaning is not possible, phosphating is recommended for cold rolled steel to improve adhesion.</p> <p><u>Zinc surfaces:</u> Sweep blast-clean with mineral abrasives, e.g. quartz sand, to an even roughness. (SaS, SFS 5873) If sweep blasting is not possible, the surface should be roughened by hand abrading or washed with PANSSARIPESU detergent.</p> <p>Hot dip galvanized surfaces are recommended to be painted with a misty coat (paint thinned 25 - 30 % or with separate TEMACOAT SEALER before the actual priming).</p> <p><u>Aluminium surfaces:</u> Sweep blast-clean with non-metallic abrasives to an even roughness. (SaS, SFS 5873) If sweep blasting is not possible, the surface should be roughened by hand abrading or washed with MAALIPESU detergent.</p> <p><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)</p>
Primer	TEMACOAT GF PRIMER, TEMAZINC 77 and 99.
Finish	TEMACOAT GPL, TEMACOAT GS 50, TEMACOAT RM 40, TEMACOAT HS 40, TEMACOAT GPL-S MIO, 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 + 5 °C / 41 °F during application or 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	<p>By airless or conventional spray or by brush. At airless spray application the paint should be thinned 5 - 25 %. Airless spray nozzle tip 0.011" - 0.017", spray angle shall be chosen according to the shape of the object.</p> <p>At conventional spray the paint should be thinned 20 - 30 % to a viscosity of 20 - 30 s DIN4.</p> <p>At brush application the paint should be thinned according to the circumstances.</p>
Thinner	Thinner 1031.
Cleaning of equipment	Thinner 1031.
VOC	The Volatile Organic Compounds amount to 430 ± 20 g/litre of paint.
HEALTH AND SAFETY	<p>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.</p> <p>A health and safety data sheet is available on request from Tikkurila Coatings Oy.</p> <p>For professional use only.</p>