

## TEMADUR 20

### DESCRIPTION

A two component, semi-matt polyurethane paint containing anti-corrosive pigments, hardener aliphatic isocyanate.

### PRODUCT FEATURES AND RECOMMENDED USES

- ◆ Excellent weathering and abrasion resistance.
- ◆ Recommended as a primer for polyurethane systems or as a semi-matt topcoat for epoxy systems exposed to weathering and/or chemical stress.
- ◆ Due to anti-corrosion pigments can also be used as a single coat system for steel, zinc and aluminium surfaces.
- ◆ Recommended for painting of transport and haulage equipment, storage tank exteriors, steel framework and other steel structures, machinery and equipment.
- ◆ The product has MED (Marine Equipment Directive) certificate no 0809-MED-0397 and is thus accepted for painting surfaces inside the ships.

### TECHNICAL DATA

**Volume solids** 57 ± 2 %. (ISO 3233)

**Weight solids** 70 ± 2 %.

**Specific gravity** 1.3 ± 0.1 kg / l (mixed)

**Mixing ratio and product codes**  
Base 5 parts by volume 114-series  
Hardener 1 part by volume 008 7590

**Pot life** 4 hours (23 °C)

### Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
40 µm	70 µm	14.2 m <sup>2</sup> /l
100 µm	175 µm	5.7 m <sup>2</sup> /l

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

### Drying times

DFT 50 µm	+ 5 °C	+ 10 °C	+ 23 °C	+ 35 °C
Dust dry, after	45 min	30 min	15 min	10 min
Touch dry, after	8 h	6 h	4 h	2 h
Recoatable, after	No limitations.			

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

**Finish** Semi-matt.

**Colours** RAL, NCS, SSG, BS, MONICOLOR NOVA and SYMPHONY colour cards. TEMASPEED tinting.

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## APPLICATION DETAILS

<b>Surface preparation</b>	<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 FONTECLEAN ZN detergent.</p> <p>Hot dip galvanized surfaces are recommended to be painted with a misty coat (paint thinned 25 - 30 %) before the actual priming.</p> <p><u>Aluminium surfaces:</u> Sweep blast-clean with none-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 FONTECLEAN AL detergent.</p> <p><u>Stainless steel:</u> Roughen the surface by grinding or sweep blasting using mineral abrasives.</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>
<b>Primer</b>	TEMACOAT GPL-S PRIMER, TEMACOAT GF PRIMER, TEMACOAT HB PRIMER, TEMACOAT PM PRIMER, TEMACOAT GPL-S MIO, TEMACOAT RM 40, TEMACOAT SPA, TEMABOND, TEMAMASTIC PM 100, TEMAPRIME GF, FONTECRYL 10 and FONTECOAT EP PRIMER.
<b>Finish</b>	TEMADUR and TEMATHANE.
<b>Application conditions</b>	All surfaces must be dry. The temperature of the ambient air, surface or paint should not fall below + 5 °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.
<b>Mixing components</b>	First stir base and hardener separately. The correct proportions of base and hardener must be mixed thoroughly before use. Use Temaspeed Squirrel Mixer for mixing.
<b>Application</b>	By airless or conventional spray or by brush. Depending on the temperature of the components (base, hardener, thinner) and the required viscosity the paint can be thinned 0 - 30 %. Airless spray nozzle tip 0.011" - 0.015" and nozzle pressure 120 - 160 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.
<b>Thinner</b>	Thinner 1048 or Thinner 1067. Thinner 1061 (fast) is also suitable for conventional spraying.
<b>Cleaning of equipment</b>	Thinner 1048, 1067 or 1061.
<b>VOC</b>	The Volatile Organic Compounds amount is 420 g/litre of paint mixture. VOC content of the paint mixture (thinned 30 % by volume) is 530 g/l.
<b>HEALTH AND SAFETY</b>	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.

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