

TEMALAC ML 90

DESCRIPTION

A high gloss, one component alkyd topcoat.

PRODUCT FEATURES AND RECOMMENDED USES

- ◆ High gloss alkyd topcoat for steel surfaces.
- ◆ Good gloss and colour retention when exposed to weathering.
- ◆ Can be applied using a "wet-on-wet" painting technique.
- ◆ Suitable for industrial finishing.
- ◆ Recommended uses: small tanks, agricultural machinery, haulage equipment and other machinery and equipment.

TECHNICAL DATA

Volume solids	45 ± 2 %. (ISO 3233)
Weight solids	57 ± 2 %.
Specific gravity	0.9 - 1.1 kg / l depending on colour.
Product code	513-series

Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
40 µm	90 µm	11.2 m ² /l
60 µm	135 µm	7.5 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 40 µm	+ 10 °C	+ 23 °C	+ 35 °C
Dust dry, after	2 h	1 h	½ h
Touch dry, after	8 h	5 h	3 h
Recoatable, after	36 h	24 h	16 h
Recoatable, "wet-on-wet", after		½ - 1 h	
Touch dry 1 h / 60 °C, ½ h / 80 °C			

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

Finish

High gloss.

Colours

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

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APPLICATION DETAILS

Surface preparation	<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)
Primer	TEMAPRIME EE, TEMAPRIME EUR, TEMAPRIME GF, TEMAPRIME ML and FONTECRYL 10.
Finish	TEMALAC ML 90.
Application conditions	All surfaces must be dry. The temperature of the ambient air, surface and paint should not fall below + 5 °C during application and drying. Relative humidity should not exceed 80 %. The temperature of the substrate should remain at least 3 °C above the dew point.
Application	By airless or conventional spray or by brush. Mix the paint thoroughly before use. At airless spray the paint should be thinned 0 - 10 % to a viscosity of 30 - 60 s DIN 4. Airless spray nozzle tip 0.011" - 0.015" and nozzle pressure 140 - 180 bar. Spray angle shall be chosen according to the shape of the object. At conventional spray the paint should be thinned 20 - 30 %. The best finish is obtained using a "wet-on-wet" technique, with 5 - 30 minutes evaporating pauses.
Thinner	At spray application Thinner 1006. At brush application Thinner 1054.
Cleaning of equipment	Thinner 1006 or Thinner 1054.
VOC	The Volatile Organic Compounds amount is 460 g/litre of paint. VOC content of the paint (thinned 30 % by volume) is 550 g/l.
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.

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