FONTECOAT EP 60

DESCRIPTION
A two component, waterborne epoxy topcoat and a single coat paint.

PRODUCT FEATURES AND RECOMMENDED USES
- Used as a topcoat for epoxy paint systems on steel surfaces or as a single coat paint.
- Resistant against modest mechanical and chemical stress.

TECHNICAL DATA

Volume solids 45 ± 2 %.
Density 1.4 kg / litre (mixed).

Product codes and mixing ratio
- Base 1 part by volume 168 - series.
- Hardener 1 part by volume 007 1019

Pot life 1½ h (23 °C/ 74 °F).

Film thicknesses and theoretical coverage

<table>
<thead>
<tr>
<th>Film thickness</th>
<th>Theoretical coverage</th>
</tr>
</thead>
<tbody>
<tr>
<td>wet</td>
<td>dry</td>
</tr>
<tr>
<td>application range</td>
<td>110 - 350 µm</td>
</tr>
<tr>
<td>typical</td>
<td>220 µm</td>
</tr>
</tbody>
</table>

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

Drying time

<table>
<thead>
<tr>
<th>Drying time</th>
<th>+ 15 °C</th>
<th>+ 23 °C</th>
<th>+ 35 °C</th>
</tr>
</thead>
<tbody>
<tr>
<td>DFT 100 µm</td>
<td>4 h</td>
<td>2 h</td>
<td>1 h</td>
</tr>
<tr>
<td>Dust dry</td>
<td>8 h</td>
<td>5 h</td>
<td>2 h</td>
</tr>
<tr>
<td>Touch dry</td>
<td>16 h</td>
<td>6 h</td>
<td>4 h</td>
</tr>
<tr>
<td>Recoatable (min.), by itself</td>
<td>14 d</td>
<td>7 d</td>
<td>3 d</td>
</tr>
<tr>
<td>Fully cured</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

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

Thinner
Water.

Cleaning of equipment
Water or a mixture of water and Thinner 1029, 1:1. The equipment must be cleaned immediately after use before the paint has dried.

Finish
Semigloss.

Colours
By request.
The above information, based on laboratory tests and practical experience, has been proved valid at the date marked on the product data sheet. When necessary verify the validity of the product data sheet. The quality of the product is ensured by our operational system, based on the requirements of the standards ISO 9001 and ISO 14001. As a manufacturer we cannot be responsible for any damages caused by using the product against our instructions or for inappropriate purposes.

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APPLICATION DETAILS

Surface preparation

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.

Steel surfaces: Blast clean to grade Sa2½ (ISO 8501-1).

Primed surfaces: Remove water soluble salts, oil and grease and other contaminants which may harm coating. Let the surfaces dry and remove dust. Touch up damages in the primer coat. (ISO 12944-4).

Prime

FONTECOAT EP PRIMER, FONTECOAT EP 60, TEMACOAT GPL-S PRIMER.

Finish

FONTECOAT EP 60.

Application conditions

All surfaces must be dry. The temperature of the ambient air, surface or paint should not fall below +15 °C / 59 °F during application and drying. Relative humidity should not exceed 70 %. The surface temperature of the steel should remain at least 3 °C / 5 °F above the dew point.

Application

By airless spray or brush. Before the mixing of components, base:hardener (1:1) those should be thoroughly stirred. The correct proportions of base and hardener must be mixed thoroughly before use, mechanical mixing is recommended. If necessary, the paint can be thinned 0-15 %. Airless spray nozzle tip 0.011"-0.015"; spray angle shall be chosen according to the shape of the object.

VOC

The Volatile Organic Compounds amount to 60 ± 5 g/litre of paint.

HEALTH AND SAFETY

At all times observe precautionary notices on containers. Further information about hazardous influences and protection against those are described in Safety Data Sheet. A health and safety data sheet is available on request from Tikkurila Coatings OY.

As a general rule, avoid inhalation and skin contact and provide sufficient ventilation. Splashes on skin have to be washed off immediately. Splashes in eyes, rinse with plenty of water and consult a medical centre if the irritation continues.

For professional use only.