FONTECRYL 10

DESCRIPTION
A waterborne, one component fast drying acrylic based paint which contains active anticorrosive pigments.

PRODUCT FEATURES AND RECOMMENDED USES
♦ Used as a primer for interior and exterior steel surfaces.
♦ Overcoatable with a wide range of products, also with solvent borne products.
♦ Not suitable for immersion or constant humidity.
♦ Drying times can be shortened by using higher temperatures.

TECHNICAL DATA

Volume solids 43 ± 2 %. (ISO 3233)

Weight solids 53 ± 2 %.

Specific gravity 1.2 ± 0.1 kg / l

Product code 213-series.

Recommended film thicknesses and theoretical coverage

<table>
<thead>
<tr>
<th>Recommended film thicknesses</th>
<th>Theoretical coverage</th>
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<tbody>
<tr>
<td>dry 40 µm</td>
<td>wet 95 µm</td>
</tr>
<tr>
<td>10.7 m²/l</td>
<td></td>
</tr>
<tr>
<td>60 µm 140 µm</td>
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<tr>
<td>7.2 m²/l</td>
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</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>DFT 50 µm</th>
<th>+ 15 °C</th>
<th>+ 23 °C</th>
<th>+ 35 °C</th>
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</thead>
<tbody>
<tr>
<td>Dust dry</td>
<td>30 min</td>
<td>20 min</td>
<td>10 min</td>
</tr>
<tr>
<td>Touch dry</td>
<td>6 h</td>
<td>1 - 2 h</td>
<td>20 min</td>
</tr>
<tr>
<td>Recoatable, min.</td>
<td>24 h</td>
<td>2 - 3 h</td>
<td>1 h</td>
</tr>
<tr>
<td>Recoatable, min. with solvent borne polyurethane paints</td>
<td>24 h</td>
<td>12 h</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.

Finish
Matt.

Colours
Reddish brown and grey. Other colours as per order.
FONTECRYL 10

APPLICATION DETAILS

Surface preparation

Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4)

**Steel surfaces:** Blast clean to grade Sa2½. (ISO 8501-1) If blast cleaning is not possible, phosphating is recommended for cold rolled steel to improve adhesion.

**Zinc surfaces:** 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.

Hot dip galvanised surfaces are recommended to be painted with a misty coat (paint thinned 25 - 30 % or with separate TEMACOAT SEALER primer before the actual priming).

**Aluminium surfaces:** 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 MAALIPESU detergent.

Primer

FONTECRYL 10 and TEMAZINC EE 91.

Finish

After 2 - 3 h: FONTECRYL 25 and 50, FONTELAC 90, FONTELAC QD 80, FONTEDUR 90, FONTECOAT EP 50, FONTECOAT EP 80, TEMALAC FD 50, TEMALAC FD 80 and TEMALAC ML 90.

After 6 h: TEMADUR, TEMALUX, TEMATHANE and TEMACRYL.

Application conditions

All surfaces must be dry. The temperature of the ambient air, surface or paint should not fall below +15 ºC / 59 ºF during application or drying. Relative humidity should be between 20 - 70 %. The surface temperature of the steel should remain at least 3 ºC / 38 ºF above the dew point.

Application

By spray or brush. Depending on the application method the paint can be thinned 0 - 5 %. Airless spray nozzle tip 0,011" - 0,015"; spray angle shall be chosen according to the shape of the object.

Thinner

Water.

Cleaning of equipment

Water or VO cleaner. The equipment must be cleaned immediately after use before the paint dries.

VOC

The Volatile Organic Compounds amount to 95 ± 5 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.

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 of for inappropriate purposes.