FONTECRYL 25

DESCRIPTION

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

PRODUCT FEATURES AND RECOMMENDED USES

- Suitable for use in product painting in metal industry and painting stations.
- Recommended especially as a single coat paint system for steel structures in dry interior areas.
- Typical uses are e.g. steel frameworks, machinery and equipment.
- Not suitable for immersion or constant humidity.
- Drying times can be shortened by using higher temperatures.

TECHNICAL DATA

Volume solids 42 ± 2 %. (ISO 3233)

Weight solids 53 ± 2 %.

Specific gravity 1.2 ± 0.1 kg / l

Product code 214-series.

Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
40 µm	100 µm	10.5 m^2/l
60 µm	145 µm	7.0 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 50 µm, RH 50 %	**+ 15 ºC**	**+ 23 ºC**	**+ 35 ºC**
Dust dry	20 min	15 min	5 min
Touch dry	6 h	1 h	15 min
Recoatable	20 h	2 h	1 h

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

Finish Semimatt.

Colours SYMPHONY tinting.

FONTECRYL 25

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 galvanized 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.

Primed surfaces: 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

FONTECRYL 25 and 10, TEMAPRIME AB and TEMAPRIME EE.

Finish

FONTECRYL 25 and 50, FONTEDUR 90 and FONTELAC QD 80.

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, brush or dipping. 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 FONTECLEAN 1921. The equipment must be cleaned immediately after use before the paint dries.

VOC

The Volatile Organic Compounds amount to 75 ± 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.

tmk170203/214-s.

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.