TE50

TEMACOAT RM 40

The epoxy systems TE50 are recommended for steel, stainless steel, aluminium and zinc surfaces exposed to abrasion, chemicals, high humidity and climate in indoor and outdoor applications, also for submerged and underground constructions. TEMACOAT RM 40 is available in many colours, also light ones, which makes it easier to follow up the condition of the coating.

### Corrosivity categories/durability according to ISO 12944

#### Steel surfaces

**S1.34, S3.19, S4.13**  
Corrosivity categories/durability C3-H, C4-M  
Steelwork exposed to severe climatic conditions, where the humidity is high.

**S1.37, S4.14**  
Corrosivity categories/durability C4-H  
Steelwork and equipment in damp environment, e.g. inside of pontoons, ballast water tanks.

**S8.04**  
Corrosivity categories/durability Im1, Im2, Im3  
Steel constructions in underground and underwater applications and surfaces exposed to extensive splashing.

**Marking of paint systems:** TE50-SFS EN ISO 12944-5/S4.14 (EP280/3-FeSa2½)

#### Aluminium surfaces

**Corrosivity categories** C2, C3, C4, Im1, Im2, Im3  
Aluminium surfaces exposed water and splashing. E.g. bottoms of aluminium vessels.

**Zinc surfaces** (hot-dip galvanized)

**S9.09**  
Corrosivity categories/durability C2-H, C3-M  
Zinc surfaces, indoors and outdoors, exposed to mild stress.

**S9.11**  
Corrosivity categories/durability C4-H, C5-I-L, C5-M-M  
Zinc surfaces, indoors exposed to mechanical abrasion and outdoors in modest climate.

**Corrosivity categories** C2, C3, C4, Im1, Im2, Im3  
Zinc surfaces in underwater and underground applications.

### Tikkurila Coatings code

<table>
<thead>
<tr>
<th>Tikkurila Coatings code</th>
<th>Treatment</th>
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<tbody>
<tr>
<td>TE50</td>
<td>EP240/3-FeSa2½</td>
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<tr>
<td>TEMACOAT RM 40</td>
<td>3 x 80 µm</td>
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<td>DFT 240 µm</td>
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<td>TE50</td>
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<td>TEMACOAT RM 40</td>
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<td>TEMACOAT RM 40</td>
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<td>DFT 280 µm</td>
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<td>EP380/3-FeSa2½</td>
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<tr>
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<td>DFT 380 µm</td>
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</table>

**COLOURS**

The product is tintable with TEMASPEED colorants, thus ensuring the possibility to get shades from RAL-, BS-, NCS- and other colour cards.

**SUITABLE SHOP PRIMERS**

TEMABLAST EV 110, epoxy shop primer.
SD ZINC 1000 HA; zinc silicate
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. (ISO 12944)

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

Zinc surfaces:
Sweep blast-clean with mineral abrasives, e.g. quartz sand, to grade Sa5. (SFS 5873).
Damages in the zinc coating have to be repaired with TEMAZINC 99, a zinc rich epoxy paint. Before painting, clean the surfaces thoroughly (Sa2½/St3) and level off the edges around the cleaned areas.

Aluminium surfaces:
Sweep blast-clean with non-metallic abrasives to grade Sa5. (SFS 5873).

APPLICATION CONDITIONS

The surface must clean and dry and the surface temperature should remain at least 3 °C/5 °F above the dew point. During application and drying the temperature of the air, paint and surface should be a minimum of + 10 °C/50 °F. The relative humidity should not exceed 80%.

APPLICATION

The paint should be mixed thoroughly before application and then applied in an even coat on the dry and clean surface. Application with airless or conventional spray, brush or roller. Stripe coating of sharp edges, welding seams etc. should be done by brush or roller.

MAINTENANCE PAINTING

Maintenance
Touch-up painting is sufficient for maintenance when the rust grade is Ri1 - Ri3. (ISO 4628-3)
Damages caused by transport or installation may also be repaired by touch-up painting.
Remove all loose paint, clean rusty areas according to system demands. On steel surfaces small areas can be grinded or wire brushed to preparation grade St2 (SFS-ISO 8501-1).
Level off the edges between the old paint film and the cleaned up areas. When using blast cleaning, be sure that there are no cracks in the remaining paint film. If the entire surface has to be overcoated, abrade the old topcoat to a rough finish. Remove all dust and other cleaning residues. Apply primers and finish according to the original paint system, qualities and film thicknesses.

Repainting
When the rust grade is Ri4 or Ri5, the entire coating must be renewed. Remove the old paint film and clean the surfaces to preparation grade Sa 2½. Recoat in accordance with the original paint system.

PRODUCT INFORMATION

More detailed product information is available in respective data sheets.