TEMACOAT GS 50

DESCRIPTION
A two component, polyamide-cured high build epoxy finishing and intermediate coat.

PRODUCT FEATURES AND RECOMMENDED USES
♦ Used as a finishing or intermediate coat in epoxy and polyurethane systems exposed to abrasion and mechanical and/or chemical attack.
♦ Can also be applied direct to zinc and aluminium surfaces.
♦ Recommended as a sealer on hot dip galvanized surfaces when thinned 20 - 30 %.
♦ Rapidly recoatable and ready to handle.
♦ Recommended for haulage equipment, steel frameworks, conveyors, tubular bridges and other steel structures.

TECHNICAL DATA

Volume solids 57 ± 2 %. (ISO 3233)
Weight solids 71 ± 2 %.
Specific gravity 1.3 - 1.4 kg / l (mixed)
Mixing ratio and product codes Base 4 parts by volume 172-series.
Hardener 1 part by volume 008 5600 or 008 5605 (fast)
Pot life 6 hours (23 ºC / 74 ºF) with Hardener 008 5600
3 hours (23 ºC / 74 ºF) with Hardener 008 5605

<table>
<thead>
<tr>
<th>Recommended film thicknesses and theoretical coverage</th>
</tr>
</thead>
<tbody>
<tr>
<td>dry</td>
</tr>
<tr>
<td>60 µm</td>
</tr>
<tr>
<td>100 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 times

<table>
<thead>
<tr>
<th>DFT 70 µm</th>
<th>+ 5 ºC</th>
<th>+ 10 ºC</th>
<th>+ 23 ºC</th>
<th>+ 35 ºC</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dust dry, after</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>with Hardener 008 5600</td>
<td>3 h</td>
<td>1 h</td>
<td>½ h</td>
<td>15 min</td>
</tr>
<tr>
<td>with Hardener 008 5605</td>
<td>2 h</td>
<td>¾ h</td>
<td>½ h</td>
<td>12 min</td>
</tr>
<tr>
<td>Touch dry, after</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>with Hardener 008 5600</td>
<td>14 h</td>
<td>10 h</td>
<td>4½ h</td>
<td>2½ h</td>
</tr>
<tr>
<td>with Hardener 008 5605</td>
<td>8 h</td>
<td>6 h</td>
<td>3½ h</td>
<td>2 h</td>
</tr>
<tr>
<td>Recoatable, min., with epoxy paints</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>with Hardener 008 5600</td>
<td>24 h</td>
<td>6 h</td>
<td>2 h</td>
<td>1 h</td>
</tr>
<tr>
<td>with Hardener 008 5605</td>
<td>14 h</td>
<td>4 h</td>
<td>1½ h</td>
<td>¾ h</td>
</tr>
<tr>
<td>Recoatable, min., with polyurethane paints</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>with Hardener 008 5600</td>
<td>36 h</td>
<td>20 h</td>
<td>8 h</td>
<td>4 h</td>
</tr>
<tr>
<td>with Hardener 008 5605</td>
<td>24 h</td>
<td>12 h</td>
<td>6 h</td>
<td>3 h</td>
</tr>
</tbody>
</table>

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

Finish
Semigloss.

Colours
RAL, NCS, SSG, BS, MONICOLOR NOVA and SYMPHONY colour cards.
TEMASPEED tinting.
TEMACOAT GS 50

APPLICATION DETAILS

Surface preparation
- 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)
- 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 mist coat (paint thinned 25 - 30 % or with separate TEMACOAT SEALER before the actual priming).
- Aluminium surfaces: Sweep blast-clean with non-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
- TEMACOAT GPL-S PRIMER, TEMACOAT HB PRIMER, TEMACOAT HS PRIMER, TEMACOAT PM PRIMER, TEMACOAT GPL-S MIO, TEMACOAT SPA, TEMABOND and FONTECOAT EP PRIMER.

Finish
- TEMACOAT GPL, TEMACOAT GS 50, TEMADUR and TEMATHANE.

Application conditions
- All surfaces must be dry. The temperature of the ambient air, surface or paint should not fall below + 5 ºC / 41 ºF during application or drying. Relative humidity should not exceed 80 %. The surface temperature of the steel should remain at least 3 ºC / 38 ºF above the dew point.

Mixing components
- First stir base and hardener separately. The correct proportions of base and hardener must be mixed thoroughly before use. Use a mechanical agitator for mixing.

Application
- By airless or conventional spray or by brush. At airless spray application the paint should be thinned 5 - 25 % by volume. Airless spray nozzle tip 0.011" - 0.017"; nozzle pressure 120 - 160 bar, spray angle shall be chosen according to the shape of the object.
- At conventional spray the paint should be thinned 20 - 30 % to a viscosity of 20 - 30 s DIN4.
- At brush application the paint should be thinned according to the circumstances.

Thinner
- Thinner 1031.

Cleaning of equipment
- Thinner 1031.

VOC
- The Volatile Organic Compounds amount to 370 ± 20 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.