

TEMACOAT HB PRIMER

DESCRIPTION A two component, resin modified epoxy paint.

PRODUCT FEATURES AND RECOMMENDED USES

- ◆ Good adhesion to steel, zinc and aluminium surfaces.
- ◆ Used as a primer or an intermediate coat for steel, aluminium and zinc surfaces exposed to climatic conditions and mechanical and/or chemical attack.
- ◆ Recommended for building frameworks, tubular bridges, conveyors and other steelwork and equipment.

TECHNICAL DATA

Volume solids 63 ± 2 %. (ISO 3233)

Weight solids 75 ± 2 %.

Specific gravity 1.3 - 1.4 kg / l (mixed)

Mixing ratio and product codes

Base	4 parts by volume	164 4000, 4001
Hardener	1 part by volume	008 5600 or 008 5605 (fast)

Pot life 8 hours (23 °C / 74 °F) with Hardener 008 5600
4 hours (23 °C / 74 °F) with Hardener 008 5605

Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
80 µm	130 µm	7.9 m ² /l
150 µm	240 µm	4.2 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 100 µm		+ 10 °C	+ 23 °C	+ 35 °C
Dust dry, after	with Hardener 008 5600	4 h	2 h	1 h
	with Hardener 008 5605	2½ h	1½ h	¾ h
Touch dry, after	with Hardener 008 5600	10 h	4 h	2 h
	with Hardener 008 5605	6 h	3 h	1½ h
Recoatible, min.	with Hardener 008 5600	10 h	4 h	2 h
	with Hardener 008 5605	6 h	3 h	1½ h
Recoatible, min., surfaces to be submerged	with Hardener 008 5600	28 h	12 h	6 h
	with Hardener 008 5605	16 h	8 h	4 h
Recoatible, min., with polyurethane paints	with Hardener 008 5600	28 h	12 h	6 h
	with Hardener 008 5605	16 h	8 h	4 h

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

Finish Semimatt.

Colours Reddish brown (TVT 4000) and grey (TVT 4001).

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APPLICATION DETAILS

Surface preparation	<p>Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4)</p> <p><u>Steel surfaces:</u> Blast clean to grade Sa2½. (ISO 8501-1) If blast cleaning is not possible, phosphating is recommended for cold rolled steel to improve adhesion.</p> <p><u>Zinc surfaces:</u> 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.</p> <p>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).</p> <p><u>Aluminium surfaces:</u> 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.</p> <p><u>Primed surfaces:</u> 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)</p>
Primer	TEMACOAT HB PRIMER, TEMAZINC 77 and 99.
Finish	TEMACOAT HB 30, TEMACOAT GPL, TEMACOAT GS 50, TEMACOAT GPL-S MIO, TEMADUR and TEMATHANE.
Application conditions	All surfaces must be dry. The temperature of the ambient air, surface or paint should not fall below +10 °C / 50 °F during application and drying. Relative humidity should not exceed 80 %. The surface temperature of the steel should remain at least 3 °C / 38 °F 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 spray or brush. At spray application the paint should be thinned 0 - 10 % by volume. Airless spray nozzle tip 0.015" - 0.021"; nozzle pressure 120 - 180 bar, spray angle shall be chosen according to the shape of the object. 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 330 ± 20 g/litre of paint.
HEALTH AND SAFETY	<p>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.</p> <p>A health and safety data sheet is available on request from Tikkurila Coatings Oy.</p> <p>For professional use only.</p>