TEMACRYL EA 50

DESCRIPTION
A two component, semi-gloss, non-isocyanate, acrylic finish.

PRODUCT FEATURES AND RECOMMENDED USES
♦ Excellent weathering and abrasion resistance.
♦ A durable, non-chalking and easy to clean topcoat with good gloss and colour retention.
♦ Recommended as a semi-gloss topcoat for epoxy systems exposed to weathering and/or chemical attack.
♦ Recommended for storage tank exteriors, steel masts, haulage equipment, structural steel and other steelwork, machinery and equipment.

TECHNICAL DATA
Volume solids 50 ± 2 %. (ISO 3233)
Weight solids 62 ± 2 %.
Specific gravity 1.2 ± 0.1 kg / l (mixed)
Mixing ratio and product codes Base 3 parts by volume 515-series
Hardener 2 part by volume 008 7650
Pot life about 30 hours (23 ºC / 74 ºF)

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>40 µm</td>
<td>80 µm</td>
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<tr>
<td>60 µm</td>
<td>120 µm</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>Drying</th>
<th>+ 10 ºC</th>
<th>+ 23 ºC</th>
<th>+ 35 ºC</th>
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</thead>
<tbody>
<tr>
<td>DFT 40 µm</td>
<td></td>
<td></td>
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<tr>
<td>Dust dry</td>
<td>1 h</td>
<td>15 min</td>
<td>10 min</td>
</tr>
<tr>
<td>Touch dry</td>
<td>10 h</td>
<td>4 h</td>
<td>2 h</td>
</tr>
<tr>
<td>Recoatable</td>
<td>14 h</td>
<td>6 h</td>
<td>3 h</td>
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</tbody>
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Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation.

Finish
Semi-gloss.

Colours
RAL, NCS, SSG, BS, MONICOLOR NOVA and SYMPHONY colour cards. TEMASPEED tinting.
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APPLICATION DETAILS

Surface preparation: 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: TEMACOAT GPL-S PRIMER, GF PRIMER and HB PRIMER, TEMACOAT RM 40, TEMABOND, TEMASIL 90, TEMAPRIME EE and GF, FONTECRYL 10.

Finish: TEMACRYL EA.

Application conditions: All surfaces must be dry. The temperature of the ambient air, surface or paint should not fall below +5 °C / 41 °F during application or 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 or conventional spray. At airless spray application the paint can be thinned 10 - 25 % to a viscosity of 30 - 60 s DIN4. Airless spray nozzle tip 0.011" - 0.013", pressure 120 - 180 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. In order to reach a tight, even finish for spray application a "wet-on-wet" technique is recommended: first a thin coat and after the solvents have evaporated for 5 - 20 minutes the final coat.

Thinner: Thinner 1048.

Cleaning of equipment: Thinner 1048 or 1006.

VOC: The Volatile Organic Compounds amount to 480 ± 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.