TEMADUR 90

DESCRIPTION
A two component, glossy polyurethane paint, hardener aliphatic isocyanate.

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

TECHNICAL DATA

Volume solids  55 ± 2 %. (ISO 3233)
Weight solids  68 ± 2 %.
Specific gravity  1.2 ± 0.1 kg / l (mixed)
Mixing ratio and product codes
Base  5 parts by volume  115-series
Hardener  1 part by volume  008 7590
Pot life  4 hours (23 °C / 74 °F)

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>dry</td>
<td>40 µm</td>
</tr>
<tr>
<td>wet</td>
<td>75 µm</td>
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Theoretical coverage = 13.7 m²/l

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 time</th>
<th>+ 5 °C</th>
<th>+ 10 °C</th>
<th>+ 23 °C</th>
<th>+ 35 °C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dust dry</td>
<td>45 min</td>
<td>30 min</td>
<td>20 min</td>
<td>10 min</td>
</tr>
<tr>
<td>Touch dry</td>
<td>12 h</td>
<td>8 h</td>
<td>4 h</td>
<td>2½ h</td>
</tr>
<tr>
<td>Recoatable</td>
<td>No limitations.</td>
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</table>

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

Finish
Glossy.

Colours
RAL, NCS, SSG, BS, MONICOLOR NOVA and SYMPHONY colour cards. TEMASPEED tinting.
TEMADUR 90

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)

Primer
TEMACOAT GPL-S PRIMER, TEMACOAT GF PRIMER, TEMACOAT HB PRIMER, TEMACOAT HS PRIMER, TEMACOAT PM PRIMER, TEMACOAT GPL-S MIO, TEMACOAT RM 40, TEMACOAT SPA, TEMAMASTIC PM 100, TEMABOND, TEMADUR 20, TEMADUR PRIMER, TEMAPRIME GF, FONTECOAT EP PRIMER and FONTECRYL 10

Finish
TEMADUR and TEMATHANE.

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 or by brush. In order to obtain an even, non-porous finish, spray a misty coat: first a thin layer, then let the solvents evaporate for 5 - 30 minutes and then apply the full coat. Depending on the temperature of the components (base, hardener, thinner) the paint can be thinned 25 - 35 %. The viscosity should be 20 - 25 s DIN4. Airless spray nozzle tip 0.011" - 0.013"; nozzle pressure 120 - 160 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 1048 or 1067. Thinner 1061 (fast) is also suitable for conventional spraying.

Cleaning of equipment
Thinner 1048, 1067 or 1061.

VOC
The Volatile Organic Compounds amount to 420 ± 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.

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