TEMADUR PRIMER

DESCRIPTION
A two component matt polyurethane paint containing anti-corrosive pigments, hardener aliphatic isocyanate.

PRODUCT FEATURES AND RECOMMENDED USES
♦ Recommended as a primer for polyurethane systems exposed to weathering and/or chemical attack.
♦ Excellent weathering and abrasion resistance.
♦ Recommended for painting of haulage equipment, storage tank exteriors and other steelwork, machinery and equipment.

TECHNICAL DATA
Volume solids 50 ± 2 %. (ISO 3233)
Weight solids 67 ± 2 %.
Specific gravity 1.3 ± 0.1 kg / l (mixed)
Mixing ratio and product codes
| Base | 7 parts by volume | 007 1590-91 |
| Hardener | 1 part by volume | 008 7590 |
Pot life 4 hours (23 ºC / 74 ºF)

Recommended film thicknesses and theoretical coverage

<table>
<thead>
<tr>
<th>Recommended film thicknesses</th>
<th>Theoretical coverage</th>
</tr>
</thead>
<tbody>
<tr>
<td>dry</td>
<td>40 µm</td>
</tr>
<tr>
<td>100 µm</td>
<td>200 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 time
<table>
<thead>
<tr>
<th>DFT 50 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</td>
<td>30 min</td>
<td>30 min</td>
<td>15 min</td>
<td>10 min</td>
</tr>
<tr>
<td>Touch dry</td>
<td>6 h</td>
<td>5 h</td>
<td>3 h</td>
<td>1½ h</td>
</tr>
<tr>
<td>Recoatible, min.</td>
<td>4 h</td>
<td>2 h</td>
<td>30 min</td>
<td>20 min</td>
</tr>
</tbody>
</table>

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

Finish Matt.

Colours Grey, TVT 4004 and TVT 4007.
TEMADUR PRIMER

APPLICATION DETAILS

Surface preparation

Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4)

Steel surfaces: Blast clean to grade Sa2½. (ISO 8501-1) If blast cleaning is not possible, phosphating is recommended for cold rolled steel to improve adhesion.

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 misty coat (paint thinned 25 - 30 % or with separate TEMACOAT SEALER primer before the actual priming).

Aluminium surfaces: Sweep blast-clean with none-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.

Stainless steel: Roughen the surface by grinding or sweep blasting using mineral abrasives.

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

TEMADUR PRIMER.

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. Depending on the temperature of the components and the required viscosity the paint can be thinned 0 - 20 %. Mixing of the components and adjustment of the viscosity should be done right before use in order to reach an optimal result. Airless spray nozzle tip 0.011” - 0.015”; pressure 120 - 160 bar, spray angle shall be chosen according to the shape of the object. At conventional spray application the viscosity should be 20 - 25 s DIN4. At brush application the paint should be thinned according to the circumstances.

Thinner

Thinner 1048. Thinner 1061 is also suitable for conventional spraying.

Cleaning of equipment

Thinner 1048 or 1061.

VOC

The Volatile Organic Compounds amount to 430 ± 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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