

TEMALAC FD 50

DESCRIPTION

A fast drying, one component semigloss alkyd topcoat, containing anti-corrosive pigments.

PRODUCT FEATURES AND RECOMMENDED USES

- ◆ A semigloss topcoat to be used in alkyd systems for steel surfaces.
- ◆ Excellent gloss and colour retention when exposed to weathering.
- ◆ Ideal for use in machine shops with fast production cycles and in the field.
- ◆ Suitable also for electrostatic painting.
- ◆ Recommended for steel framework, service platforms and different types of machinery and equipment.
- ◆ Due to anti-corrosive pigments can also be used as a single coat system.

TECHNICAL DATA

Volume solids	47 ± 2 %. (ISO 3233)
Weight solids	64 ± 2 %.
Specific gravity	1.0 - 1.2 kg / l depending on colour
Product code	181-series

Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
40 µm	85 µm	11.8 m ² /l
60 µm	130 µm	7.7 m ² /l

Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated.

Drying times

DFT 40 µm	+ 10 °C	+ 23 °C	+ 35 °C
Dust dry, after	40 min	15 min	10 min
Touch dry, after	3 h	1½ h	1 h
Recoatible, after	12 d	6 d	4 d
Recoatible, "wet-on-wet", after	1 - 4 h	½ - 2 h	30 min

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.

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APPLICATION DETAILS

Surface preparation	Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4) <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. <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)
Primer	TEMAPRIME EE, TEMAPRIME EUR, TEMAPRIME GF, TEMAPRIME ML and FONTECRYL 10.
Finish	TEMALAC FD 50.
Application conditions	All surfaces must be dry. The temperature of the ambient air, surface or paint should not fall below + 5 °C during application or drying. Relative humidity should not exceed 80 %. The surface temperature of the steel should remain at least 3 °C above the dew point.
Application	By airless spray. Mix the paint thoroughly before use. At airless spray application the paint should be thinned 5 - 15 %. Airless spray nozzle tip 0.011" - 0.015" and nozzle pressure 120 - 180 bar. Spray angle shall be chosen according to the shape of the object.
Thinner	Thinner 1006. Large surfaces Thinner 1053 (slow).
Cleaning of equipment	Thinner 1006.
VOC	The Volatile Organic Compounds amount is 470 g/litre of paint. VOC content in ready to use paint (thinned 15 % by volume) is 522 g/l.
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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