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

<table>
<thead>
<tr>
<th>Recommended film thicknesses and theoretical coverage</th>
<th>Theoretical coverage</th>
</tr>
</thead>
<tbody>
<tr>
<td>dry</td>
<td>wet</td>
</tr>
<tr>
<td>40 µm</td>
<td>85 µm</td>
</tr>
<tr>
<td>60 µm</td>
<td>130 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 times

<table>
<thead>
<tr>
<th>DFT 40 µm</th>
<th>+ 10 ºC</th>
<th>+ 23 ºC</th>
<th>+ 35 ºC</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dust dry, after</td>
<td>40 min</td>
<td>15 min</td>
<td>10 min</td>
</tr>
<tr>
<td>Touch dry, after</td>
<td>3 h</td>
<td>1½ h</td>
<td>1 h</td>
</tr>
<tr>
<td>Recoatable, after</td>
<td>12 d</td>
<td>6 d</td>
<td>4 d</td>
</tr>
<tr>
<td>Recoatable, &quot;wet-on-wet&quot;, after</td>
<td>1 - 4 h</td>
<td>½ - 2 h</td>
<td>30 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
Semigloss.

Colours
RAL, NCS, SSG, BS, MONICOLOR NOVA and SYMPHONY colour cards. TEMASPEED tinting.
TEMALAC FD 50

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.

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  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 ºC during application or drying. Relative humidity should not exceed 80 %. The surface temperature of the steel should remain at least 3 ºC 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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