TEMALAC FD 80

DESCRIPTION
A fast drying, one component glossy alkyd topcoat.

PRODUCT FEATURES AND RECOMMENDED USES
♦ A glossy, alkyd based topcoat 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 uses: steel structures, service platforms and different types of machinery and equipment.

TECHNICAL DATA

Volume solids
45 ± 2 %. (ISO 3233)

Weight solids
62 ± 2 %.

Specific gravity
1.0 - 1.2 kg / l depending on colour.

Product code
180-series

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>wet</td>
</tr>
<tr>
<td>40 µm</td>
<td>90 µm</td>
</tr>
<tr>
<td></td>
<td>11.2 m²/l</td>
</tr>
<tr>
<td>60 µm</td>
<td>135 µm</td>
</tr>
<tr>
<td></td>
<td>7.5 m²/l</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 40 µm</th>
<th>+ 10 °C</th>
<th>+ 23 °C</th>
<th>+ 35 °C</th>
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</thead>
<tbody>
<tr>
<td>Dust dry</td>
<td>40 min</td>
<td>15 min</td>
<td>10 min</td>
</tr>
<tr>
<td>Touch dry</td>
<td>3 h</td>
<td>1½ h</td>
<td>1 h</td>
</tr>
<tr>
<td>Recoatable</td>
<td>12 d</td>
<td>6 d</td>
<td>4 d</td>
</tr>
<tr>
<td>Recoatable, &quot;wet-on-wet&quot;</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
Glossy.

Colours
RAL, NCS, SSG, BS, MONICOLOR NOVA and SYMPHONY colour cards.
TEMASPEED tinting.
TEMALAC FD 80

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
TEMAPRIME EE, EUR, GF and ML, FONTECRYL 10.

Finish
TEMALAC FD 80.

Application conditions
All surfaces must be dry. The temperature of the ambient air, surface and paint should not fall below + 5 °C / 41 °F during application and drying. Relative humidity should not exceed 80 %. The temperature of the substrate should remain at least 3 °C / 38 °F above the dew point.

Application
Airless or conventional spray. Mix the paint thoroughly before use. At airless spray the paint should be thinned 15 - 20 % to a viscosity of 30 - 40 s DIN 4. Airless spray nozzle tip 0.011" - 0.015", nozzle pressure 120 - 160 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 - 25 s DIN 4. At spray application a "wet-on-wet" technique is recommended.

Thinner
Thinner 1006. Large surfaces Thinner 1053 (slow).

Cleaning of equipment
Thinner 1006.

VOC
The Volatile Organic Compounds amount to 470 ± 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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