TEMALAC ML 90

DESCRIPTION
A high gloss, one component alkyd topcoat.

PRODUCT FEATURES AND RECOMMENDED USES
♦ High gloss alkyd topcoat for steel surfaces.
♦ Good gloss and colour retention when exposed to weathering.
♦ Can be applied using a "wet-on-wet" painting technique.
♦ Suitable for industrial finishing.
♦ Recommended uses: small tanks, agricultural machinery, haulage equipment and other machinery and equipment.

TECHNICAL DATA

Volume solids 45 ± 2 %. (ISO 3233)
Weight solids 57 ± 2 %.
Specific gravity 0.9 - 1.1 kg / l depending on colour.
Product code 513-series

<table>
<thead>
<tr>
<th>Recommended film thicknesses and theoretical coverage</th>
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</thead>
<tbody>
<tr>
<td>dry</td>
</tr>
<tr>
<td>40 µm</td>
</tr>
<tr>
<td>60 µm</td>
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</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, after</td>
<td>2 h</td>
<td>1 h</td>
<td>½ h</td>
</tr>
<tr>
<td>Touch dry, after</td>
<td>8 h</td>
<td>5 h</td>
<td>3 h</td>
</tr>
<tr>
<td>Recoatable, after</td>
<td>36 h</td>
<td>24 h</td>
<td>16 h</td>
</tr>
<tr>
<td>Recoatable, &quot;wet-on-wet&quot;, after</td>
<td>½ - 1 h</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Touch dry 1 h / 60 °C, ½ h / 80 °C</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
High gloss.

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

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

Finish

TEMALAC ML 90.

Application conditions

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

Application

By airless or conventional spray or by brush. Mix the paint thoroughly before use. At airless spray the paint should be thinned 0 - 10 % to a viscosity of 30 - 60 s DIN 4. Airless spray nozzle tip 0.011” - 0.015” and nozzle pressure 140 - 180 bar. Spray angle shall be chosen according to the shape of the object. At conventional spray the paint should be thinned 20 - 30 %. The best finish is obtained using a "wet-on-wet" technique, with 5 - 30 minutes evaporating pauses.

Thinner

At spray application Thinner 1006. At brush application Thinner 1054.

Cleaning of equipment

Thinner 1006 or Thinner 1054.

VOC

The Volatile Organic Compounds amount is 460 g/litre of paint. VOC content of the paint (thinned 30 % by volume) is 550 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.