TEMALINE FW

DESCRIPTION
A two component, solvent free epoxy coating.

PRODUCT FEATURES AND RECOMMENDED USES
♦ Suitable for steel and concrete surfaces in immersion, also for walls etc. in the food industry. When fully cured the coat is tasteless and odourless.
♦ Can be applied by standard airless spray equipment.
♦ Recommended for interior surfaces of potable water tanks, grain and other foodstuff containers, as well as dairy, bakery, slaughterhouse and other installations in the food industry.
♦ Withstands +150 ºC / 300 ºF dry heat and + 60 ºC / 140 ºF in immersion.
♦ More detailed information on chemical resistance available on a separate table.
♦ VTT (Technical Research Centre of Finland) approval certificate No. ELI 1188/93 is available. (When tested the name was Reapox FW)

TECHNICAL DATA

| Volume solids | about 100 %. (ISO 3233) |
| Weight solids | about 100 %. |
| Specific gravity | 1.4 kg / l (mixed) |
| Mixing ratio and product codes | Base 3 parts by volume 008 7085  
Hardener 1 part by volume 008 7089 |
| Pot life | 40 min (23 ºC / 74 ºF) |

<table>
<thead>
<tr>
<th>Recommended film thicknesses and theoretical coverage</th>
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<tbody>
<tr>
<td>Recommended film thicknesses</td>
</tr>
<tr>
<td>dry</td>
</tr>
<tr>
<td>200 µm</td>
</tr>
<tr>
<td>300 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 250 µm</th>
<th>+ 10 ºC</th>
<th>+ 23 ºC</th>
<th>+ 35 ºC</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dust dry</td>
<td>6 h</td>
<td>2 - 3 h</td>
<td>1½ h</td>
</tr>
<tr>
<td>Touch dry</td>
<td>20 h</td>
<td>12 h</td>
<td>6 h</td>
</tr>
<tr>
<td>Recoatable without sanding</td>
<td>8 - 72 h</td>
<td>4 - 48 h</td>
<td>2 - 24 h</td>
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Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation.

Finish
Glossy.

Colours
White.
TEMALINE FW

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)

Concrete surfaces: The surface must be dry and at least 4 weeks old. The relative humidity of the concrete should not exceed 97%. Remove any splashes and unevennesses by grinding. Remove laitance and form oil from concrete castings by sanding or blast cleaning. Any cracks, crevices or voids must be repaired with a mixture of TEMALINE FW and fine dry quartz sand.

Primer

Steel surfaces: TEMALINE FW
Concrete surfaces: Impregnation with 30 % thinned TEMALINE FW

Finish

Steel surfaces: TEMALINE FW
Concrete surfaces: 1 - 2 x TEMALINE FW

Application conditions

All surfaces must be dry. The temperature of the ambient air, surface or paint should not fall below +15 ºC / 59 ºF during application and drying. Relative humidity should not exceed 80 %. The surface temperature of the steel should remain at least 3 ºC / 38 ºF above the dew point.

Mixing components

First mix the base and a necessary amount of thinner using mechanical stirring. Then add the pre-mixed hardener. The correct proportions of base and hardener must be mixed thoroughly before use. Use a mechanical agitator for mixing.

Application

By airless spray or brush. Airless spray nozzle tip 0.018" - 0.023"; spray angle shall be chosen according to the shape of the object. It is recommendable to use a reverse nozzle.

Sharp edges, corners, weld seams and other areas difficult to paint should be painted by brush prior to spray application.

For patching small areas, the coating can be thinned abt. 5 %.

Note! Pot life of the mixture is about 40 min. at + 23 ºC / 74 ºF and about 5 min. at + 35 ºC / 95 ºF. Avoid to let the mixture cure in hoses, pump or spray gun.

Thinner

Thinner 1031. When coating food industry subjects, Thinner 1029 should be used.

Cleaning of equipment

Thinner 1031 or 1029.

VOC

Does not contain Volatile Organic Compounds.

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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