TEMALINE LP PRIMER

DESCRIPTION
A two component, amine adduct cured epoxy paint.

PRODUCT FEATURES AND RECOMMENDED USES
♦ Resistant to splashes and immersion in water and chemicals.
♦ Used as a primer and an intermediate coat for inside epoxy systems to kerosene and oil tanks.
   Warning! Not recommended for leadfree petrol tanks.
♦ Withstands aliphatic hydrocarbons, alkaline solutions and mild acids.
♦ Withstands immersion in neutral mineral solutions, vegetable and animal fats and oils.
♦ May also be used as a primer in other epoxy paint systems.

TECHNICAL DATA

Volume solids 60 ± 2 %. (ISO 3233)
Weight solids 70 ± 2 %.
Specific gravity 1.4 kg / l (mixed)
Mixing ratio and product codes
   Base 4 parts by volume 008 6965-6
   Hardener 1 part by volume 008 6969
Pot life 8 hours (23 ºC / 74 ºF)

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>70 µm</td>
<td>120 µm</td>
</tr>
<tr>
<td>125 µm</td>
<td>210 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 100 µm</th>
<th>+ 10 ºC</th>
<th>+ 23 ºC</th>
<th>+ 35 ºC</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dust dry</td>
<td>8 h</td>
<td>4 h</td>
<td>2 h</td>
</tr>
<tr>
<td>Touch dry</td>
<td>12 h</td>
<td>6 h</td>
<td>3 h</td>
</tr>
<tr>
<td>Recoatable without sanding, min/max</td>
<td>32 h - 12 d</td>
<td>16 h - 6 d</td>
<td>8 h - 2 d</td>
</tr>
<tr>
<td>Fully cured</td>
<td>14 d</td>
<td>7 d</td>
<td>3 d</td>
</tr>
</tbody>
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Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation.

Finish
Semigloss.

Colours
Light grey and reddish brown.
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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)

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: TEMALINE LP PRIMER.

Finish: TEMALINE LP PRIMER, LP 60 and TEMACOAT GPL.

Application conditions: All surfaces must be dry. The temperature of the ambient air, surface or paint should not fall below +10 °C / 50 °F during application and drying. Relative humidity should not exceed 80 %. The surface temperature of the steel should remain at least 3 °C / 38 °F above the dew point.

Mixing components: First stir base and hardener separately. 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. If necessary, the paint can be thinned 5 - 20 %. Airless spray nozzle tip 0.015" - 0.021"; choose the spray angle according to the shape of the object.

Thinner: Thinner 1031.

Cleaning of equipment: Thinner 1031.

VOC: The Volatile Organic Compounds amount to 450 ± 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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