

# Fontecoat EP 50 Beige

## DESCRIPTION

A two-component water-borne epoxy primer.

## PRODUCT FEATURES AND RECOMMENDED USES

- An epoxy primer for steel in highly corrosive environments. Due to its good adhesion to the substrate and the subsequent coat, the primer ensures high mechanical and chemical resistance of the paint system
- Used as an intermediate coat in the NORSOK approved paint system. The approval indicates the paint system's ability to function in off-shore environments
- Can also be recoated with solvent-borne topcoats. The paint can be used in hybrid systems to replace solvent-borne primer and/or intermediate coating
- Used as a primer or an intermediate coat in epoxy / polyurethane systems
- Can also be used as a topcoat or as a single coat paint in epoxy paint systems for steel surfaces
- Resistant to diesel and biodiesel (RME) fuel
- Recommended for framework, service platforms, conveyors and other steelwork, machinery and equipment

## TECHNICAL DATA

**Volume solids** 47±2% (ISO 3233)

**Weight solids** 62±2%

**Specific gravity** 1.4 kg / l (mixed)

**Mixing ratio** Base 1 part by volume Fontecoat EP 50 Beige  
Hardener 1 part by volume 007 1019

**Pot life (+23°C)** 1½ h

## Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
wet	dry	
130µm	60µm	7.7 m²/l
210µm	100µm	4.8 m²/l
300µm	140µm	3.3 m²/l

Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated.

## Drying time

DFT 100 µm	+ 15 °C	+ 23 °C	+ 35 °C
Dust dry, after	4 h	2 h	1 h
Touch dry, after	8 h	5 h	2 h
Recoat by itself, min. after	16 h	6 h	4 h
Fully cured, after	14 d	7 d	3 d

Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation

**Gloss** Semi-gloss.

**Color shades** Beige

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## APPLICATION INSTRUCTIONS

<b>Surface preparation</b>	<p>Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4)</p> <p>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.</p> <p>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)</p>
<b>Recommended primers</b>	Fontecryl AP, Fontecryl PP, Fontezinc 85, Fontecoat EP 50, Temazinc 77, Temazinc 88, Temazinc 99, Temakeep, Temacoat GPL-S Primer.
<b>Recommended topcoats</b>	Fontecoat EP 50, Fontedur HB 80, Temasolid SC 60, Temadur 50, Temacryl EA 50.
<b>Application conditions</b>	<p>All surfaces must be clean, dry and free from contamination. The temperature of the ambient air, surface and paint should not fall below +15°C during application and drying. If the ambient relative humidity is 70% or higher, appropriate measures must be taken to reduce the relative humidity in the drying stage (forced drying or dehumidifier). The surface temperature of steel should remain at least 3°C above the dew point. Good ventilation and sufficient air movement is required in confined areas during application and drying.</p> <p>Note! There is a natural tendency of this coating to chalk, discolor or yellow unevenly. It is recommended to use polyurethane topcoat when there are high aesthetical requirements on color appearance.</p>
<b>Mixing components</b>	First stir base and hardener separately. The correct proportions of base and hardener must be mixed thoroughly before use. Use power mixer for mixing. Insufficient mixing or incorrect mixing ratio will result in uneven drying of the surface and weaken the properties of the coating.
<b>Application</b>	<p>For airless spraying, the product is thinned approximately 0–10%. Recommended nozzle tip is 0.013"–0.023" and pressure 140–200 bar. Spray angle shall be chosen according to the shape of the object.</p> <p>For brush application product should be thinned according to the circumstances.</p> <p>For large flat surfaces, and for nozzle tip above 0,015", 40° or higher spray angle is recommended. Forced drying must be used when nominal dry film thickness (NDFT) is above 140 µm. Forced drying can be used up to 450 µm wet film thickness. 200 µm dry film thickness should not be exceeded.</p> <p>For aluminium and zinc substrates and when applied on zinc rich primer it is recommendable to apply a mist coat: first a thin layer, then let the water evaporate for 5–10 minutes and then apply the full coat.</p>
<b>Thinners</b>	Water

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### Cleaning of equipment

Clean the spraying equipment immediately after use as follows:

1. Run the equipment with water to remove excess paint from the equipment.
2. Run the equipment with a mixture of approx 20% Thinner 1109 in clean water, at least two times.
3. Finally wash with undiluted Thinner 1109.

Wash the equipment with water before starting to paint again. Unwashed equipment can cause serious surface defects.

Contact Tikkurila Technical Service for detailed instructions for cleaning 2-component application equipment.

### VOC

The Volatile Organic Compounds amount is 55 g/litre of paint mixture.

VOC content of paint mixture (thinned by 10 % by volume) 50 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 Oyj.

### For industrial and professional use only.

The above information is not intended to be exhaustive or complete. The information is based on laboratory tests and practical experience, and it is given to the best of our knowledge. The quality of the product is ensured by our operational system, based on the requirements of ISO 9001 and ISO 14001. As manufacturer we cannot control the conditions under which the product is being used or the many factors that have an effect on the use and application of the product. We disclaim liability for any damages caused by using the product against our instructions or for inappropriate purposes. We reserve the right to change the given information unilaterally without notice.

The product is intended for professional use only and shall only be used by professionals who have sufficient knowledge and expertise on the proper use of the product. The information above is advisory only. To the extent permitted by applicable law, we shall not approve of any liability for the conditions under which the product is being used or for the use or application of the product.

In case you intend to use the product for any other purpose than that recommended in this document without first getting our written confirmation on the suitability for the intended use, such use takes place at your own risk.