Fontecoat EP 50

DESCRIPTION
A two-component water-borne epoxy topcoat and a single-coat paint.

PRODUCT FEATURES AND RECOMMENDED USES
• A semi-gloss epoxy paint to be used as a single-coat paint, primer, intermediate coat or topcoat in epoxy or polyurethane systems for steel surfaces. It dries rapidly and can be applied in thick layers
• An ideal option when a low VOC content is required. The paint has very good resistance against mechanical and chemical stress. The product provides protection comparable to that of solvent-borne epoxy paints
• Can be primed with the solvent-borne adhesion primer Temakeep. The system has extremely good adhesion and surface tolerance. At the same time, it is possible to achieve a very rapid production cycle
• Fast curing and environmentally friendly (low VOC)
• Resistant to diesel and biodiesel (RME) fuel
• The product has MED (Marine Equipment Directive) certificate no VTT-C-12360-15-18 and is thus accepted for painting surfaces inside the ships
• 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
Hardener 1 part by volume 007 1019

Pot life (+23°C) 1½ h

Recommended film thicknesses and theoretical coverage

<table>
<thead>
<tr>
<th>Recommended film thicknesses</th>
<th>Theoretical coverage</th>
</tr>
</thead>
<tbody>
<tr>
<td>wet</td>
<td>dry</td>
</tr>
<tr>
<td>130µm</td>
<td>60µm</td>
</tr>
<tr>
<td>215µm</td>
<td>100µm</td>
</tr>
<tr>
<td>225µm</td>
<td>120µm</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 100µm</th>
<th>+15°C</th>
<th>+23°C</th>
<th>+35°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dust dry, after</td>
<td>4h</td>
<td>2h</td>
<td>1h</td>
</tr>
<tr>
<td>Touch dry, after</td>
<td>8h</td>
<td>5h</td>
<td>2h</td>
</tr>
<tr>
<td>Recoatable by itself, min. after</td>
<td>16h</td>
<td>6h</td>
<td>4h</td>
</tr>
<tr>
<td>Recoatable without roughing, max. after</td>
<td>7d</td>
<td>5d</td>
<td>2d</td>
</tr>
<tr>
<td>Fully cured, after</td>
<td>14d</td>
<td>7d</td>
<td>3d</td>
</tr>
</tbody>
</table>

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

Gloss Semi-gloss.
Fontecot EP 50

Color shades

RAL, NCS, SSG, BS, MONICOLOR NOVA and SYMPHONY colour cards. Temaspeed Fonte tinting.
Fontecoat EP 50

APPLICATION INSTRUCTIONS

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) If blast cleaning is not possible, phosphating is recommended for cold rolled steel to improve adhesion.

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)

Recommended primers

(overcoating on touch dry surface)

Recommended topcoats

Application conditions
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. Relative humidity of the air should not exceed 70% during application and drying. 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. Tinting, mixing ratio, thinning, film thickness and drying conditions can affect the gloss.

Mixing components
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.

Application
For airless spraying, the product is thinned approximately 0–10%. Recommended nozzle tip is 0.011”–0.023” and pressure 140–200 bar. Spray angle shall be chosen according to the shape of the object. DFT 160μm should not be exceeded.

For conventional spraying, the product is thinned approximately 5–10%. Recommended nozzle tip is 1.8–2.0 mm and pressure 3–4 bar.

For brush application the product should be thinned according to the circumstances.

Thinners
Water

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 60g/litre of paint mixture.

VOC content of paint mixture (thinned by 10% by volume) 55g/l.
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.