

# Fontezinc 85

## DESCRIPTION

A two-component, water-borne zinc-rich epoxy paint.

## PRODUCT FEATURES AND RECOMMENDED USES

- More environmentally friendly option for bridges, cranes and steel framework as well as steelwork and equipment in the forest and chemical industries
- Designed for use as a primer in water-borne epoxy, polyurethane and acrylic systems for steel surfaces exposed to severe climatic conditions up to corrosivity class C5
- Offers cathodic protection of steel
- Used as a primer in epoxy, polyurethane and acrylic systems for steel surfaces exposed to severe climatic conditions
- Can be used without a topcoat on surfaces exposed to weathering
- Recommended for bridges, cranes and steel frameworks as well as steelwork and equipment in the forest and chemical industries; such as tubular bridges, conveyors etc

## TECHNICAL DATA

### Volume solids

44±2% (thinned 40 volume-%)

### Specific gravity

2.4 kg/l (mixed and thinned 40%)

### Mixing ratio

Base	4.3 parts by volume	Fontezinc 85
Hardener	1.0 part by volume	930 2760
Water	2.0 part by volume	(see overleaf: "Application")

### Pot life (+23°C)

4 hours

### Recommended film thicknesses and theoretical coverage

Recommended film thicknesses*		Theoretical coverage*
wet	dry	
85µm	40µm	11.6 m²/l
170µm	80µm	5.8 m²/l
*Thinned 25 volume-%		

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

### Drying time

DFT 40µm	+10°C	+23°C	+35°C
Dust dry, after	1h	½h	20min
Touch dry, after	2h	1h	½h
Recoat with waterborne paints, after	5h	2h	1h
Recoat with solventborne paints, after	48h	24h	12h

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

### Gloss

Matt.

### Color shades

Reddish grey.

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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) In order to get the best performance the surface profile should be medium grit. (ISO 8503-2)</p>
<b>Recommended topcoats</b>	<p>Fontedur HB 80, Fontecoat EP 50, Temacoat GPL-S Primer, Temacoat GPL-S MIO, Temacoat RM 40, Temanyl MS Primer.</p>
<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 +10°C during application and drying. Relative humidity of the air should not exceed 80% 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.</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>	<p>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.</p>
<b>Application</b>	<p>Agitate during application.</p> <p>For airless spraying, the product is thinned approximately 20–50%. Recommended nozzle tip is 0.013"–0.019" and pressure 160–200 bar. Spray angle shall be chosen according to the shape of the object.</p> <p>Sharp edges, corners, weld seams and other areas difficult to cover properly by spray application should be coated by brush before the spray application.</p> <p>For brush application product should be thinned according to the circumstances.</p>
<b>Thinners</b>	<p>Water</p>
<b>Cleaning of equipment</b>	<p>Clean the spraying equipment immediately after use as follows:</p> <ol style="list-style-type: none"><li>1. Run the equipment with water to remove excess paint from the equipment.</li><li>2. Run the equipment with a mixture of approx 20% Thinner 1109 in clean water, at least two times.</li><li>3. Finally wash with undiluted Thinner 1109.</li></ol> <p>Wash the equipment with water before starting to paint again. Unwashed equipment can cause serious surface defects.</p> <p>Contact Tikkurila Technical Service for detailed instructions for cleaning 2-component application equipment.</p>
<b>VOC</b>	<p>The Volatile Organic Compounds amount to 180 g/litre of paint mix thinned 40% by volume.</p>
<b>HEALTH AND SAFETY</b>	<p>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.</p> <p>A health and safety data sheet is available on request from Tikkurila Oyj.</p>

**For industrial use only.**



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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.