



# Fontecryl 25

## DESCRIPTION

A water-borne, one-component fast drying acrylic based paint with active anticorrosive pigments.

## PRODUCT FEATURES AND RECOMMENDED USES

- Due to its good anti-corrosive properties, Fontecryl 25 can be used as a single-coat product on various substrates, such as steel, zinc and aluminium.
- Dries fast and is, therefore, quickly ready for overcoating.
- Drying times can be shortened by using higher temperatures. The property increases the efficiency of the application process.
- Not suitable for immersion or constant humidity.
- Suitable for product painting in metal industry and painting stations.
- Typical uses are e.g. steel frameworks, machinery and equipment.

## TECHNICAL DATA

**Volume solids** 42±2%. (ISO 3233)

**Weight solids** 53±2%.

**Specific gravity** 1.2±0.1 kg / l

### Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
wet	dry	
100µm	40µm	10.5 m <sup>2</sup> /l
145µm	60µm	7.0 m <sup>2</sup> /l

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

### Drying time

DFT 50µm	+15°C	+23°C	+35°C
Dust dry, after	20min	15min	5min
Touch dry, after	6h	1h	15min
Recoatable, after	20h	2h	1h

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

### Gloss

Semi-matt.

### Color shades

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

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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>Zinc surfaces: Sweep blast clean with mineral abrasives, e.g. quartz sand, to an even roughness. (SaS, SFS 5873) If sweep blasting is not possible, the surface should be roughened by hand abrading or washed with Panssaripesu detergent. For hot dip galvanized surfaces see separate application instructions or contact Tikkurila Technical Service.</p> <p>Aluminium surfaces: Sweep blast clean with none-metallic abrasives to an even roughness. (SaS, SFS 5873) If sweep blasting is not possible, the surface should be roughened by hand abrading or washed with Maalipesu detergent.</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 25, Temaprime AB, Temaprime EE.
<b>Recommended topcoats</b>	Fontecryl 25, Fontelac QD 80.
<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. Relative humidity of the air should be between 20–70%. 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>
<b>Application</b>	<p>Stir the product carefully before use.</p> <p>For airless spraying, the product is thinned approximately 0–5%. Recommended nozzle tip is 0.011"–0.015" and pressure 120–160 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>
<b>Thinners</b>	Water
<b>Cleaning of equipment</b>	<p>Water</p> <p>The equipment must be cleaned immediately after use before the paint dries.</p>
<b>VOC</b>	<p>The Volatile Organic Compounds amount is 70g/litre of paint. VOC content in paint (thinned 5% by volume) is 65g/l.</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> <p><b>For industrial and professional use only.</b></p>



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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.