



# Fontecryl AP

## DESCRIPTION

A water-borne, one-component fast-drying acrylic based primer for various surfaces containing active anticorrosive pigments.

## PRODUCT FEATURES AND RECOMMENDED USES

- Provides excellent adhesion and is used as an anti-corrosive primer on steel, aluminium and zinc surfaces.
- Due to its good wetting and levelling properties, Fontecryl AP is also suitable for dipping applications.
- Can be overcoated both with water and solvent-borne topcoats.
- Wide range of colors available.
- Drying times can be shortened by using higher temperatures.
- Recommended to be used in process industry and agriculture and earth moving equipment.

## TECHNICAL DATA

**Volume solids** 33±2% (ISO 3233)

**Weight solids** 45±2%

**Specific gravity** 1.2±0.1 kg / l

### Recommended film thicknesses and theoretical coverage

| Recommended film thicknesses                               |      | Theoretical coverage   |
|--|------|------------------------|
| wet  | dry  |                        |
| 125µm  | 40µm | 8.3 m <sup>2</sup> /l  |
| Recommended film thicknesses with Duasolid 50 as a topcoat |      | Theoretical coverage   |
| wet  | dry  |                        |
| 60µm   | 20µm | 16.5 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.

Note! The painting work should be performed and supervised according to 12944-7 if not otherwise stated in the respective technical data sheet. Excessive film thickness may result e.g. in cracking, sagging, prolonged drying time, soft film, less chemical resistance, gloss deviation, adhesion and intercoat functionality. In case the product is used otherwise than stated in the standard a written approval from Tikkurila is required.

### Drying time

| DFT 40µm                | +15°C | +23°C | +35°C |
|-------------------------|-------|-------|-------|
| Dust dry, after         | 2h    | 30min | 5min  |
| Touch dry, after        | 2½h   | 1h    | 15min |
| Recoatible, min., after | 24h   | 1–2 h | 30min |

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

Water-borne paints and coatings are sensitive to moisture and cold before they are completely dry. Painted surfaces must be stored indoors at a temperature of min. +20°C for at least 40 hours before exposed to weather conditions. Forced drying may shorten the time before exposing the painted objects to outdoors. Please consult Tikkurila Technical Service for more information.



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**Gloss**

Matt.

**Color shades**

Black, red, TVT 4004 and RAL 7046. RAL, NCS, SSG, BS, MONICOLOR NOVA and SYMPHONY colours made from FCL base paint. 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 non-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> |
| <b>Recommended primers</b>    | Fontecryl AP.  |
| <b>Recommended topcoats</b>   | Duasolid 50, Temadur SC-F 20, Temadur SC-F 50, Temadur SC-F 80, Fontedur HB 80, 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>For spraying, the product is thinned approximately 0–15%. 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 dip coating, the product is thinned 7–15% to the viscosity 20–25s (DIN4).</p> <p>For brush application the product should be thinned according to the circumstances.</p> <p>Mix the product properly in case of sedimentation or viscosity increase.</p> <p>Note! The viscosity falls quickly when thinning the paint.</p>   |
| <b>Thinners</b>               | Water  |
| <b>Cleaning of equipment</b>  | <p>Thinner 1109</p> <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 Thinner 1109, at least two times.</li></ol> <p>Wash the equipment with water before starting to paint again. Unwashed equipment can cause serious surface defects.</p>  |
| <b>VOC</b>                    | <p>The Volatile Organic Compounds amount is 125±10 g/litre of paint depending on the color. VOC content in paint (thinned 15% by volume) is 110±10 g/l depending on the color. VOC 2004/42/EC (cat A/i) 140 g/l (2010)</p>   |



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## 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.