

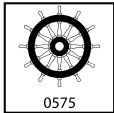
Temacoat GPL-S Primer

DESCRIPTION

A two-component, polyamide-cured high build epoxy primer containing zinc phosphate.

PRODUCT FEATURES AND RECOMMENDED USES

- Rapidly recoatable Temacoat GPL-S Primer is used as a primer or an intermediate coat in paint systems exposed to abrasion and chemical stress. The paint adheres extremely well to steel, zinc and aluminium surfaces making it a universal, all-round primer for various applications.
- The product has MED (Marine Equipment Directive) certificate no EUFI29-19002494-MED and is thus accepted for painting surfaces inside the ships.
- The primer can be tinted to various of colors, which helps achieve the best possible hiding power for the topcoat.
- Can be used as an intermediate coat on zinc-rich epoxy and zinc silicate paints.
- Rapidly recoatable.
- Resistant to grey/waste water when applied 2x125µm.
- Approved by Deutsche Bahn AG according to TL 918300, Sheet 3, as a solvent-borne epoxy primer in trains.
- Recommended for bridges, haulage equipment, cranes, steel masts, conveyors and other steelwork, machinery and equipment.



TECHNICAL DATA

Volume solids 55±2% (mixture, ISO 3233)

Weight solids 68±2% (mixture)

Specific gravity 1.3–1.4 kg / l (mixture)

Mixing ratio Base 4 parts by volume Temacoat GPL-S Primer
Hardener 1 part by volume 008 5600, 008 5602* or 008 5605 (fast)

*sold only in China

Pot life 4 hours (+23°C) with Hardener 008 5600 or 008 5602
2 hours (+23°C) with Hardener 008 5605

Recommended film thicknesses and theoretical coverage

| Recommended film thicknesses | | Theoretical coverage |
|------------------------------|-------|----------------------|
| wet | dry | |
| 110µm | 60µm | 9.0 m²/l |
| 185µm | 100µm | 5.5 m²/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.

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Drying time

| Hardener 008 5600, 008 5602 or 008 5605 | | | | | | |
|---|------------------------------------|-----|------|-------|-------|-------|
| DFT 60 µm | | 0°C | +5°C | +10°C | +23°C | +35°C |
| Dust dry, after | with Hardener 008 5600 or 008 5602 | 4h | 2h | 1h | ½h | 15min |
| | with Hardener 008 5605 | 3h | 1½h | 45min | ½h | 12min |
| Touch dry, after | with Hardener 008 5600 or 008 5602 | 16h | 8h | 4h | 2½h | 1h |
| | with Hardener 008 5605 | 12h | 6h | 3h | 1½h | ½h |
| Recoatable with epoxy paints, min. after | with Hardener 008 5600 or 008 5602 | 16h | 6h | 4h | 2h | 45min |
| | with Hardener 008 5605 | 12h | 5h | 3h | 1½h | ½h |
| Recoatable with polyurethane paints, min. after | with Hardener 008 5600 or 008 5602 | 24h | 8h | 5h | 2h | 1h |
| | with Hardener 008 5605 | 16h | 6h | 4h | 1½h | 45min |
| Recoatable without roughening max. 6 months | | | | | | |

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

Gloss

Matt.

Color shades

Temaspeed Primers colour card. Temaspeed Premium tinting.

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APPLICATION INSTRUCTIONS

| | |
|-------------------------------|---|
| Surface preparation | <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> <p>Stainless steel: Roughen the surface by grinding or sweep blasting using non-metallic abrasives.</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> |
| Recommended primers | Temacoat GPL-S Primer, Temabond ST 200, Temabond ST 300, Temazinc 77, Temazinc 99, Temasil 90. |
| Recommended topcoats | Temacoat GPL, Temacoat GS 50, Temacoat RM 40, Temacoat SPA 50, Temadur 10, Temadur 20, Temadur 50, Temadur 90, Temadur HB 50, Temadur HB 80, Temadur SC-F 20, Temadur SC-F 50, Temadur SC-F 80, Temadur HS 90, Temathane 50, Temathane 90, Temathane PC 50, Temathane PC 80, Fontecoat EP 50, Fontecoat EP 80. |
| Application conditions | <p>All surfaces must be clean and dry and free from contamination. During application and drying the temperature of the substrate should be minimum 0°C and relative humidity of the air should not exceed 80%. The surface temperature of the steel should be at least 3°C above the dew point.</p> <p>The product should not be applied at temperatures below 0°C where there is a possibility of ice formation on the substrate. The temperature of paint itself should be above +15°C for proper application. Good ventilation 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> |
| 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 | <p>For airless spraying, the product is thinned approximately 0–15%. Recommended nozzle tip is 0.011"–0.017" and pressure 120–160 bar. Spray angle shall be chosen according to the shape of the object.</p> <p>Use brush application only for stripe coating. For brush application product should be thinned according to the circumstances.</p> |
| Thinners | Thinner 1031 |
| Cleaning of equipment | Thinner 1031 |



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|--------------------------|---|
| VOC | The Volatile Organic Compounds amount is 420 g/litre of paint mixture. VOC content of the paint mixture (thinned 15% by volume) is 480 g/l. VOC 2004/42/EC (cat A/j) 500 g/l (2010) |
| 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.