

# Temacoat SPA Primer

**DESCRIPTION** A two-component resin modified epoxy primer with anti-corrosive pigments.

- PRODUCT FEATURES AND RECOMMENDED USES**
- Has high solids content and can be applied in thick layers, thus enabling faster production.
  - Used as a primer or an intermediate coat in paint systems exposed to abrasion and chemical stress. The paint adheres well to steel, zinc and aluminium surfaces.
  - Pigmented with zinc phosphate.
  - Recommended for building frameworks, tubular bridges, conveyors and other steelwork and equipment.

## TECHNICAL DATA

**Volume solids** 67±2%(ISO 3233)

**Weight solids** 80±2%.

**Specific gravity** 1.4 kg / l (mixed)

**Mixing ratio** Base 4 parts by volume Temacoat SPA Primer  
Hardener 1 part by volume 008 5607

**Pot life (+23°C)** 6 hrs

**Recommended film thicknesses and theoretical coverage**

Recommended film thicknesses		Theoretical coverage
wet	dry	
120µm	80µm	8.4 m²/l
225µm	150µm	4.4 m²/l

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

**Drying time**

DFT 100µm	0°C	+10°C	+23°C	+35°C
Dust dry, after	16h	4h	2h	1h
Touch dry, after	24h	10h	4h	2h
Recoatable, min. after	24h	3h	1h	½h
Recoatable, surfaces to be submerged, min. after	4d	28h	12h	6h
Recoatable with polyurethane paints, min. after	1d	5h	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** Reddish brown (TVT 4000) and grey (TVT 4001 and TVT 4002).

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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> <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>	Temacoat SPA Primer, Temazinc 77, Temazinc 99.
<b>Recommended topcoats</b>	Temacoat HB 30, Temacoat GPL, Temacoat GS 50, Temacoat GPL-S MIO, Temacoat SPA 50, Temadur HB 50, Temadur HB 80, Temadur 50, Temadur 90, Temathane 50, Temathane PC 50, Temathane PC 80.
<b>Application conditions</b>	<p>All surfaces must be clean and dry and free from contamination. During application and drying the temperature of the surface should not fall below 0°C. Relative humidity of the air should not exceed 80% during application and drying. The surface temperature of the steel should remain 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. For proper application the temperature of the paint itself should be above +15°C during mixing and application. 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>	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.
<b>Application</b>	<p>For airless spraying, the product is thinned approximately 0–10%. Recommended nozzle tip is 0.015"–0.021" and pressure 120–180 bar. Spray angle shall be chosen according to the shape of the object.</p> <p>For brush application the product should be thinned according to the circumstances.</p>
<b>Thinners</b>	Thinner 1031
<b>Cleaning of equipment</b>	Thinner 1031
<b>VOC</b>	The Volatile Organic Compounds amount is 310 g/litre of paint mixture. VOC content of the paint mixture (thinned 30 % by volume) is 430 g/l.



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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.