

# Temakeep

## DESCRIPTION

A two-component adhesion primer based on epoxy resin.

## PRODUCT FEATURES AND RECOMMENDED USES

- Used on cold-rolled steel, stainless steel, aluminium, zinc, epoxy and polyurethane surfaces as an adhesion primer before the primary paint system.
- For surfaces exposed to climatic conditions, gases or splashes.
- Can be overcoated with an extensive range of topcoats.
- Can be applied onto a finished epoxy coating as a barrier coat for other types of systems.

## TECHNICAL DATA

**Volume solids** 32±2% (mixture, ISO 3233)

**Weight solids** 55±2% (mixture)

**Specific gravity** 1.3 kg / l (mixture)

**Mixing ratio** Base 2 parts by volume Temakeep  
Hardener 1 part by volume 930 5182

**Pot life (+23°C)** 24 hours

## Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
wet	dry	
35µm	10µm	30.0 m <sup>2</sup> /l
70µm	20µm	15.0 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.

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 15µm	+10°C	+23°C	+35°C
Dust dry, after	10min	3–5min	3min
Touch dry, after	10min	3–5min	3min
Recoatible, after	6h	4h	3h

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

**Gloss** Matt.

**Color shades** Grey and black (RAL 7046 and 7021) Temaspeed Premium tinting.

Please note that with bright and intensive colors hiding power may not be sufficient.

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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>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>
<b>Recommended primers</b>	Temakeep.
<b>Recommended topcoats</b>	Any type of paint can be used with the exception of zinc rich paints.
<b>Application conditions</b>	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.
<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 paint should be thinned 0–15% in order to avoid dry spraying. Recommended nozzle tip is 0.011"–0.015" and pressure 120–140 bar. Spray angle shall be chosen according to the shape of the object.</p> <p>For conventional spraying, the product is thinned approximately 0–30%. Recommended nozzle tip is 1.4–1.8 mm. Atomising air pressure should be 2–4 bar.</p> <p>For brush application 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 to 560±20 g/litre of paint mixture. VOC content of paint mixture (thinned 30% by volume) is 620±20 g/l. Directive 2004/42/EC is not applicable in the use of the product.



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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 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.