

TE80
**TEMACOAT PRIMER
TEMACOAT 50**

The epoxy systems TE80 are recommended for steel, aluminium and zinc surfaces exposed to abrasion, chemicals and other special stress. Resistance to chemicals in a separate table. The systems are suitable for application both in the field and in painting shops.

Corrosivity categories/durability according to ISO 12944	Tikkurila code	Treatment
Steel surfaces		
C2.05, C3.05, C4.04 (12944-5:2019) Corrosivity categories/durability C2-H, C3-M, C4-L Steel constructions exposed to mild condensation in cold indoor spaces and outdoors in clean rural environment.	TE80 TEMACOAT PRIMER TEMACOAT 50	EP120/2-FeSa2½ 80 µm <u>40 µm</u> DFT 120 µm
C2.06, C3.06, C4.05, C5.01 (12944-5:2019) Corrosivity categories/durability C2-VH, C3-H, C4-M, C5-L Steel constructions exposed to mild condensation in cold indoor spaces and outdoors in clean rural environment.	TE80 TEMACOAT PRIMER TEMACOAT 50	EP180/2-FeSa2½ 100 µm <u>80 µm</u> DFT 180 µm
C3.07, C4.06, C5.02 (12944-5:2019) Corrosivity categories/durability C3-VH, C4-H, C5-M Steel structures in damp environment.	TE80 TEMACOAT PRIMER TEMACOAT 50	EP240/2-FeSa2½ 160 µm <u>80 µm</u> DFT 240 µm
C4.07, C5.03 (12944-5:2019) Corrosivity categories/durability C4-VH, C5-H Steel structures in damp environment.	TE80 TEMACOAT PRIMER TEMACOAT PRIMER TEMACOAT 50	EP300/3-FeSa2½ 100 µm 100 µm <u>100 µm</u> DFT 300 µm
C5.04 (12944-5:2019) Corrosivity categories/durability C5-VH Steel structures in damp environment.	TE80 TEMACOAT PRIMER TEMACOAT PRIMER TEMACOAT 50	EP360/3-FeSa2½ 120 µm 120 µm <u>120 µm</u> DFT 360 µm

Marking of paint systems: TE80-EP180/2-FeSa2½

Aluminium surfaces**Corrosivity categories C3, C4**

Aluminium surfaces indoors in urban, maritime and industrial environment with high demands on aesthetics and resistance. According to SFS 5873, system F40.05.

TE80	EP120/2-AISaS	
TEMACOAT PRIMER		80 µm
TEMACOAT 50		<u>40 µm</u>
	DFT	120 µm

Corrosivity categories C5

Aluminium surfaces indoors in severe maritime and industrial environment with high demands on aesthetics and resistance. According to SFS 5873, system F40.07.

TE80	EP200/3-AISaS	
TEMACOAT PRIMER		2 x 80 µm
TEMACOAT 50		<u>40 µm</u>
	DFT	200 µm

Zinc surfaces**G2.03, G3.02, G4.02, G5.01 (12944-5:2019)****Corrosivity categories/durability C2-VH, C3-H, C4-M, C5-L**

Zinc surfaces indoors exposed to mechanical abrasion and outdoors exposed to moderate climatic conditions.

TE80	EP120/2-ZnSaS	
TEMACOAT PRIMER		80 µm
TEMACOAT 50		<u>40 µm</u>
	DFT	120 µm

G3.04, G4.04, G5.02b (12944-5:2019)**Corrosivity categories/durability C3-VH, C4-H, C5-M**

Zinc surfaces outdoors in coastal and industrial areas in aggressive environment.

TE80	EP160/2-ZnSaS	
TEMACOAT PRIMER		80 µm
TEMACOAT 50		<u>80 µm</u>
	DFT	160 µm

SaS = Sweep blasting according to EN ISO 12944-4

COLOURS

Temacoat 50 is tintable with TEMASPEED colorants, thus ensuring the possibility to get shades from RAL-, BS-, NCS- and other colour cards.

SUITABLE SHOP PRIMERS

Temablast EV 110, epoxy shop primer

SURFACE PREPARATION

Oil, grease, salts and dirt are removed by appropriate means. (EN ISO 12944-4)

Steel surfaces:

Blast clean to grade Sa2½. (EN ISO 8501-1) If blast cleaning is not possible, phosphating is recommended for cold rolled steel to improve adhesion.

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.

Hot dip galvanized surfaces are recommended to be painted with a misty coat (paint thinned 25–30%) before the actual priming.

Damages in the zinc coating have to be repaired with TEMAZINC 99, a zinc rich epoxy paint. Before painting, clean the surfaces thoroughly (Sa2½/St3) and level off the edges around the cleaned areas.

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.

APPLICATION CONDITIONS

The surface must be clean and dry and the surface temperature should remain at least 3°C above the dew point. During application and drying the temperature of the air, paint and surface should be a minimum of +10°C. The relative humidity should not exceed 80%.

APPLICATION

The paint should be mixed thoroughly before application and then applied in an even coat on the dry and clean surface. Application with airless or conventional spray, brush or roller. Stripe coating of sharp edges, welding seams etc. should be done by brush or roller.

MAINTENANCE PAINTING**Maintenance**

Touch-up painting is sufficient for maintenance when the rust grade is Ri1–Ri3. (EN ISO 4628-3)

Damages caused by transport or installation July also be repaired by touch-up painting. Remove all loose paint, clean rusty areas according to system demands. On steel surfaces small areas can be grinded or wire brushed to preparation grade St2. (EN ISO 8501-1)

Level off the edges between the old paint film and the cleaned up areas. When using blast cleaning, be sure that there are no cracks in the remaining paint film. If the entire surface has to be overcoated, abrade the old topcoat to a rough finish. Remove all dust and other cleaning residues. Apply primers and finish according to the original paint system, qualities and film thicknesses.

Repainting

When the rust grade is Ri4 or Ri5, the entire coating must be renewed. Remove the old paint film and clean the surfaces to preparation grade Sa2½. Recoat in accordance with the original paint system.

PRODUCT INFORMATION

More detailed product information is available in respective data sheets.

HNO200124

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 14101. 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.