

TP246

Fontezinc 85
Fontecoat EP 50 Beige
Fontedur HB 80

The polyurethane systems TP246 are suitable for steel surfaces exposed to severe climatic conditions. The primer of the system, Fontezinc 85, a zinc rich epoxy paint, offers cathodic protection for the steel. Fontedur HB 80 polyurethane paint forms an easy to clean finish with good gloss and colour retention properties. The systems are suitable for application both in field and in painting shops.

Corrosivity categories/durability according to ISO 12944

| Steel surfaces | Tikkurila code | Treatment |
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| C3.10, C4.10, C5.06 (12944-5:2019) Corrosivity categories/durability C3-VH, C4-H, C5-M Steel surfaces outdoors in urban, maritime and industrial environment with high demands on aesthetics and resistance. | TP246 | EPZn(R)EPPUR200/3-FeSa2½ |
| | Fontezinc 85 | 60 µm |
| | Fontecoat EP 50 Beige | 100 µm |
| | Fontedur HB 80 | <u>40 µm</u> |
| | DFT | 200 µm |
| C4.11, C5.07 (12944-5:2019) Corrosivity categories/durability C4-VH, C5-H Steel surfaces outdoors in urban, maritime and industrial environment with high demands on aesthetics and resistance. | TP246 | EPZn(R)EPPUR260/3-FeSa2½ |
| | Fontezinc 85 | 60 µm |
| | Fontecoat EP 50 Beige | 140 µm |
| | Fontedur HB 80 | <u>60 µm</u> |
| | DFT | 260 µm |

Marking of paint systems: TP246 EN ISO 12944-5/C4.11 EPZn(R)EPPUR260/3-FeSa2½

COLOURS

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

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| SURFACE PREPARATION | Oil, grease, salts and dirt are removed by appropriate means. (EN ISO 12944-4) Steel surfaces: Blast clean to grade Sa2½ Medium Grit. (EN ISO 8501-1) |
| APPLICATION CONDITIONS | 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. If the ambient relative humidity is 70% or higher, appropriate measures must be taken to reduce the relative humidity in the drying stage (forced drying or dehumidifier). 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 |
| 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 may 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. |

HNO240521

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.