



## Temacoat HS-F Primer

### DESCRIPTION

A two-component high-solids, fast-drying all seasons epoxy primer containing anti-corrosive pigments.

### PRODUCT FEATURES AND RECOMMENDED USES

- Fast drying of Temacoat HS-F Primer enables rapid overcoating with polyurethane topcoats, thus shortening overall painting time.
- With Temacoat HS-F Primer, it is possible to achieve both thin and thick dry film thicknesses with the same product. Eases the painting process of multiform structures
- Due to Temacoat HS-F Primer's good adhesion to the substrate and the subsequent coat, it provides excellent corrosion protection for the paint system
- Good adhesion to steel, zinc and aluminium surfaces
- Used as a primer or an intermediate coat on surfaces exposed to climatic, mechanical and chemical stress
- Fast drying even at low temperatures
- Pigmented with zinc phosphate
- Resistant to grey/waste water when applied 2x125µm, tested 6 months
- Recommended for building frameworks, bridges, conveyors and other steelwork and equipment

### TECHNICAL DATA

**Volume solids** 80±2% (ISO 3233)

**Weight solids** 90±2%

**Specific gravity** ab. 1.6 kg / l (mixed)

**Mixing ratio** Base 5 parts by volume Temacoat HS-F Primer  
Hardener 1 part by volume Hardener 008 5615

**Pot life** 1½ hours (+23°C)

### Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
wet	dry	
125µm	100µm	8.0 m <sup>2</sup> /l
250µm	200µm	4.0 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.

### Drying time

DFT 100µm	-10°C	-5°C	0°C	+10°C	+23°C	+35°C
Dust dry, after	16h	10h	6h	4½h	1h	½h
Touch dry, after	29h	15h	10h	6h	2h	1½h
Recoatible, min. after	23h	11h	7h	4h	2h	1h
Recoatible with polyurethane paints, min. after	23h	11h	7h	4h	2h	1h
Recoatible without roughening max. 3 months						

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



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**Gloss** Semi-matt.

**Color shades** Grey (TVT 4001) and red (TVT 4000)

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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 ProService.</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 HS-F Primer, Temazinc 77, Temazinc 99.
<b>Recommended topcoats</b>	Temacoat GPL, Temacoat GS 50, Temacoat GPL-S MIO, Temacoat 50, Temadur 50, Temadur 90, Temathane 50, Temathane PC 50, Temathane PC 80, Temasilox.
<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 -10°C. The surface temperature of steel should remain at least 3°C above the dew point. Care has to be taken that there is no ice 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 mechanical mixer.
<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> <p>In case of larger projects, i.e. more than one set, it is recommended either to use the whole mixture at once or to prepare a new mixture instead of combining old and new mixtures. Use of two-component equipment is recommended as well in order to maintain homogenous mixture.</p>
<b>Thinners</b>	Thinner 1031
<b>Cleaning of equipment</b>	Thinner 1031
<b>VOC</b>	The Volatile Organic Compounds amount (ISO 11890) is 215 g/litre of paint mixture. VOC content of the paint mixture (thinned 10% by volume) is 275 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.