

# Duasolid 50

**DESCRIPTION** A two-component oxirane-ester paint containing active anti-corrosive pigments.

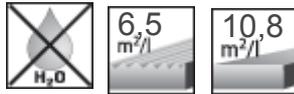
**PRODUCT FEATURES** Used as a single coat or as a topcoat in oxirane ester based systems on steel surfaces exposed to abrasion and chemicals in severe climatic conditions.

**RECOMMENDED USES** Suitable for earth moving machines, haulage and lifting equipment, forklifts, agricultural machinery, electric appliances, pumps and other steel structures, equipment and machinery.



[zoom](#)

## TECHNICAL DATA



**Features** Excellent durability. Environmentally more friendly and for users more safe alternative than epoxy and polyurethane paints. High volume solids. High film build properties, up to 100 µm / one coat.

Coverage	Recommended film thicknesses approx.		Theoretical coverage approx.
	dry	wet	
	60 µm	95 µm	10.8 m <sup>2</sup> /l
	100 µm	160 µm	6.5 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.

**Thinner** 1048 and 1112

**Mixing ratio** Base 2 parts by volume 527-series  
Hardener 1 part by volume 008 7675, other hardeners: see application

**Application method** By airless, conventional or electrostatic spray

**Pot-life (+23°C)** 8 hours

Drying times	DFT 80 µm	+ 23 °C
	Dust dry, after	30 - 60 min
	Touch dry, after	4 - 6 h
	Dry to handle, after	8 - 12 h
	Recoat with other Duasolid 50 paints, after	a few min
	Through dry at increased temperature after 45 min / 80 °C.	



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

Solids volume approx. 65 ± 2 volume %  
Density approx. 1.5 kg / l  
Product code 527-series

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### APPLICATION DETAILS

**Application conditions**  
All surfaces must be dry. The temperature of the ambient air, surface or paint itself should not fall below +10 °C during application or drying. Relative humidity should not exceed 80 %. The surface temperature of the steel should remain at least 3 °C above the dew point.  
Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4)

**Preparation**  
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.

**Priming**  
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)  
**Finishing**  
Duasolid Primer and Duasolid 50.  
Duasolid 50.

By airless, conventional or electrostatic spray. At airless spray application the paint can be thinned if necessary to a viscosity of 30–60 s DIN 4. Airless spray nozzle tip "0.011–0.015", pressure ratio at least 30:1 and nozzle pressure 120–180 bar. At conventional spray application the viscosity should be 20–40 s DIN 4 and at electrostatic spraying 20–40 s DIN 4.

**Painting**  
Properties and gloss of DUASOLID 50 will vary according to the used hardener:

Hardener 008 7675 gloss abt. > 70 mixing ratio 2:1  
Hardener 008 7665 gloss abt. 60 mixing ratio 2:1  
Hardener 008 7667 gloss abt. 10 mixing ratio 2:1  
Hardener 008 7672 gloss abt. 40 mixing ratio 2:1  
Hardener 008 7668 gloss abt. < 10 mixing ratio 2:1

**Mixing of components**  
Avoid hot spray!  
First stir base and hardener separately. The correct proportions of base and hardener must be mixed thoroughly before use. Use Temaspeed Squirrel Mixer for mixing.

**Cleaning of tools** Thinner 1048 or Thinner 1112.

**EU VOC 2004/42/  
EC-limit value** The Volatile Organic Compounds amount is 320 g/litre of paint mixture.  
VOC content of the paint mixture (thinned 15 % by volume) is 399 g/l.

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### HEALTH AND SAFETY

LABELLING according to Regulation (EC) No. 1272/2008

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. [DUASOLID 50 \[GB-ENG\]](#)

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### ENVIRONMENTAL

and WASTE -  
DISPOSAL -  
TRANSPORT -

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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.