



# Temacoat Primer

## DESCRIPTION

A two-component resin modified epoxy paint containing anti-corrosive pigments.

## PRODUCT FEATURES AND RECOMMENDED USES

- Adheres well to steel, zinc and aluminium surfaces. It is possible to achieve high film thickness with one application. The high-solids product ensures a long service life for the paint system
- A high-build primer for paint systems used in severe environments. The product is used as an intermediate coat in the NORSOK approved systems on surfaces exposed to marine conditions
- The speed of the painting process can be adjusted by choice of hardener. Can be applied at sub-zero temperatures
- Used as a primer or an intermediate coat on surfaces exposed to climatic, mechanical and chemical stress
- Pigmented with zinc phosphate
- Recommended for building frameworks, tubular bridges, conveyors and other steelwork and equipment

## TECHNICAL DATA

**Volume solids** 72±2% (ISO 3233)

**Weight solids** 83±2%

**Specific gravity** ab. 1.5 kg / l (mixed)

**Mixing ratio**

Base	4 parts by volume	Temacoat Primer
Hardener	1 part by volume	008 5611
Base	5 parts by volume	Temacoat Primer
Hardener	1 part by volume	008 5613

**Pot life (+23°C)** 6 hours with Hardener 008 5611  
4 hours with Hardener 008 5613

## Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
wet	dry	
110µm	80µm	9.0 m <sup>2</sup> /l
225µm	160µm	4.5 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.

# Temacoat Primer

## Drying time

DFT 100 µm		-10°C	-5°C	0°C	+10°C	+23°C	+35°C
Dust dry, after	Hardener 008 5611	-	-	20h	5h	3h	1½h
	Hardener 008 5613	16h	10h	6h	4½h	1h	½h
Touch dry, after	Hardener 008 5611	-	-	30h	12h	5h	3h
	Hardener 008 5613	30h	16h	11h	7h	3h	1½h
Recoatible, min. after	Hardener 008 5611	-	-	32h	12h	4h	2h
	Hardener 008 5613	24h	12h	8h	5h	3h	1h
Recoatible with polyurethane paints, min. after	Hardener 008 5611	-	-	2½d	18h	6h	3h
	Hardener 008 5613	30h	16h	10h	6h	4h	2h
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.

## Gloss

Semi-matt.

## Color shades

Reddish brown (TVT 4000) and grey (TVT 4001 and TVT 4002)

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## APPLICATION INSTRUCTIONS

- Surface preparation** Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4)
- 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.
- 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.
- 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.
- 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)
- Recommended primers** Temazinc 99, Temazinc 77, Temacoat Primer.
- Recommended topcoats** Temacoat GPL, Temacoat GS 50, Temacoat 50, Temacoat GPL-S MIO, Temadur 10, Temadur 50, Temadur HS 90, Temadur SC 20, Temadur SC 50, Temadur SC 80, Temadur SC-F 20, Temadur SC-F 50, Temadur SC-F 80, Temathane 50, Temathane 90, Temathane PC 50, Temathane PC 80, Temasilox, Temacryl EA 50.
- Application conditions**
- With hardener 008 5611:  
All surfaces must be clean and dry and free from contamination. During application and drying the temperature of the surface should not fall below 0°C. Relative humidity of the air should not exceed 80% during application and drying. The surface temperature of the steel should remain at least 3°C above the dew point.  
The product should not be applied at temperatures below 0°C where there is a possibility of ice formation 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.
- With hardener 008 5613:  
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.
- 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.
- Mixing components** 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.



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**Application** 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.

For brush application the product should be thinned according to the circumstances.

**Thinners** Thinner 1031

**Cleaning of equipment** Thinner 006 1031.

**VOC** The Volatile Organic Compounds amount is 280 g/litre of paint mixture.

VOC content of the paint mixture (thinned 10% by volume) is 325 g/l.

**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.

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