



TE65B

TEMACOAT 50

The epoxy systems TE65B are recommended for steel, aluminium and zinc surfaces exposed to abrasion, chemicals, high humidity and climate in indoor and outdoor applications, also for submerged and underground constructions.

Temacoat 50 is available in many colours, also light ones, which makes it easier to follow up the condition of the coating.

Corrosivity categories according to ISO 12944

Tikkurila code

Treatment

Steel surfaces

12944-6:2018

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.

TE65B

TEMACOAT 50

EP100/1-FeSa2½

100 µm

DFT 100 µm

Marking of paint systems: TE65B-SFS-EN ISO 12944-6 (EP100/1-FeSa2½)

COLOURS

Temacoat 50 is tintable with TEMASPEED Premium 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

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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. (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. (EN ISO 12944-4) 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. (EN ISO 12944-4)

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. (EN ISO 12944-4)

APPLICATION CONDITIONS

The surface must be clean, 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 enough 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.

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