TF24

FONTECRYL 25

The waterborne systems TF24 are suitable for steel, aluminium and zinc surfaces exposed to climatic conditions. The waterborne systems make it possible to reduce the solvent emissions. FONTECRYL 25 is anticorrosive pigmented, fast drying acrylic paint. The systems are most suitable for application in painting shops.

Corrosivity categories/durability according to ISO 12944	**Tikkurila code**	**Treatment**
Steel surfaces		
C2.01 (12944-5:2019)		
Corrosivity categories/durability C2-L	**TF24**	**AY80/1-FeSa2½**
Steel surfaces indoors and outdoors in clean rural environment.	FONTECRYL 25	80 µm
	DFT	80 µm
C2.02, C3.01 (12944-5:2019)		
Corrosivity categories/durability C2-M, C3-L	**TF24**	**AY100/1-FeSa2½**
Steel structures, machines and equipment outdoors in urban and industrial environment.	FONTECRYL 25	100 µm
	DFT	100 µm
C2.03, C3.02, C4.01 (12944-5:2019)		
Corrosivity categories/durability C2-H, C3-M, C4-L	**TF24**	**AY160/2-FeSa2½**
Steel surfaces outdoors in rural and urban environment.	FONTECRYL 25	80 µm
	FONTECRYL 25	80 µm
	DFT	160 µm

Marking of paint systems: TF36- EN ISO 12944-5/C2.03 (AY160/2-FeSa2½)

Aluminium surfaces		
Corrosivity categories C1, C2	**TF24**	**AY120/2-AlSaS**
Aluminium surfaces indoors and outdoors in mild environment.	FONTECRYL 25	2 x 60 µm
According to SFS 5873, system F40.03	DFT	120 µm
Zinc surfaces		
G2.01, G3.01, G4.01 (12944-5:2019)	**TF24**	**AY80/1-ZnSaS**
Corrosivity categories/durability C2-H, C3-M, C4-L	FONTECRYL 25	80 µm
Zinc surfaces outdoors in rural and urban environment.	DFT	80 µm
G2.02, G3.03, G4.03, G5.02a (12944-5:2019)	**TF24**	**AY160/2-ZnSaS**
Corrosivity categories/durability C2-VH, C3-H, C4-M, C5-L	FONTECRYL 25	80 µm
Zinc surfaces outdoors in rural and urban environment.	FONTECRYL 25	80 µm
	DFT	160 µm

SaS = Sweep blasting according to EN ISO 12944-4

COLOURS	The product is tintable with TEMASPEED FONTE 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

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. (SaS, SFS 5873) If sweep blasting is not possible, the surface should be roughened by hand abrading or washed with PANSSARIPESU detergent.

Hot dip galvanized surfaces are recommended to be painted with a misty coat (paint thinned 25 - 30 %) before the actual priming.

Aluminium surfaces: Sweep blast-clean with none-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.
(EN ISO 12944-4)

APPLICATION CONDITIONS

The surface must be clean, dry and the surface temperature should remain at least
3 ºC above the dew point. During application and drying the temperature of the air, paint and surface should be a minimum of + 15 ºC. The relative humidity should not exceed 70 %.

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.