

**TH44B**
**Temamastic PM 100  
Fontecoat EP 80**

The hybrid systems TH44B consist of high solids epoxy primer and waterborne epoxy topcoat. The hybrid systems are suitable for steel constructions exposed to severe mechanical and other special stress. Because FONTECOAT EP 80 is waterborne the use does not cause danger of fire or harm of solvents in the application spaces. It also makes it possible to reduce the solvent emissions. The primer of the system, TEMAMASTIC PM 100, a high solids epoxy paint forms a very tight, abrasion and chemically resistant coat due to the aluminium pigments. The systems are suitable for application in the field, workshops and painting stations.

Corrosivity categories/durability according to ISO 12944	Tikkurila code	Treatment
<b>Steel surfaces</b>		
<b>(12944-6:2018)</b>		
<b>Corrosivity categories/durability C2-VH, C3-H, C4-M, C5L</b>	<b>TH44B</b>	<b>EP280/3-FeSa2½</b>
Steel surfaces in severe industrial and marine environment with high demands on aesthetics and resistance.	TEMAMASTIC PM 100	120 µm
	FONTECOAT EP 80	<u>2 x 80 µm</u>
	DFT	280 µm
<b>(12944-6:2018)</b>		
<b>Corrosivity categories C3-VH, C4-H, C5-M</b>	<b>TH44B</b>	<b>EP320/3-FeSa2½</b>
Steel constructions, machines and equipment in indoor spaces and outdoors exposed to severe splashes and chemical dust. E.g. in paper and wood-processing industry.	TEMAMASTIC PM 100	100 µm
	TEMAMASTIC PM 100	140 µm
	FONTECOAT EP 80	<u>80 µm</u>
	DFT	320 µm

**Marking of paint systems: TH44B - EN ISO 12944-6 (EP280/3-FeSa2½)**

**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.

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<b>SURFACE PREPARATION</b>	Oil, grease, salts and dirt are removed by appropriate means. (EN ISO 12944-4)  <b>Steel surfaces:</b> 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.
<b>APPLICATION CONDITIONS</b>	The surface must be clean and dry. When applying TEMAMASTIC PM 100 the temperature of the ambient air, surface or paint should not fall below +10 °C during application and drying, when applying FONTECOAT EP 80 +15 °C. The relative humidity should not exceed 70 %. The surface temperature of the steel should remain at least 3 °C above the dew point.
<b>APPLICATION</b>	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.
<b>MAINTENANCE PAINTING</b>	<b>Maintenance</b> Touch-up painting is sufficient 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 must 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.  <b>Repainting</b> 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.
<b>PRODUCT INFORMATION</b>	More detailed product information is available in respective data sheets.

HNO200408

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 14101. 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.