

TH64
**TEMACOAT HS-F PRIMER
FONTEDUR HB 80**

The Hybrid polyurethane systems TH64 are recommended for steel surfaces exposed to severe climatic conditions. FONTEDUR HB 80 polyurethane paint forms an easy to clean finish with good gloss and colour retention properties. The system is suitable for application both in the field and in painting shops.

Corrosivity categories/durability according to ISO 12944	Tikkurila code	Treatment
Steel surfaces		
C2.05, C3.05, C4.04 (12944-5:2019)		
Corrosivity categories/durability C2-H, C3-M, C4-L	TH64	EPPUR120/2-FeSa2½
Steel surfaces indoors and outdoors in clean rural environment, providing high demands on aesthetics and durability of the paint film.	TEMACOAT HS-F PRIMER	80 µm
	FONTEDUR HB 80	40 µm
	DFT	120 µm
C2.06, C3.06, C4.05, C5.01 (12944-5:2019)		
Corrosivity categories/durability C2-VH, C3-H, C4-M, C5-L	TH64	EPPUR180/2-FeSa2½
Steel surfaces outdoors in industrial and urban environment, providing high demands on aesthetics and durability of the paint film.	TEMACOAT HS-F PRIMER	140 µm
	FONTEDUR HB 80	40 µm
	DFT	180 µm

Marking of paint systems: TH64 - EN ISO 12944-5/C2.06 (EPPUR180/2-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

SURFACE PREPARATION	<p>Oil, grease, salts and dirt are removed by appropriate means. (EN ISO 12944-4)</p> <p>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.</p>
APPLICATION CONDITIONS	<p>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 + 15 °C. The relative humidity should not exceed 80 %.</p>
APPLICATION	<p>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.</p>
MAINTENANCE PAINTING	<p>Maintenance 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 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.</p> <p>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.</p>
PRODUCT INFORMATION	<p>More detailed product information is available in respective data sheets.</p>

HNO200703

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.