

**TE28**
**TEMACOAT SPA 50**

The epoxy systems TE28 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 SPA 50 is available in many colours, also light ones, which makes it easier to follow up the condition of the coating.

<b>Corrosivity categories according to ISO 12944</b>	<b>Tikkurila code</b>	<b>Treatment</b>
<b>Steel surfaces</b>		
<b>C2.05, C3.05, C4.04 (12944-5:2019)</b> <b>Corrosivity categories/durability C2-H, C3-M, C4-L</b> Steel constructions exposed to mild condensation in cold indoor spaces and outdoors in clean rural environment.	<b>TE28</b> TEMACOAT SPA 50	<b>EP120/1-FeSa2½</b> <u>120 µm</u> DFT 120 µm
<b>C2.06, C3.06, C4.05, C5.01 (12944-5:2019)</b> <b>Corrosivity categories/durability C2-VH, C3-H, C4-M, C5-L</b> Steel constructions exposed to mild condensation in cold indoor spaces and outdoors in clean rural environment.	<b>TE28</b> TEMACOAT SPA 50	<b>EP180/2-FeSa2½</b> <u>2 x 90 µm</u> DFT 180 µm
<b>C3.07, C4.06, C5.02 (12944-5:2019)</b> <b>Corrosivity categories/durability C3-VH, C4-H, C5-M</b> Steel structures in damp environment.	<b>TE28</b> TEMACOAT SPA 50 DFT	<b>EP240/2-FeSa2½</b> <u>2 x 120 µm</u> 240 µm

**Marking of paint systems: TE28-SFS-EN ISO 12944-5/ C2.05 (EP120/1-FeSa2½)**

**Zinc surfaces****G2.01, G3.01, G4.01 (12944-5:2019)****Corrosivity categories/durability C2-H, C3-M, C4-L**

Zinc surfaces outdoors in rural areas and urban areas

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DFT

**EP80/1-ZnSaS**80 µm

80 µm

**G2.03, G3.02, G4.02, G5.01 (12944-5:2019)****Corrosivity categories/durability C2-VH, C3-H, C4-M, C5-L**

Zinc surfaces indoors exposed to mechanical abrasion and outdoors exposed to moderate climatic conditions.

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DFT

**EP120/1-ZnSaS**120 µm

120 µm

**G3.04, G4.04, G5.02b (12944-5:2019)****Corrosivity categories/durability C3-VH, C4-H, C5-M**

Zinc surfaces outdoors in coastal and industrial areas in aggressive environment.

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DFT

**EP160/2-ZnSaS**2 x 80 µm

160 µm

**G4.06, G5.04 (12944-5:2019)****Corrosivity categories/durability C4-VH, C5-H**

Zinc surfaces outdoors in coastal and industrial areas in aggressive environment.

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DFT

**EP200/2-ZnSaS**2 x 100 µm

200 µm

**SaS = Sweep blasting according to EN ISO 12944-4****COLOURS**

Temacoat SPA 50 is tintable with TEMASPEED 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. (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 and 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 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.

**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.

HNO200124

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.