

TE65

TEMACOAT 50

The epoxy systems TE65 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		
C2.05, C3.05, C4.04 (12944-5:2019)		
Corrosivity categories/durability C2-H, C3-M, C4-L	TE65	EP120/1-FeSa2½
Steel constructions exposed to mild condensation in cold indoor spaces and outdoors in clean rural environment.	TEMACOAT 50	<u>120 µm</u>
		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	TE65	EP180/2-FeSa2½
Steel constructions exposed to mild condensation in cold indoor spaces and outdoors in clean rural environment.	TEMACOAT 50	<u>2 x 90 µm</u>
		DFT 180 µm
C3.07, C4.06, C5.02 (12944-5:2019)		
Corrosivity categories/durability C3-VH, C4-H, C5-M	TE65	EP240/2-FeSa2½
Steel structures in damp environment.	TEMACOAT 50	<u>2 x 120 µm</u>
	DFT	240 µm
I.03 (12944-5:2019)		
Corrosivity categories/durability Im1-H, Im2-H, Im3-H	TE65	EP380/3-FeSa2½
Steel structures immersed in fresh water, sea water and soil.	TEMACOAT 50	80 µm
	TEMACOAT 50	<u>2 x 150 µm</u>
	DFT	380 µm

Marking of paint systems: TE65-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

TE65
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 DFT

EP80/1-ZnSaS
 80 µm
 80 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.

TE65
 TEMACOAT 50
 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.

TE65
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 TEMACOAT 50
 DFT

EP200/2-ZnSaS
 80 µm
 120 µm
 200 µm

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

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.

HNO200323

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.