

TE85
**TEMACOAT HS-F PRIMER
TEMACOAT 50**

The epoxy system TE85 is suitable for steel surfaces exposed to severe conditions. The system is suitable for application both in the field and in painting shops.

Corrosivity categories according to ISO 12944	Tikkurila code	Treatment
Steel surfaces		
C2.06, C3.06, C4.05, C5.01 (12944-5:2019)	TE85	EP180/2-FeSa2½
Corrosivity categories/durability C2-VH, C3-H, C4-M, C5-L	TEMACOAT HS-F PRIMER	100 µm
Indoor steel surfaces in buildings areas with high humidity and some air pollution; almost permanent condensation and high pollution.	TEMACOAT 50	<u>80 µm</u>
	DFT	180 µm
C3.07, C4.06, C5.02 (12944-5:2019)	TE85	EP240/2-FeSa2½
Corrosivity categories/durability C3-VH, C4-H, C5-M	TEMACOAT HS-F PRIMER	120 µm
Indoor steel surfaces in buildings areas with high humidity and some air pollution; almost permanent condensation and high pollution.	TEMACOAT 50	<u>120 µm</u>
	DFT	240 µm
C4.07, C5.03 (12944-5:2019)	TE85	EP300/2-FeSa2½
Corrosivity categories/durability C4-VH, C5-H	TEMACOAT HS-F PRIMER	150 µm
Indoor steel surfaces in buildings areas with almost permanent condensation and high pollution.	TEMACOAT 50	<u>150 µm</u>
	DFT	300 µm
C5.04 (12944-5:2019)	TE85	EP360/3-FeSa2½
Corrosivity categories/durability C5-VH	TEMACOAT HS-F PRIMER	120 µm
Indoor steel surfaces in buildings areas with almost permanent condensation and high pollution.	TEMACOAT HS-F PRIMER	120 µm
	TEMACOAT 50	<u>120 µm</u>
	DFT	360 µm

Marking of paint systems: TE85-EN ISO 12944-5/C4.06- EP240/2-FeSa2½

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

Indoor zinc surfaces in buildings areas with high humidity and some air pollution; almost permanent condensation and high pollution.

TE85	EP120/2-ZnSaS
TEMACOAT HS-F PRIMER	80 µm
TEMACOAT 50	<u>40 µm</u>
DFT	120 µm

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

Indoor zinc surfaces in buildings areas with high humidity and some air pollution; almost permanent condensation and high pollution.

TE85	EP160/2-ZnSaS
TEMACOAT HS-F PRIMER	80 µm
TEMACOAT 50	<u>80 µm</u>
DFT	160 µm

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

Indoor zinc surfaces in buildings areas with almost permanent condensation and high pollution.

TE85	EP200/2-ZnSaS
TEMACOAT HS-F PRIMER	80 µm
TEMACOAT 50	<u>120 µm</u>
DFT	200 µm

G5.05 (12944-5:2019)**Corrosivity categories/durability C5-VH**

Indoor zinc surfaces in buildings areas with almost permanent condensation and high pollution.

TE85	EP240/2-ZnSaS
TEMACOAT HS-F PRIMER	80 µm
TEMACOAT 50	<u>160 µm</u>
DFT	240 µm

SaS = Sweep blasting according to EN ISO 12944-4

COLOURS

TEMACOAT 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. (SaS, SFS 5873) If sweep blasting is not possible, the surface should be roughened by hand abrading

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

Damages in the zinc coating have to be repaired with Temazinc 99, a zinc rich epoxy paint. Before painting, clean the surfaces thoroughly (Sa2½/St3) and level off the edges around the cleaned areas.

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 and surface should be a minimum of 0 °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 areas. When using blast cleaning, be sure that there are no cracks in the remaining paint film. If the entire surface have 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.

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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.