



# Fontezinc 85

## DESCRIPTION

A two-component, water-borne zinc-rich epoxy paint.

## PRODUCT FEATURES AND RECOMMENDED USES

- Offers cathodic protection of steel
- Used as a primer in epoxy, polyurethane and acrylic systems for steel surfaces exposed to severe climatic conditions
- Can be used without a topcoat on surfaces exposed to weathering
- Recommended for bridges, cranes and steel frameworks as well as steelwork and equipment in the forest and chemical industries; such as tubular bridges, conveyors etc

## TECHNICAL DATA

**Volume solids** 44±2% (thinned 40 volume-%)

**Specific gravity** 2.4 kg/l (mixed and thinned 40%)

**Mixing ratio**

Base	4.3 parts by volume	Fontezinc 85
Hardener	1.0 part by volume	930 2760
Water	2.0 part by volume	(see overleaf: "Application")

**Pot life (+23°C)** 4 hours

## Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
wet	dry	
85µm	40µm	11.6 m <sup>2</sup> /l
170µm	80µm	5.8 m <sup>2</sup> /l

Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated.

## Drying time

DFT 40µm	+10°C	+23°C	+35°C
Dust dry, after	1h	½h	20min
Touch dry, after	2h	1h	½h
Recoatable with waterborne paints, after	5h	2h	1h
Recoatable with solventborne paints, after	48h	24h	12h

Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation.

**Gloss** Matt.

**Color shades** Reddish grey.



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## APPLICATION INSTRUCTIONS

<b>Surface preparation</b>	Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4)  Steel surfaces: Blast clean to grade Sa2½. (ISO 8501-1) In order to get the best performance the surface profile should be medium grit. (ISO 8503-2)
<b>Recommended topcoats</b>	Fontedur HB 80, Fontecoat EP 50, Temacoat GPL-S Primer, Temacoat GPL-S MIO, Temacoat RM 40, Temanyl MS Primer.
<b>Application conditions</b>	All surfaces must be clean, dry and free from contamination. The temperature of the ambient air, surface and paint should not fall below +10°C during application and drying. Relative humidity of the air should not exceed 80% during application and drying. The surface temperature of steel should remain at least 3°C above the dew point. Good ventilation and sufficient air movement is required in confined areas during application and drying.  Note! There is a natural tendency of this coating to chalk, discolor or yellow unevenly. It is recommended to use polyurethane topcoat when there are high aesthetical requirements on color appearance.
<b>Mixing components</b>	First stir base and hardener separately. The correct proportions of base and hardener must be mixed thoroughly before use. Use power mixer for mixing. Insufficient mixing or incorrect mixing ratio will result in uneven drying of the surface and weaken the properties of the coating.
<b>Application</b>	Agitate during application. For airless spraying, the product is thinned approximately 20–50%. Recommended nozzle tip is 0.013"–0.019" and pressure 160–200 bar. Spray angle shall be chosen according to the shape of the object.  Sharp edges, corners, weld seams and other areas difficult to cover properly by spray application should be coated by brush before the spray application.  For brush application product should be thinned according to the circumstances.
<b>Thinners</b>	Water
<b>Cleaning of equipment</b>	Water and Thinner 1029.
<b>VOC</b>	The Volatile Organic Compounds amount to 180 g/litre of paint mix thinned 40% by volume.
<b>HEALTH AND SAFETY</b>	Containers are provided with safety labels, which should be observed. Further information about hazardous influences and protection are detailed in individual health and safety data sheets. A health and safety data sheet is available on request from Tikkurila Oyj.

### For industrial use only.

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 14001. 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.

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