

Fontecoat EP 50

- DESCRIPTION** A two component waterborne epoxy topcoat and a single coat paint.
- PRODUCT FEATURES** Used as a topcoat or as a single coat paint in epoxy paint systems for steel surfaces. Can also be used as a primer or intermediate coat in epoxy / polyurethane systems.
- Recommended uses** Recommended for framework, service platforms, conveyors and other steelwork, machinery and equipment.

TECHNICAL DATA

Features Very good resistance against mechanical and chemical stress. Resistant to diesel and biodiesel (RME) fuel.

Colour Cards TEMASPEED FONTE tinting.

Gloss groups Semi-gloss

Coverage	Recommended film thicknesses		Theoretical coverage
	dry	wet	
	60µm	130µm	7.7m ² /l
	100µm	215µm	4.7m ² /l
	120µm	225µm	3.9m ² /l

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

Thinner Water

Mixing ratio Base 1 part by volume 168-series
Hardener 1 part by volume 007 1019

Application method By airless spray or brush.

Pot-life (+23°C) 1½ h.

Drying times	DFT 100 µm		
	+ 15 °C	+ 23 °C	+ 35 °C
Dust dry, after	4 h	2 h	1 h
Touch dry, after	8 h	5 h	2 h
Recoat by itself, min. after	16 h	6 h	4 h
Recoat without roughing, max. after	7 d	5 d	2 d
Fully cured, after	14 d	7 d	3 d

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

Solids volume 47 ± 2 volume % (ISO 3233)
62 ± 2 weight %

Density 1,4 kg/l (mixed).

Product code 168 -series



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APPLICATION DETAILS

Application conditions	All surfaces must be dry. The temperature of the ambient air, surface or paint should not fall below +15°C during application and drying. Relative humidity should not exceed 70%. The surface temperature of the steel should remain at least 3°C above the dew point.
Preparation	Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4) Steel surfaces: Blast clean to grade Sa2½. (ISO 8501-1) If blast cleaning is not possible, phosphating is recommended for cold rolled steel to improve adhesion. 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. (ISO 12944-4)
Priming	Fontecryl APS, Fontezinc 85, Fontecoat EP Primer, Fontecoat EP 50, Temazinc 99 and Temacoat GPL-S Primer.
Finishing	Fontecoat EP 50 and Fontedur HB 80.
Painting	By airless spray or brush. If necessary, the paint can be thinned 0 - 10%. Airless spray nozzle tip 0.011" - 0.015" and nozzle pressure 140 - 180 bar. Spray angle shall be chosen according to the shape of the object. 160 µm DFT should not be exceeded.
Mixing of components	First stir base and hardener separately. The correct proportions of base and hardener must be mixed thoroughly before use. Use mechanical mixer for mixing.
Cleaning of tools	Clean the spraying equipment immediately after use as follows: 1. Run the equipment with water to remove excess paint from the equipment. 2. Run the equipment with a mixture of approx 20% Thinner 1109 in clean water, at least two times. 3. Finally wash with undiluted Thinner 1109. Wash the equipment with water before starting to paint again. Unwashed equipment can cause serious surface defects. Contact Tikkurila Technical Service for detailed instructions for cleaning 2-component application equipment.
EU VOC 2004/42/EC-limit value	The Volatile Organic Compounds amount is 60 g/litre of paint mixture. VOC content of paint mixture (thinned by 10 % by volume) 55 g/l. Only for industrial and professional use.

HEALTH AND SAFETY LABELLING according to Regulation (EC) No. 1272/2008

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.

Safety data sheet	 FONTECOAT EP 50
Hardener safety data sheet	 HARDENER 007 1019 [GB-ENG]

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