

## TEMABOND WG 300

### DESCRIPTION

A two component, low temperature curing modified epoxy paint.

### PRODUCT FEATURES AND RECOMMENDED USES

- ◆ Forms a tight coat with good chemical and abrasion resistance.
- ◆ Especially used as a primer for steel surfaces difficult to clean in process and chemical industry and in water immersion, such as ship hulls and ballast tanks.
- ◆ Very good adhesion to blast cleaned or power tool prepared steel.
- ◆ Recommended for repairing of damages caused by transport or installation and for repainting and touch-up painting of earlier painted surfaces.
- ◆ Can also be applied on old alkyd paint surfaces.

### TECHNICAL DATA

**Volume solids** 70 ± 2 %. (ISO 3233)

**Weight solids** 78 ± 2 %.

**Specific gravity** 1.3 kg / l (mixed)

**Mixing ratio and product codes**  
Base 1 part by volume 176-series  
Hardener 1 part by volume 008 7518

**Pot life** 1 hour (23 °C / 74 °F)

### Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
100 µm	145 µm	7.0 m <sup>2</sup> /l
200 µm	290 µm	3.5 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 150 µm	- 5 °C	0 °C	+ 5 °C	+ 10 °C	+ 23 °C
Dust dry	18 h	14 h	6½ h	3½ h	2½ h
Touch dry	48 h	36 h	17 h	9 h	5 h
Recoatable	48 h	36 h	17 h	9 h	5 h
Recoatable with epoxy, max. without sanding	2 months	2 months	2 months	2 months	2 months
Recoatable with polyurethane	-	-	14 d	14 d	14 d

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

**Finish** Semigloss.

**Colours** TEMASPEED tinting.

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### APPLICATION DETAILS

<b>Surface preparation</b>	Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4)  <u>Steel surfaces:</u> Remove rust by tool cleaning to minimum St2 or blast clean to Sa2½ . Blast clean to grade Sa2½ for immersion. (ISO 8501-1).  <u>Earlier painted surfaces:</u> Roughen old paint surfaces using e.g. abrasive wheel, sand paper or blast cleaning.
<b>Primer</b>	TEMABOND WG 300 and WG 200.
<b>Finish</b>	TEMACOAT GPL, TEMACOAT GPL-S MIO, TEMACOAT GPL-S PRIMER, TEMACOAT GS 50, TEMACOAT RM 40, TEMACOAT HS 40, TEMADUR, TEMATHANE, TEMACRYL EA, TEMABOND WG 300 and ST 300.
<b>Application conditions</b>	All surfaces must be dry. The temperature of the ambient air and the surface should not fall below - 5 °C / 23 °F during application and drying, the temperature of the paint should be at least +15 °C / 59 °F. Relative humidity should not exceed 80 %. The surface temperature of the steel should remain at least 3 °C / 38 °F above the dew point.
<b>Mixing components</b>	First stir base and hardener separately. The correct proportions of base and hardener must be mixed thoroughly before use. Use a mechanical agitator for mixing.
<b>Application</b>	By airless spray or brush. If necessary, the paint can be thinned 0 - 10 %. Airless spray nozzle tip 0.013" - 0.019", pressure 120 - 180 bar, spray angle shall be chosen according to the shape of the object.
<b>Thinner</b>	Thinner 1031.
<b>Cleaning of equipment</b>	Thinner 1031.
<b>VOC</b>	The Volatile Organic Compounds amount to 300 ± 20 g/litre of paint.
<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 Coatings Oy.  For professional use only.

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