

**TE56**
**MAINTENANCE PAINTING SYSTEM**
**TEMABOND ST 300**

The epoxy systems TE56 are recommended for steel constructions exposed to climatic conditions when blast cleaning is not achievable. The product, TEMABOND ST 300 forms a very tight, abrasion and chemically resistant coat. Maintenance painting system.

Corrosivity categories/durability according to ISO 12944	Tikkurila Oyj code	Treatment
<b>Steel surfaces</b>		
<b>Corrosivity categories/durability C2</b> Steel surfaces in environment where the humidity and salinity are moderate. According to SFS 5873, system R25.04	<b>TE56</b> TEMABOND ST 300	<b>EP100/1-FeSt2</b> DFT <u>100 µm</u> 100 µm
<b>Corrosivity categories/durability C4, C5-I, C5-M</b> Steel constructions and equipment exposed to gas and chemical dust. E.g. tubular bridges and service platforms.	<b>TE56</b> TEMABOND ST 300	<b>EP200/2-FeSt2</b> DFT $\frac{2 \times 100 \mu\text{m}}{200 \mu\text{m}}$
<b>Corrosivity categories/durability Im1, Im2, Im3</b> Steel surfaces in water immersion, e.g. ships.	<b>TE56</b> TEMABOND ST 300	<b>EP300/2-FeSt2</b> DFT $\frac{2 \times 150 \mu\text{m}}{300 \mu\text{m}}$
<b>Corrosivity categories/durability Im1-M, Im2-M, Im3-M</b> Steel surfaces in water immersion, e.g. ships.	<b>TE56</b> TEMABOND ST 300 TEMABOND ST 300	<b>EP380/3-FeSt2</b> 80 µm $\frac{2 \times 150 \mu\text{m}}{380 \mu\text{m}}$ DFT

Marking of paint systems: TE56-SFS 5873/R25.04 EP100/1-FeSt2

**COLOURS**

The product 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.  
 TEMAWELD ZSM, zinc silicate

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<b>SURFACE PREPARATION</b>	Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4)  <b>Steel surfaces:</b> Remove rust by tool cleaning to minimum St2 or blast clean to Sa2½. Blast clean to grade Sa2½ for immersion. (ISO 8501-1)
<b>APPLICATION CONDITIONS</b>	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, paint and surface should be a minimum of + 10 °C. The relative humidity should not exceed 80 %.
<b>APPLICATION</b>	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.
<b>MAINTENANCE PAINTING</b>	<b>Maintenance</b> Touch-up painting is sufficient for maintenance when the rust grade is Ri1 - Ri3. (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. (SFS-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.  <b>Repainting</b> 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.
<b>PRODUCT INFORMATION</b>	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 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.

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.