



Fontedur HB 80 - Water-borne polyurethane topcoat

DESCRIPTION

A two-component, water-borne polyurethane topcoat.



PRODUCT FEATURES

Suitable to be used as a topcoat for epoxy/polyurethane systems in steel surfaces exposed to weathering, abrasion and chemical stress.

Recommended uses

Steel surfaces.

TECHNICAL DATA

Features

A durable, easy to clean and non-chalking topcoat with excellent gloss and colour retention in climatic stress. Can be cured at higher temperatures. Recommended to be used for agricultural and earth moving machinery, steel framework and other steel structures, machinery and equipment.

Colour Cards

RAL, NCS, SSG, BS, MONICOLOR NOVA and SYMPHONY colour cards. TEMASPEED FONTE tinting.

Gloss groups

Gloss

Coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
40 µm	90 µm	11.2 m ² /l
60 µm	135 µm	7.5 m ² /l
80 µm	180 µm	5.6 m 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 2.5 parts by volume 156-series
Hardener 1 part by volume 008 7605

Application method

By air-assisted airless or conventional spray.

Pot-life (+23°C)

1 h

Drying times

DFT 40 µm	+ 15 °C	+ 23 °C	+ 60 °C
Dust dry, after	6 h	1 h	45 min
Touch dry, after	8 h	2 h	1 h
Recoatable, min. after	24 h	2 h	1 h

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



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Solids volume	45 ± 2 volume % 60 ± 2 weight %
Density	Approx. 1.3 kg / l mixture
Product code	156-series

APPLICATION DETAILS

Application conditions	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)
Preparation	All surfaces must be dry. The temperature of the ambient air, surface or paint should not fall below +15°C during application or drying. Relative humidity should not exceed 80%. The surface temperature of the steel should remain at least 3°C above the dew point.
Priming	Fontecoat EP 50, Fontecryl 10 and Fontecryl AP.
Finishing	Fontedur HB 80.
Painting	By air-assisted airless or conventional spray. Depending on the application method the paint can be thinned 0-10%. At air-assisted airless spray application the paint should be thinned 0-5% with water, nozzle pressure 160 - 200 bar, atomizing pressure 1-2 bar, nozzle tip 0.011"-0.013". Spray angle shall be chosen according to the shape of the object. At conventional spray the paint should be thinned 3-10%, atomizing pressure 3-4 bar, nozzle 1.4-1.8 mm.
Mixing of components	First stir base and hardener separately. The correct proportions of base and hardener must be mixed thoroughly before use. Use T emaspeed Squirrel Mixer for mixing. Insufficient mixing or incorrect mixing ratio will result in uneven drying of the surface and weaken the properties of the coating.
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 155 g/litre of paint. VOC content in paint (mixed 10 % of water) is 145 g/litre of paint. 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  [Fontedur HB 80](#)

Hardener safety data sheet  [Fontedur HB 80](#)



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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.

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