

# Technical Data

## Jotacoat Tiecoat



### Product description

Jotacoat tiecoat is a low temperature cure two-pack corrosion preventing epoxy tie coat. It has a good adhesion and a good compatibility with top coat paint.

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### Recommended use

Steel work in general, usually used in combination with an epoxy and polyurethane system.

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### Film thickness and spreading rate

	Minimum	Maximum	Typical
Film thickness, dry (µm)	70	125	100
Film thickness, wet (µm)	108	193	154
Theoretical spreading rate (m <sup>2</sup> /l)	9,3	5,2	6,5

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### Physical properties

Colour	Cream/Grey/Limited color
Solids (vol %)*	65 ± 2
Flash point	27°C ± 2 (Setaflash)
Gloss	Flat
Water resistance	Good
Abrasion resistance	Good
Solvent resistance	Good
Chemical resistance	Good
Flexibility	Good

\*Measured according to ISO 3233:1998 (E)

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### Surface preparation

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504.

#### Other surfaces

The coating may be used on other substrates. Please contact your local Jotun office for more information.

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### Condition during application

The temperature of the substrate should be minimum -5°C and at least 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. Good ventilation is required in confined areas to ensure proper drying. The coating should not be exposed to oil, chemicals or mechanical stress until cured.

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## Application methods

<b>Spray</b>	Use airless spray
<b>Brush</b>	Recommended for stripe coating and small areas, care must be taken to achieve the specified dry film thickness.

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## Application data

<b>Mixing ratio (volume)</b>	5 parts Comp. A (base) to be mixed thoroughly with 1 part Comp. B (curing agent).
<b>Pot life (23°C)</b>	5 hours (Reduced at higher temp.)
<b>Thinner/Cleaner</b>	Jotun Thinner No. 17
<b>Guiding data airless spray</b>	
<b>Pressure at nozzle</b>	15 MPa ( 150 kp/cm <sup>2</sup> , 2100 psi)
<b>Spray angle</b>	0.53-0.78 mm (0.021-0.031")
<b>Filter</b>	40-80°
<b>Note</b>	Check to ensure that filters are clean.

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## Drying time

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

- \* Good ventilation (Outdoor exposure or free circulation of air)
- \* Typical film thickness
- \* One coat on top of inert substrate

<b>Substrate temperature</b>	<b>5°C</b>	<b>10°C</b>	<b>23°C</b>	<b>40°C</b>
<b>Surface dry</b>	6 h	4 h	2 h	1 h
<b>Through dry</b>	24 h	18 h	12 h	8 h
<b>Dry to recoat, minimum</b>	24 h	18 h	12 h	8 h
<b>Substrate temperature</b>	<b>-5°C</b>			
<b>Surface dry</b>	10 h			
<b>Through dry</b>	36 h			
<b>Dry to recoat, minimum</b>	36 h			
<b>Dry to recoat, maximum</b>				

- 1 In case of multi-coat application, drying times will be influenced by the number in sequence and by the total thickness of previous coat applied - reference is made to the corresponding system datasheet.
- 2 Recommended data given for recoating with the same generic type of paint.

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

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## Typical paint system

Paint system:

Jotamastic NB	1 x 125µm	(Dry Film Thickness)
<b>Jotacoat Tiecoat 1 x 100µm</b>		<b>(Dry Film Thickness)</b>
Hardtop AS	1 x 50µm	(Dry Film Thickness)

Other systems may be specified, depending on area of use

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## Storage

The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed.

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## Packing size

12.5 ltr. Comp. A and 2.5 ltr. Comp. B (curing agent).

Packing may vary from country to country according to local requirements.

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## Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

**For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Material Safety Data Sheet.**

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## DISCLAIMER

*The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, we cannot guarantee anything but the quality of the product itself. We reserve the right to change the given data without notice.*

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