

Jotatop LEP Tiecoat

Product description

This is a two-component modified epoxy coating. It is a fast-drying product with good adhesion property. To be used as a tiecoat for leading edge areas of wind turbine blades. Developed for improving the adhesion of Jotatop LEP Pro on various type of substrates, such as glass/carbon fiber reinforced epoxy and/or polyester composite substrate, as well as on other primers or topcoats such as Jotatop BC100, Jotatop BC300WF. Jotatop LEP Tiecoat must be applied in the LEP area prior to Jotatop LEP Pro.

Typical use

Protective:
Specially designed as tiecoat for protection of the leading edge of wind turbine rotor blades.

Colours

Clear

Product data

Property	Test/Standard	Description
Solids by volume		35 ± 2 %
Solids by weight	calculated	41 ± 2 %
Gloss level (GU 60 °)	ISO 2813	glossy (70-90)
Flash point	ISO 3679 Method 1	24 °C
Density	calculated	1 kg/l

Region	Regulation	Test Standard	VOC Value
China	GB 30981-2020 Limit of harmful substances of industrial protective coatings	GB/T 23985-2009 8.3	592 g/l

The provided data is typical for factory produced products, subject to slight variation depending on colour.

Gloss description: According to Jotun Performance Coatings' definition.

Film thickness per coat

Typical recommended specification range

Dry film thickness	20 - 40	µm
Wet film thickness	57 - 115	µm
Theoretical spreading rate	17.2 - 8.6	m ² /l
Theoretical spreading rate	16.8 - 8.4	m ² /kg

Surface preparation

Surface preparation summary table

Substrate	Surface preparation	
	Minimum	Recommended
Coated surfaces	Coated surface must be fully cured before initiating the surface preparation. The surface shall be hand or machine abraded with non-metallic abrasives or bonded fibre machine or medium to fine abrasive paper with grit P80-P120 to impart a scratch pattern to the surface.	Coated surface must be fully cured before initiating the surface preparation. The surface shall be hand or machine abraded with non-metallic abrasives or bonded fibre machine or medium to fine abrasive paper with grit P80-P120 to impart a scratch pattern to the surface.
Composite	Composites must be fully cured before initiating the surface preparation. The surface shall be hand or machine abraded with non-metallic abrasives or bonded fibre machine or medium to fine abrasive paper with grit P80-P120 to impart a scratch pattern to the surface.	Composites must be fully cured before initiating the surface preparation. The surface shall be hand or machine abraded with non-metallic abrasives or bonded fibre machine or medium to fine abrasive paper with grit P80-P120 to impart a scratch pattern to the surface.

Application

Application methods

The product can be applied by

Spray:	Use conventional spray.
Brush:	Recommended. Use high-quality natural brushes (such as badger or ox hair). Care must be taken to achieve the specified dry film thickness.
Roller:	Recommended. Use short hair or flocked foam roller to achieve good leveling performance, and reduce orange peel on the surface.

Product mixing ratio (by weight)

Jotatop LEP Tiecoat Comp A	4 part(s)
Jotatop LEP Tiecoat Comp B	1 part(s)

Thinner/Cleaning solvent

Thinner: Jotun Thinner No. 73

Drying and Curing time

Substrate temperature	10 °C	23 °C	40 °C
Surface (touch) dry	1 h	30 min.	15 min.
Walk-on-dry	19 h	8 h	4 h
Dry to over coat, minimum	1 h	30 min.	15 min.
Dried/cured for service	10 d	7 d	3 d

For maximum overcoating intervals, refer to the Application Guide (AG) for this product.

Surface (touch) dry: The state of drying when slight pressure with a finger does not leave an imprint or reveal tackiness.

Walk-on-dry: Minimum time before the coating can tolerate normal foot traffic without permanent marks, imprints or other physical damage.

Dry to over coat, minimum: The recommended shortest time before the next coat can be applied.

Dried/cured for service: Minimum time before the coating can be permanently exposed to the intended environment/medium.

Induction time and Pot life

Paint temperature	23 °C
Pot life	6 h

Packaging (typical)

	Weight	Size of containers (litres)
Jotatop LEP Tiecoat Comp A	0.8 kg	1
Jotatop LEP Tiecoat Comp B	0.2 kg	0.5

The volume stated is for factory made colours. Note that local variants in pack size and filled volumes can vary due to local regulations.

Storage

The product must be stored in accordance with national regulations. Keep the containers in a dry, shaded, cool, well-ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.

Shelf life at 23 °C

Jotatop LEP Tiecoat Comp A	24 month(s)
Jotatop LEP Tiecoat Comp B	24 month(s)

In some markets commercial shelf life can be dictated shorter by local legislation. The above is minimum shelf life, thereafter the paint quality is subject to re-inspection.

Caution

This product is for professional use only. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly and according to Jotun's technical documentation. Applicators and operators shall use appropriate personal protection equipment when using this product. This guideline is given based on the current knowledge of the product. Any suggested deviation to suit the site conditions shall be forwarded to the responsible Jotun representative for approval before commencing the work.

Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not inhale spray 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.

Colour variation

When applicable, products primarily meant for use as primers or antifoulings may have slight colour variations from batch to batch. Such products and epoxy based products used as a finish coat may chalk when exposed to sunlight and weathering.

Colour and gloss retention on topcoats/finish coats may vary depending on type of colour, exposure environment such as temperature, UV intensity etc., application quality and generic type of paint. Contact your local Jotun office for further information.

Disclaimer

The information in this document is given to the best of Jotun's knowledge, based on laboratory testing and practical experience. Jotun's products are considered as semi-finished goods and as such, products are often used under conditions beyond Jotun's control. Jotun cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Jotun reserves the right to change the given data without further notice.

Users should always consult Jotun for specific guidance on the general suitability of this product for their needs and specific application practices.

If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail.