

**Product code:**

649-051 :part A

649-052 :part B

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**General description:** Two-component, epoxy polyamide polyurethane modified primer, with excellent adhesion to galvanized steel, aluminum and stainless steel.

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**Product Features:**

- A primer for galvanized steel, stainless steel and ferrous metal for synthetic top-coats (e.g., Super Durable Top-Coat) and epoxy and polyurethane top-coats (e.g., Tamaglass). Blasting of ferrous metal is recommended
  - Suitable for marine and industrial environment.
  - Two component paints can be applied on this primer at any time without maximum time limitation.
  - Resistant to maximum constant dry heat up to 110°C
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**Recommended Uses:** Protects metal structures in industrial or sea-shore environments

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**Technical Data:**

**Shade:** Beige, additional colors available upon request

**Gloss at 60°:** Matt-silk

**Solids percentage in volume:** 50±2%

**Dry film thickness per layer:** 50-75 micron

**Calculated coverage per layer\* (sqm./liter):** 6.3-16.3 – in the above thicknesses

**Recommended thinner:** Thinner 4-100

**Mixing ratio by volume:** part A : part B = 9.5:1

**Shelf life\*\*:** 24 months

**Drying times (hours):**

Drying method	5° C	15° C	25° C	40° C
Dry to touch	8	4	2	1
Hard Dry	16	10	5	2

<b>Minimum waiting time between coats</b>	60	32	16	8
<b>Maximum waiting time between coats</b>	Extended	Extended	Extended	Extended

### Pot life after mixing (hours):

	<b>5° C</b>	<b>15° C</b>	<b>25° C</b>	<b>40° C</b>
<b>time</b>	30	16	8	3

### Surface preparation and system recommendation:

**Application on galvanized metal and aluminum:** completely remove white acids. To remove grease and foreign impurities use various detergents such as Ecoclean 2230 by "GES" accompanied by rinsing with tap water and waiting for complete drying or use thinners such as thinner 1-32 manufactured by Tambour. In case of the use of chemicals wait until surface is fully dry and neutral. Mechanical roughening should be performed using spray granules or by sanding to a depth of 10-15 microns, at least until full haziness of the original look. Recommended primer thickness for these substrates about 60-100 dry microns.

**Steel:** Surface preparation to grade Sa-2.5 according to the Swedish Standard and roughness depth of at least 40 microns according to system conditions. The painted surface should be free of dirt, oil, grease, dust and any other foreign matter.

**Stable rust - partial preparation:** Remove loose rust by mechanical means up to a grade of St-2, at least until obtaining stable rust. Layers of loose paint should be removed using mechanical cleaning, preferably using standard spraying granules. Layers of stable paint must be roughened (sanding) to a depth of at least 30 micron until absolute haziness of the original look. Also suitable for damp surfaces (not wet). May also be used as primer for old epoxy and polyurethane paints such as: Solkot, Polichemcure Ecogalss, Tamglass or Tamglass HS after the above preparation process.

## Application:

Painting method	Inlet pressure atmospheres	Spraying pressure PSI	Nozzle diameter	Recommended percentage thinning with 4-100 thinner
Brush/roller			-	5%
Spraying with air gun – up to 60 microns per layer	3-4			10-15%
Airless spraying with a compression rate of at least 1:35	4-5	2000-3000	0.021" - 0.023"	0-5%

\* Before painting mix Part A and Part B separately and bring to uniformity. Do not leave sediment at the bottom of the packaging. Pour Part B in to Part A slowly and stir to uniformity with air mixer only for at least 1 minute until full uniformity.

4-100 thinner may be added as recommended in the table above.

**Thinner for Cleanup:** 4-100 thinner.

**Notes regarding painting:** Ensure appropriate ventilation conditions. Application shall be done in a temperature of above 5<sup>o</sup> C. Maximum metal temperature 35<sup>o</sup>C. Maximum product temperature before spraying: 30<sup>o</sup>C. Maximum permissible humidity up to 85%. Do not apply at temperatures lower than 3<sup>o</sup>C above dew point.

**System compatibility:** Topcoat: epoxy or polyurethane, such as Epitamarin Solekote, Multipoxy or Tamaglass

Recommended epoxy polyurethane system: Epogal at a thickness of 50-70 microns, 16 hour to 3 month interval before application of Tamaglass at a thickness of 50 microns.

Recommended "combined" system Epogal primer and a synthetic top-coat: 4-16 hours\*\* interval before application of Super Durable top-coat.

Epogal is not suitable as a primer for synthetic paints diluted with turpentine.

**Cautions:** Application and use of the product should be done in accordance with the Israeli Safety, Health and Environmental regulations. Read the safety instructions and warnings on the safety data sheet – which may be obtained from the Tambour Safety Department – Phone: 04-9877483 and on the product label.

Keep away from fire and sparks. Non-edible. Allow adequate ventilation of the workplace. When spraying do not inhale fumes. Use appropriate protective measures, refer to the Safety Data Sheet.

**General notes:** The data presented are based on experience and knowledge accumulated over the years. We reserve the right to update and/or change it without notice. Obtaining the desired results is contingent upon correct product application while adhering to instructions of use. Please ensure you check before applying the product that it is indeed designed for the intended usage and that the surfaces to be painted are properly prepared to apply the product.

\* Actual coverage depends on several factors: the surface, the application method, paint's shades, the painter's skill and weather conditions at the site. It is customary to assume that it accounts for about 75% of the calculated coverage.

\*\* At 25°C and 65% relative humidity.

Manufactured by Tambour, a company with a quality assurance system that meeting the requirements of Israeli Standards ISO 9001, ISO 18001, ISO 14001 and accredited by the Israel Institute of Standards in compliance with them.