

Product code:

464-xxx

General description: Synthetic, one-component, high build paint, used as a primer and top-coat for direct application on ferrous metal, galvanized steel and aluminum.

Product Features:

- Used as an all in one coat primer and top coat.
 - Fast drying.
 - Suitable for direct application on galvanized steel, ferrous metal and aluminum.
 - Good resistance to corrosion and high exterior durability.
 - Enables application of a single coat up to 60 microns.
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Recommended Uses:

- Provides a highly economical and quick application process, where same day application and transportation of metal objects is required.
 - Designed for bare metal and light maintenance application on ferrous metal constructions and galvanized objects (including stable treated rust to ST-2 class) in an urban and light industry environments.
 - Prevent direct contact of this product with chemicals, acid or alkali and application on concrete.
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Technical Data:

Shade: Tambour Industrial shade card/ RAL colors range

Gloss at 60°: above 50

Solids percentage in volume: 46±2%

Dry film thickness per layer: 40-60 micron (a final thickness of 100 microns can be obtain by applying "wet on wet" coats in 15 minutes intervals).

Calculated coverage per layer* (sqm./liter): 6-10 (according to coat thickness and color)

Recommended thinner: for spraying: 1-32; for brush: 18

Shelf life: 24 months

Drying times**:

	Time
Dry to touch	15 min
Minimum interval between coats	15 min
Final cure	12 hr
Dry to handle	1-2 hr

Surface preparation and system recommendation:

Steel: Surface preparation to grade Sa-2.5 according to the Swedish Standard and roughness depth of 30-40 microns according to system conditions. The painted surface should be free of dirt, oil, grease, dust and any other foreign matter. A salts test must be done at the water line. In long waiting times wash with fresh water and wait for complete drying.

Stable rust - partial preparation: Remove loose rust by mechanical means up to a grade of St-3, at least until obtaining stable rust. Layers of loose paint should be removed using mechanical cleaning, preferably using standard spraying granules. Old paint must be roughened (sanding) to a depth of at least 30 micron until absolute haziness of the original look.

Application on galvanized steel and aluminum: blast and roughen surface to a profile depth of 7-15 microns (blasting), until complete gloss removal. Where blasting is impractical, roughen surface mechanically. Surface preparation which excludes mechanical roughening shall reduce paint system durability up to immediate failure. In this preparation remove any zinc oxides, oils and any other foreign matter.

General: Where these treatments are impractical, ascertain removal of loose scales and oils from all metals, using a suitable thinner. Remove oxides from galvanized metal and aluminum using fresh water. This option is not a recommended alternative to the aforementioned treatments and should be used as the last resort.

Paint system:

A single application paint, used as both a primer and a top-coat. Apply another coat of MONOCOAT FD if needed. On stable rust 2 coats, 60 microns each at least.

Application:

Painting method	Spraying pressure atm	Nozzle diameter	Thinner	Recommended percentage thinning
Brush/roller		-	18	Up to 10%
Spraying with air gun – up to 60 microns per layer	3-5		1-32	Up to 15%
Airless spraying with a compression rate of at least 1:35	3-5	0.015" - 0.021"	1-32	Up to 7%

*Maximum unity is achieved by spraying. Good results by brushing will be achieved mainly on narrow surfaces (bars, railings etc.)

Thinner for Cleanup: 1-32 thinner or 18.

Notes regarding painting: Ensure appropriate ventilation conditions. Application shall be done in a temperature of above 50 C. Maximum metal temperature 350C. Maximum product temperature before spraying: 300C. Maximum permissible humidity up to 85%. Do not apply at temperatures lower than 30C above dew point.

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.