



Your Imagination...Our Paints.

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Tambour

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Painting Guide

Surface preparation for painting requires degreasing, removal of dirt, rust, mill-scale and peeling or cracking previous paint coats.

The degree of the required surface preparation depends on the object to be painted and the environmental conditions to which it will be subjected. The more severe the conditions, the more important it is to ensure that the surface is prepared properly and to maintain the highest quality of paint application at all stages. Since labour cost is the primary expense of any painting project, it is important to select the most suitable equipment, depending on the size, shape and location of the object to be painted.

Main Means of Application

Brushes, Rollers, Spray guns.

Advantages and Disadvantages

Designed for application as a topcoat of a paint system for industrial structures, such as exterior steel tanks, steel structures, equipment, galvanized steel, concrete and masonry surfaces in extreme corrosive environment of prolonged exterior exposure. Not intended for immersion.

Brushes

Are still considered as the most efficient means for painting relatively small surface areas. The brush is cheap, ensures economical paint consumption and its maintenance is cheap. However, it is a slow painting method and therefore costly, thus limited for small projects.

Brushes are Divided into Two Main Types

- Brushes with hog bristles - classic brushes. These are more expensive and used to perform "better" work, as painting doors or furniture, where an even surface, free from any brush strokes is required.
- Brushes with synthetic bristles - advantageous durability that enables usage for a longer time.

Handling Brushes

- A good brush should have tightly packed long bristles.
- The brush you use should suit best the painted surface.
- Before use, remove any loose bristles from a new brush.
- It is recommended to soak a new brush with hair bristles, before using, for two or three days in raw linseed oil.
- Dip only the tip of the brush in the paint.
- Remove any excessive paint from the brush by brushing it on the lip of the paint can.
- Clean brush immediately after the application is completed, first with a paint thinner and then with water and synthetic soap.
- Hang brush to dry with bristles pointing down.
- For prolonged storage, it is recommended to warp the brush with paper, gather the edges of the bristles into a pointed edge, but avoid bending the bristles. It is recommended to attach a moth deterrent to brushes with hair bristles.

Rollers

Suitable for painting large flat areas. Faster application than by brush. It is necessary to select the best suitable roller for the type of paint and surface to be painted. Rollers can be made from various materials with different length of hair;

For a Smooth Surface: use a roller with short hair (5 mm).

For Rough Surface: such as plaster, concrete, etc.: use a roller with medium hair (8-13 mm).

For Coarse Surface, such as coarse plaster, blocks, etc.: use a roller with long hair (18-35 mm).

The roller's handle can be extended to reach high surfaces and ceilings, which can hardly be done with a brush.

Spraying

A suitable method for quick painting of large areas, constructions, industrial installations and industrial finishing of manufactured products.

Main Spraying Methods

Regular spray, airless spray and electrostatic spray.

Regular Spraying Equipment

- a. Compressor: capable of supplying the air gun with approximately 425 liters of air per minute, at a pressure of 4-6 atmos.
- b. Filters: to prevent water and oil from penetrating with the air into the spray gun.
- c. Pipes: flexible and light to supply compressed air. When spraying from a distant paint container, paint supplying pipes to the spray gun are also required. These pipes are made of paint and thinner resistant material, with an internal diameter of at least 10 mm.
- d. Spray gun: produces a jet of atomized paint particles which are carried by a stream of air. Spray mode and amount can be adjusted to the requirements of the object to be painted.

Comments About the Spray Applicator

- a. Most paints are suitable for application by regular spray after thinning with an appropriate thinner.
- b. Spraying is usually performed at a distance of 20-25 centimeters from the painted object.
- c. Take into account a loss of 15-30% of the sprayed paint. Part of the loss is caused by particles of paint rebounding from the object and part from particles carried past the target by the air stream.
- d. Ensure the good health of the spray painter by providing good ventilation, extraction of solvent and paint during the spraying and by providing him/her with a suitable mask.
- e. Ascertain proper operation of the spraying equipment by conforming to the following rules:
 1. Immediately after spraying is completed, clean all equipment thoroughly and remove any paint residue. Clean spray gun by pouring through a sufficient quantity of thinner. Do not immerse the gun in the thinner as it will damage its seals. Clean the nozzle with a hair bristles brush or with a wooden tooth-pick only. Never use a pin or metal wire.
 2. Empty any water or oil in the compressor tank daily. Otherwise, the water or the oil may penetrate the paint through the pipes and damage it.
 3. Oil the leather seals in the spray gun from time to time, using one or two drops of lubrication oil.

Airless Spray

A pump that compresses the paint under a pressure of 100-200 atmospheres and then supplies it through a special pressure resistant pipe to the spray gun. Special interchangeable nozzles in the gun determine the type of "fan" created by the sprayed paint. Airless spray enables coverage of very large surface areas, in a short time and in a much thicker coat, that cannot be achieved by any other type of equipment. Since the paint is almost never thinned, it does not drip even on vertical surfaces. Very little paint is wasted in this application method, particularly when the fan is angled correctly in relation to the painted object. Before spraying, ensure correct grounding of the equipment, thus preventing accumulation of static electricity, which may cause flames and explosions. Take extra care to avoid injuring any person by a jet discharged from a gun when its nozzle is removed. This jet is discharged at a pressure of 100-200 atmospheres and may cause serious injury.

Electrostatic Spray

In this spraying method, particles of sprayed paint are loaded with electrical voltage of approximately 150,000 volts. These particles are attracted to the earthed object and coat it. This method enables application of paint on narrow bars, perforated surfaces and even netting, with nearly no loss. Electrostatic spraying can be performed without air, or with air, when paint is required to penetrate into corners. Special thinners are required for electrostatic spraying.

Purpose

Primer paints are applied as the first coat on a surface to be painted. Its purpose is to serve as a basis for good adhesion of the complete paint system.

Primer paints have an additional purpose – protection of metal from corrosion. Proper painting of metal objects, using a suitable system, reduces and even prevents damage caused by corrosion.

Selection of a Paint System Depends on

- The value of the object to be painted, its intended usage and the corrosive conditions it is required to resist.
- The type of the metal to be painted.
- The means and methods for preparing the metal for painting.
- The application method.

Classification of Primers According to Tie Coats

Alkyd Based Synthetic Primers

Quick drying. Careful surface preparation will ensure satisfactory results.

Chlorinated Resins Based Primers

Excellent resistance to acids. Very quick drying. Thorough surface preparation is essential. It is strongly recommended to clean by blasting. These paints are good where conditions hardly prevent moisture contact with the metal over prolonged periods of time and when it is important to perform the work quickly.

Primers Based on Epoxy Resins

The best possible surface preparation must be performed for these primers. Blasting to Sa2.5 (per ISO 8501 Standard) is recommended. Epoxy paints provide excellent resistance to humidity and various chemicals, high hardness and high-build application ability.

Primers for Stove Drying

Used for industrial painting of washing machines, refrigerators, ovens, etc. Based on special resins dedicated to this purpose.

Classification of Primers Based on Pigments

Anti-corrosive pigments are the unique properties of primers for metal; their chemical reaction reduces and even prevents corrosion.

The main anti-corrosive pigments in primers for metal are:

- Zinc chromate.
- Strontium chromate.
- Zinc phosphate.
- Zinc dust.

Primers based on Zinc Phosphate and Zinc Chromate

Suitable for application by a brush or spray, when proper precautions are taken. These primers are used to provide anti-corrosive protection of iron and steel, galvanized steel and light metals such as aluminum, magnesium and their alloys. Quick drying and humidity resistant Zinc chromate primers are recommended for aluminum. To protect magnesium against corrosion, chemical treatment is most important before applying the primer. For painting zinc, refer to the special leaflet for recommended paints and methods.

Primers based on Strontium Chromate

Usually two-component epoxy paints, used primarily by the aviation industry. In fast jet aircraft, two phenomena may occur: heating of the fuselage through air friction at low altitudes, and cooling at high altitudes. As a result of the latter, water vapor may condense on the warm paint. Strontium chromate

pigment primer is especially formulated for these conditions, but is not restricted to these conditions only and may be used for many other purposes.

Zinc Rich Primers

These primers are used for prolonged anti-corrosive protection of iron and steel. These primers contain a high percentage of metallic zinc and when applied on a thoroughly cleaned blasted surface (Sa3 (per Swedish Standard), a continuous coat of metallic zinc is formed, adhering to the steel and providing it with cathodic protection, similar to the protection provided by hot galvanizing. These paints endure outside exposure for very long periods without any top coat, on condition that the environment is not contaminated by any acidic or alkaline chemicals. Zinc-rich primers, based on epoxy resin or silicate bonder, are used to protect car underbodies, underwater installations and constructions exposed to severe corrosive conditions.

Cleaning the Metal in Preparation for Painting

Metal preparation before painting determines the durability and longevity of the paint system. The cleaning degree is determined by the type of service required of the object and according to the chosen paint system. Cleaning methods are numerous and varied, yet all have the same objective:

1. To remove oil, dirt, rust and other corrosive substances from the metal.
2. To produce an evenly roughened surface that will ensure maximum adhesion of the primer.

Mechanical Cleaning Methods:

With sandpaper, wire brush, hammers or blasting and spraying.

Chemical Cleaning Methods

Using suitable reagents by spraying or applications. Most chemical cleaning methods produce a passive coating on the surface of the metal.

Cleaning through aggregate spraying (blasting) (or spray) is proven and the best and most efficient cleaning method. It prolongs the life of the paint many times over, compared to cleaning with a steel wire brush.

Choosing a Primer

In conclusion, the choice of a primer, should also consider the existing basic facts, such as, budget and prices, restricting work conditions, time allowed for application, etc. The correct decision is made with due consideration of all the factors, striving to choose the most effective primer. Applying a double coat in thickness prolongs the paint durability by three to five years. Thorough cleaning of the metal by blasting and application of a double coat of suitable primer prolongs the life of the paint many times over, reducing maintenance costs to the minimum.

Standards and Specifications for Preparing Metal for Painting by Blasting

A summary of the standards and specifications of the American Council for Painting of Steel Structures (S.S.P.C.) for surface preparation by blasting and the corresponding Swedish Standards (S.I.S.) is detailed below.

Aggregate Blasting to White Metal

For paint systems where the object to be painted comes in direct contact with chemicals: S.S.P.C., Metal Blast Cleaning S.I.S. Sa3, or SP5-63-White; when metal surface is cleaned by blasting to white metal it has a uniform grey-white metallic color and its surface roughness is suitable for retaining and adhering paint. When the surface is inspected without magnification, it shall be completely free of oil, grease, dirt, milling scale, rust, oxides, paint or any other foreign matter.

Blasting to Near White Metal

For paint systems where the object comes in indirect contact with chemicals: S.S.P.C., Metal Blast Cleaning S.I.S. Sa3, or SP5-63-White; when metal surface is cleaned by blasting to near white specification and inspected without magnification, it shall be completely free of oil, grease, dirt and any other foreign matter. 95% of every 6 square cm of the surface will be free of milling scale, rust, paint or

any other foreign matter. Blemishes and slight scratches resulting from rust, milling scale or tiny flakes of paint attached to the surface are permitted. The color of the metal will not be completely uniform. Surface roughness is suitable for retaining the paint.

Commercial Aggregate Blasting

Applies to most paint systems used to paint objects subjected to light corrosive environment: Commercial Blast Cleaning, SP-63, or S.I.S. Sa2. The metal surface should be free of oil, grease, dirt or any other foreign matter. Remove scale, rust and scaling rust until obtaining the desired cleaning level, where small rust blemishes, remaining oxides, scaling or stubborn paint spots stick tightly to the surface may remain. For pitted surfaces, rust remnants or stubborn paint attached to the base of the digs and pits are permitted. At least two thirds of every 6 square mm of the surface shall be clean from any visible matter and only in the remaining third are slight blemishes permitted per the aforementioned standard.

Light Aggregate Blasting

Per Swedish standard specification S.I.S. – SA1. The surface shall be free from oil, dirt, rust scale, milling scale and flaking paint. Milling scale, rust and paint tightly attached to the surface may remain.

Notes

1. The resulting cleaning level is generally a direct result of the blasting intensity and duration over a surface unit. The cost of cleaning increases according to the cleaning level (blasting time).
2. Removing oil, grease, etc., must be performed by using thinners, **before blasting**.
3. Coarse rust scaling are removed by mechanical beating appliances, such as hammers and grinding and polishing tools **before blasting**.
4. Upon completion of dry blasting, clean the surface from dust and sand residue, collected in "pockets" and corners, using brushes, dry air jet or vacuuming.
5. Upon completion of wet blasting, clean the surface from any remnant spray compounds, by rinsing with water containing a rust inhibitor, using a brush or spraying means.
6. If rust reappears on the surface after blasting, blast this surface again before painting, to comply with the requirements of the standards or the specifications.
7. According to S.S.P.C., the depth of the metal's roughness suited for optimum paint retention is about 40-70 microns. (The depth of roughness is defined as the difference between the height of the highest peak on the surface and the depth of the lowest part).
8. Paint coat thickness on a roughened surface is defined as the minimal thickness above the peaks.
9. Apply paint onto surface, cleaned by blasting, as soon as possible after cleaning and no later than 4 hours after cleaning. When blasted surface is located in a corrosive environment, apply a primer coat immediately, to prevent instant rusting.

Paint Systems for Stoving

Industrial metal products, such as: Refrigerators, washing machines, mixers, ovens, metal furniture, machine parts, technical equipment and many other appliances and tools that require painting with stoving paint systems. These paints are designed for continuous, short, industrial processes. Sometimes you may apply primer and top-coat, wet-on-wet and stove both layers together. These paints provide specific resistance to weak chemicals and food products and are distinguished by excellent hardness, elasticity and adhesion to metal. These paints provide excellent finish with best appearance. You may apply the paint without a primer, provided that the metal is subjected to suitable chemical treatment, to obtain the best results.

Methods of Paint Application

First Painting

Painting an object that has never been painted before. The first application of paint must generally consist of a complete paint system (as indicated in the catalogue leaflets) and the required thorough surface preparation. Whenever you are free to choose the place and time to apply the paint, prefer

painting in a clean and dry environment (free of dust, smoke and industrial gasses) at temperatures ranging from 18°C-27°C (or as indicated in the paint specification). It is most beneficial to paint objects and accessories at their production place, especially if these are designed for service in severe corrosive conditions. Painting at the production site may be performed in optimal conditions, under supervision and guidance of the manufacturer or a representative, to ensure a resulting superior paint system, with extended longevity. Whenever a primer is applied to an object at the production site and the paint system is completed outside the production site, clean the painted object thoroughly of dust, salts, oil, rust and any other dirt accumulated during the elapsed time, before applying the next coat, to ensure good adhesion of paint coats. When an object is painted with a primer coat only, avoid, leaving it unpainted with a top-coat for any length of time, especially when the object is a steel installation designed for service in severe climatic conditions. Verify with **Tambour Technical Services** the maximum time allowed between application of the primer to application of the subsequent coats. Whenever two primer coats are required, each coat should be in a different color, as a means to distinguish between these coats during the application process. Endeavor to complete application of the entire paint system without allowing intervals between application of the paint coats, exceed the recommended intervals. Select only paints that are specifically designed for your purpose and ensure that the entire surface is coated by the required coat thickness and the required number of coats.

Surface preparation is highly important and determines the quality of the entire paint system. Application on a badly prepared surface, even when applying the best quality paint coats, is liable to weaken the entire paint system.

Maintenance Painting

General or partial painting of an object with a damaged former paint system. Sand and file all damaged paint down to a good coat or to clean (white) metal. Sand and file the good coat around the damaged area, to ensure that the newly painted surface will have a smooth appearance. If the former paint gave good service, it is preferable to continue using the same paint type. When applying a new paint type on old paint, apply it first on a small area and check whether the paint is compatible, namely, if the new paint does not attack the old one and if it adheres well. Before applying a coat on good, old paint, roughen and clean the surface first, to ensure good adhesion. It is generally recommended to apply a thinned primer coat of 20-25 microns, to ensure good penetration and adhesion to the old, sanded paint. Then proceed to apply a second, complete coat of primer.

SAFTY DATA SHEET

Application remarks

Stir well before application and while painting.

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product.

Warning

Never mix this material with others when not specifically recommended by us.

General comments

Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

* Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.

** At 25°C and 85% relative humidity.

Air Drying Time

Tested at 25°C, and relative humidity of 65%.

Coverage Rate Theoretical Spreading Rate

Area (in square meters) possible to cover with one liter of paint, for a given thickness, without any loss of paint during application.

Practical Spreading Rate

Area (in square meters) possible to cover with one liter of paint, for a given thickness, achieved in practice, depending on several factors: the surface quality, application method, worker's skill and weather conditions at the site.

Practical Spreading Rate Calculation Table

To calculate the practical spreading rate with higher precision, you may use the following table:

		Unpainted Steel				Painted Steel			
		New, with primer		Old, for repainting		New, blasting		Old, mechanical cleaning	
		Painting in closed area	Painting in open install	Painting in closed area	Painting in open install	Painting in closed area	Painting in open install	Painting in closed area	Painting in open install
Large Areas	Airless Spray	60-80	50-70	50-70	40-60	65-85	55-75	35-75	45-65
	Regular Spray	50-70	40-60	40-60	30-50	55-75	45-65	45-65	35-55
	Brush	50-80	50-80	50-70	50-70	50-85	50-85	45-75	54-75
Small Areas	Airless Spray	45-65	35-55	35-55	25-45	45-65	35-55	35-75	20-45
	Regular Spray	40-60	30-50	30-50	25-40	35-65	25-55	45-65	20-40
	Brush	60-95	60-95	60-95	50-95	60-95	60-95	45-75	50-85
Workshop	Airless Spray	10-20	10-20	10-20	10-20	10-20	10-20	10-20	10-20
	Brush	60-95	60-95	60-95	60-95	60-95	60-95	50-85	50-85

Large Areas: containers, plates, steel, ships, etc.

Small Areas: light constructions, piping, medium profiles, etc.

Workshop: steel frames, piping, small profiles, etc.

Shelf Life

The time period during which the paint remains in good condition while in its original, closed container, at a temperature of 20°C-25°C.

Pot Life

After mixing (two component product) – the time during which you can use the paint after mixing a two component product.

Reasons for Painting Galvanized Steel

- To “enhance and improve its appearance in the desired color for specific purposes, such as warning signs, signs, road marking or camouflage.
- To protect the galvanization coat in a corrosive environment, such as sea-water, cooling-water, acidic vapors, bases and various chemicals.

“Duplex” System

An integrated system, combining galvanization and paint, is the ideal solution for long-term protection of steel. The “Duplex” System has an aggregated synergetic effect on prolonging steel protection against corrosion. The “Duplex” System can almost double the life of a separate galvanization and a separate paint coat put together. It is important to note that paint adhesion to zinc differs from paint adhesion to steel or wood. Therefore, a special paint must be selected for application on zinc.

Successful Painting

The factors determining successful painting on galvanized steel are:

- Correct surface preparation.
- The choice of a zinc-compatible paint system.

Surface Preparation- Oils Removal

Similar to routine painting processes, the surface to be painted must be strictly clean and free of any grease, oil, dust, acids and any other foreign matter. Galvanized sheet metal is often marketed with an oily coating, which must be removed before painting.

Roughing: Sand the galvanized surface until complete removal of the gloss, up to a profile depth of 10 microns, at least. Act with caution when using soaps and detergents, since traces that may hinder adhesion of the paint to the metal are likely to occur. Rinse off any oil and grease, using a potent thinner. It is recommended to use **Ardrox G-551** solvent, made by Tambour Ecology, or **Detergent BC-70**, manufactured by Tambour Ecology (see separate leaflet).

Oxides Removal

Upon detecting oxides, remove by using **Paste for Removing Oxides Number 175**, manufactured by Tambour Ecology (see separate leaflet). For advice on correct application of this paste, call Tambour Ecology Technical Service, telephone 972-4-9853652.

Treatment of Steel with Defective Galvanizing

In galvanized steel with defective galvanization coating, where corrosion begins to set in, clean the rusted surface by light blasting before painting.

Tambour Paints for Galvanized Steel

Paints developed by Tambour especially for this purpose. Apply these paints directly on the galvanized product after cleaning thoroughly all dirt and oils and removing oxides. These paints were examined over a long period of time in accelerated anti-corrosive tests and in addition were exposed to industrial and marine environments.

Clarification

Data presented here is based on the best knowledge and experience of Tambour Ltd. No warranty is given or implied by our recommendations. The user must ensure, prior to application, that the recommended products and methods are suited to his requirements, to the work mode and to the prevailing conditions.

Heavy Maintenance

Heavy Maintenance

Two component epoxy & polyurethane paints designed to be used in heavy industrial & marine environments.

Designed for industrial application offering long term protection in harsh conditions, these paints provide high resistance in corrosive conditions.

This line includes paint which may be applied in high build coats (subject to the technical specifications), thus saving need for multiple coating material & work. This paint system offers an optional polyurethane finishing coat, to preserve the original color and gloss.

Epoxy EA 9

Epoxy polyamine primer, fast drying, to be used as a primer in marine atmosphere above and under water line, and in industrial environment and heavy industry.

Epitamarin solecoat, rustblock, multipoxy, polychmecure

Surface tolerant, epoxy paint system – high solid primer/topcoat. Suitable as a primer and topcoat over mechanical cleaned surface. May be applied

on steel, aluminum, galvanized steel & concrete.

Zinc rich epoxy HS SSPC

Two component, high-solids polyamide, zinc rich epoxy primer. Offers superior anti-corrosive cathodic protection. Primer for steel structures in a severe corrosive environment.

Inorganic zinc silicate

Two component zinc ethyl silicate type primer. Offers superior anti corrosive cathodic primer for protection of steel. Resistant to dry heat up to temperature of 450°C.

Tamaglass

Two component aliphatic polyurethane topcoat. Resistant to marine and industrial environment. Used as a topcoat on concrete floors. Long term retaining of color and gloss.

Tamaglass Super

Two component acrylic polyurethane topcoat. Long term retaining of color and gloss. Resistant to marine and industrial environment.



Epitamarin Solecoat Aluminium

EPOXY PRIMER 6030

Product code No.	575-100				
Product Description	Two-component, epoxy polyamide primer (part A and part B) for anti-corrosive protection of steel structures.				
Special features	Excellent resistance to alkaline solutions, diluted acids, aromatic and aliphatic solvents and oils. Resistant to dry heat up to 120°C (yellowing without affecting the protective properties may occur in prolonged constant heat).				
Suggested uses	Anti-corrosive protection of metal structures in light and heavy chemical industries or marine environment, above water line.				
Technical data					
Color	Red oxide.				
Gloss at 60°C	Matt.				
Solid content by volume	42%				
Recommended dry Film thickness	40 microns.				
Calculated spreading rate*	1.05 (sq. m/liter)				
Recommended thinner	4-100				
Touch dry**	4 hours.				
Hard coat**	24 hours.				
Dry to recoat	16-48 hours.				
Two pack product					
Mixing ratio by weight	A:B = 1:5.67.				
Mixing ratio by volume	A:B = 1:4				
Induction period before application**	30 minutes				
Pot life after mixing**	8 hours				
Shelf life**	24 Months.				
Surface preparation and specification					
Blast to Sa2.5 (per Swedish Standard). It is recommended to apply two coats and then cover with a suitable epoxy paint.					
Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			4-100	5%
	Regular spray	3-4	1.6	4-100	15-20%
	Airless spray	4-5	0.021"	4-100	10%
Cleaning thinner	4-100				
Application remarks	Stir well before application and while painting.				
	Do not apply when temperature falls below 10°C.				
Caution, Warning & General comments					
See safety data sheet on page 9.					

EPOXY TOP-COAT 6031

Product code No.	Grey:575-420, White: 575-410				
Product Description	Two-component (part A and part B) epoxy polyamide top-coat.				
Special features	Excellent resistance to concentrated alkaline solutions diluted acids, aromatic and aliphatic solvents and oils. Excellent resistance to corrosion of sea-water, distilled water, tap water and sever climatic conditions. Resistant to dry heat up to 120°C (yellowing without affecting the protective properties may occur in prolonged constant heat). Extremely tough and wear resistant.				
Suggested uses	An epoxy top-coat in a system used to protect metal structures in chemical industry or in marine environment, above water line.				
Technical data					
Color	Grey, white				
Gloss at 60°C	Satin.				
Solid content by volume	48%				
Recommended dry					
Film thickness	40 microns.				
Calculated spreading rate*	12 (sq. m/liter)				
Recommended thinner	4-100				
Touch dry**	3-4 hours.				
Hard coat**	24 hours.				
Dry to recoat	18-48 hours.				
Two pack product					
Mixing ratio by weight	A:B = 1:6.61				
Mixing ratio by volume	A:B = 1:4				
Induction period before application**	30 minutes				
Pot life after mixing**	8 hours				
Shelf life**	24 Months.				
Surface preparation and specification	Apply Epoxy Topcoat 6031 over Epoxy Primer 6030, Strontium Chromate Epoxy Primer, or Epoxy Primer EA-9.				
Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			4-100	10-15%
	Regular spray	4-5	1.4	4-100	15-20%
	Airless spray	4-5	0.016-0.018"	4-100	0-15%
Cleaning thinner	4-100				
Application remarks	Stir well before application and while painting. Do not apply when temperature falls below 10°C. Available in various colors, per request, in quantities of 400 liters at least.				
Caution	Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet. Do not inhale fumes when spraying this product.				
Warning	Never mix this material with others when not specifically recommended by us.				
General comments	See safety data sheet on page 9.				

EPOXY TOP-COAT 6035

Product code No. 710-575

Product Description

Special features

Two-component (part A and part B), high-build, epoxy polyamide top-coat. Can be sprayed to a dry thickness of 150 microns in one coat. Extreme hardness and excellent resistance to wear. Good resistance to concentrated alkaline solutions, aromatic and aliphatic solvents and oils. Resistant to dry heat up to 120°C (yellowing without affecting the protective properties may occur in prolonged constant heat).

Suggested uses

An epoxy top-coat in a system used to protect metal structures in chemical industry or in marine environment, above water line.

Technical data

Color

Grey.

Gloss at 60°C

Satin.

Solid content by volume

45%

Recommended dry

Film thickness

75-150 microns.

Calculated spreading rate*

3-6 (sq. m/liter)

Recommended thinner

4-100

Touch dry**

8 hours.

Hard coat**

24 hours.

Dry to recoat

16-24 hours. Maximum time for over coating: 36 hours.

Two pack product

Mixing ratio by weight

A:B = 1:4.5

Mixing ratio by volume

A:B = 1:2.6

Induction period

before application**

30 minutes

Pot life after mixing**

8 hours

Shelf life**

24 Months.

Surface preparation and specification

Blast to Sa-2.5 (per Swedish Standard). Epoxy Primer 6030, or Epoxy Primer EA-9.

Paint application

Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
Brush/roller			4-100	5%
Regular spray	3-4	1.6	4-100	15%
Airless spray	4-5	0.018"-0.021"	4-100	5-10%

Cleaning thinner

4-100.

Application remarks

Stir well before painting and while painting.

Do not apply when temperature falls below 10°C.

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product.

Warning

Never mix this material with others when not specifically recommended by us.

General comments

See safety data sheet on page 9.

EPOXY PRIMER EA-9

Product code No.	649-020																				
Product Description	Two-component (part A and part B) anti-corrosive primer, based on special epoxy resins.																				
Special features	Excellent anti-corrosive protection and adhesion to steel and stainless steel (after blasting).																				
Suggested uses	Recommended for use as a primer for steel constantly in contact with petroleum products, water, oils, etc. Used as a primer in systems designed to provide protection from chemicals, and on railway cars industry. Suitable interior coating of petrol tanks in system EA-9/EA-5. This system is approved by the Paint Research Association (certificate 539/75) for interior coating of IDF jet fuel tanks, after passing tests required by the following specifications: 1.Paint System High Build – Interior of Bulk Fuel Tanks, Ministry of Defence, Great Britain – TS 10143. 2.British Petroleum – Test Methods for Tank Lining Materials.																				
Technical data																					
Color	Red oxide.																				
Gloss at 60°C	Matt.																				
Solid content by volume	41%																				
Recommended dry																					
Film thickness	50 microns.																				
Calculated spreading rate*	8.2 (sq. m/liter)																				
Recommended thinner	4-100																				
Touch dry**	1 hour.																				
Hard coat**	24 hours.																				
Dry to recoat	16 hours min., max. – 3 month.																				
Two pack product																					
Mixing ratio by weight	A:B = 12:1																				
Mixing ratio by volume	A:B = 9:1																				
Induction period before application**	30 minutes																				
Pot life after mixing**	8 hours																				
Shelf life**	24 Months.																				
Surface preparation and specification																					
Blast to Sa-2.5 (per Swedish Standard). EA-9 can be applied for two-component top-coats such as Epoxy Rust Block, EA-9 H.B., Multi-Poxy, Epitamarin solecoat, POLYCHEMCURE and Tamaglass.																					
Paint application	<table><tr><td>Method</td><td>Pressure (atm.)</td><td>Nozzle Orifice</td><td>Thinner</td><td>Thinning Volume (%)</td></tr><tr><td>Brush/roller</td><td></td><td></td><td>4-100</td><td>5-10%</td></tr><tr><td>Regular spray</td><td>4-5</td><td>1.6</td><td>4-100</td><td>15-20%</td></tr><tr><td>Airless spray</td><td>4-5</td><td>0.016"-0.018"</td><td>4-100</td><td>10-15%</td></tr></table>	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)	Brush/roller			4-100	5-10%	Regular spray	4-5	1.6	4-100	15-20%	Airless spray	4-5	0.016"-0.018"	4-100	10-15%
Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)																	
Brush/roller			4-100	5-10%																	
Regular spray	4-5	1.6	4-100	15-20%																	
Airless spray	4-5	0.016"-0.018"	4-100	10-15%																	
Cleaning thinner	4-100																				
Application remarks	Stir well before application and while painting. Do not apply when temperature falls below 10°C.																				
Caution ,Warning &																					
General comments	See safety data sheet on page 9.																				

EPOXY EA-9 - HB

Product code No.	Grey: 649-000, Metallic red: 649-010, Blue: 649-003				
Product Description	Two-component (part A and part B), high-build, epoxy paint, designed for application as both a primer and a top-coat in epoxy paint systems for constructions and steel structures, providing high anti-corrosive resistance.				
Special features	Suitable for airless spray in a single, dry thickness 150 microns thick coat. Good resistance to wear and mechanical damages. Resistant to dry heat up to 100°C. Approved for use in contact with drinking water.				
Suggested uses	Designed for application on metal structures in the chemical industry and in marine environment, swimming pools, drinking water tanks.				
Technical data					
Color	Light-grey RAL 7035, metallic red, swimming pools blue, cream.				
Gloss at 60°C	Matt.				
Solid content by volume	50%				
Recommended dry					
Film thickness	75-125 microns.				
Calculated spreading rate*	4-6.6 according to the aforementioned thicknesses. (sq. m/liter)				
Recommended thinner	4-100				
Touch dry**	2 hours.				
Hard coat**	24 hours.				
Dry to recoat	16 hours min. max. – unlimited (provided that the surface is absolutely clean.				
Two pack product					
Mixing ratio by weight	A:B = 11:1				
Mixing ratio by volume	A:B = 7:1				
Induction period before application**	15 minutes.				
Pot life after mixing**	5 hours.				
Shelf life**	24 months.				
Surface preparation and specification					
Ferrous metals: Blast to Sa-2.5 (per Swedish Standard).					
Aluminum: Alodine treatment.					
First coat - Epoxy EA-9 HB, metallic red, 125 microns dry thickness.					
Second coat - Epoxy EA-9 HB, grey RAL 7035, 125 microns dry thickness.					
Concrete and Swimming pools: complete removal of loose flakes and cement water. EPICATALAC Clear followed by 2-3 coats of Epoxy EA-9 HB.					
Do not use metallic red in drinking water tanks. White sediment may occur due to salt Sedimentation and exposure to sun without ejecting paint properties					
Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			4-100	Up to 5%
	Regular spray			4-100	15-20%
	Airless spray	5-6	0.023"	4-100	5-10%
Cleaning thinner	4-100				
Application remarks	Stir well before application and while painting. Do not apply when temperature falls below 7°C.				
Caution, Warning & General comments	See safety data sheet on page 9.				

EPOXY TA-9 HB

Product code No.	649-063
Product Description	Two-component, high-build, epoxy polyamide paint. Designed as a primer in epoxy paint systems for anti-corrosive protection.
Special features	Can be airless sprayed to a dry Film thickness of 125 microns in one coat. Good resistance to wear and mechanical damages.
Suggested uses	Designed for application on metal structures in the chemical industry and in marine environment.

Technical data

Color	Red oxide.
Gloss at 60°C	Matt.
Solid content by volume	47%
Recommended dry Film thickness	50-125 microns.
Calculated spreading rate*	3.1-9.4 (sq. m/liter)
Recommended thinner	4-100
Touch dry**	1-2 hours.
Hard coat**	16 hours.
Dry to recoat	8 hours min. for a 50 microns thick coat. For a 50-125 microns thick coat – 16 hours min. (provided that the surface is absolutely clean before application).

Two pack product

Mixing ratio by weight	A:B = 7:1
Induction period before application**	15 minutes
Pot life after mixing**	5 hours
Shelf life**	24 months

Surface preparation and specification

Ferrous metal: Blast to Sa-2.5 (per Swedish Standard). Epoxy TA9 can be applied as a primer for 2 components topcoats as: Epoxy rust block, epitamarin solecoat, multy-pxy, polychemcure and tamaglass

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			4-100	Up to 50%
	Regular spray	3	1.8	4-100	15-20%
	Airless spray	5-6	0.023"	4-100	5-10%
Cleaning thinner	4-100				

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product.

Warning

Never mix this material with others when not specifically recommended by us.

General comments

See safety data sheet on page 9.

**EPOXY POLYCHEMCURE****Product code No.** 649-xxx**Product Description** Two-component, high-build, epoxy paint, designed for application on metal without a primer after appropriate surface preparation. Suitable for application on concrete over a suitable primer.**Special features** High hardness, excellent anti-corrosive protection and chemicals resistant. Can be applied in a single, dry thickness 150 microns coat min., using regular airless equipment. For effective protection of metal, apply a 300 microns thick coat in two layers.**Suggested uses** Designed for application on metal structures in the chemical industry and in marine environment.**Technical data****Color** Grey RAL 7035, or RAL colors, per request.**Gloss at 60°C** Semi-gloss.**Solid content by volume** 75%**Recommended dry****Film thickness** 75-150 microns.**Calculated spreading rate*** 5-10 according to the aforementioned thicknesses. (sq. m/liter)**Recommended thinner** 4-100**Touch dry**** 4 hours.**Hard coat**** 24 hours.**Dry to recoat** 16 hours min.**Two pack product****Mixing ratio by weight** A:B = 1:1**Mixing ratio by volume** A:B = 1:1**Induction period****before application**** 30 minutes.**Pot life after mixing**** 6 hours.**Shelf life**** 24 months.**Surface preparation and specification**

Steel: Blast to Sa-2.5 (per Swedish standard). Can be recoated at any time with any epoxy paint or polyurethane (POLYCHEMCURE EA-9 HB, Tamaglass, Glazurit, etc.). In the event of recoating, ascertain chalking, oils and dirt removal and absence of corrosion on the surface.

Consult Tambour Technical Service on the recommended thickness and surface preparation of each specific project.

Concrete (floors and walls): Remove cement water and contaminants and roughen the concrete surface (about 100 microns at least). Apply one coat of EPICATALAC Clear or EPICATALAC H.S. Proceed to apply 1-2 coats of POLYCHEMCURE, per requirements.

Paint application

Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
Airless spray	5-6	0.023"	4-100	Up to 5%

Cleaning thinner 4-100.**Application remarks**

Stir well before application and while painting.

Do not apply when temperature falls below 7°C.

Caution, Warning &**General comments**

See safety data sheet on page 9.

RUST BLOCH

HIGH-BUILD EPOXY MASTIC PRIMER APPLIED ON RUST

Product code No. 649-800

Product Description Two-component high-build, epoxy, surface tolerant paint, designed for application over stable rust. Contains zinc-phosphate.

Special features Suitable for application in thick coats of 150 microns dry thickness per coat. Provides anti-corrosive protection to metal surfaces mechanically cleaned to ST-2 at least and to stable rust. Does not contain aluminum. Resistant to chemicals environment in heavy chemical industry. . Resistant to dry heat up to 120°C (color changes without affecting the protective properties of the film may occur in prolonged constant heat).

Suggested uses Designed for application as a primer and a top-coat on metal structures in corrosive environment. Can be applied on old synthetic, epoxy and phenol paints, after appropriate preparation.

Technical data

Color Grey RAL 7035, additional colors available upon request.

Gloss at 60°C Satin.

Solid content by volume 75%

Recommended dry

Film thickness 100-150 microns.

Calculated spreading rate* 5-7.5 respectively. (sq. m/liter)

Recommended thinner 4-100

Touch dry** 6-8 hours.

Hard coat** 24 hours.

Dry to recoat 16 hours min. max. 12 months.

Dry to dip 5 days at least.

Two pack product

Mixing ratio by weight A:B = 1:1

Induction period before application** 15 minutes

Pot life after mixing** 4 hours

Shelf life** 24 months.

Surface preparation and specification

Remove all dirt, oil, grease, dust and any other foreign matter. Remove loose rust mechanically to ST-2 and stable rust. Remove peeling paint coats mechanically, preferably by blasting. For best results, apply two 125 microns thick dry coats at least. Can be applied as a primer for synthetic, epoxy or polyurethane paints, such as Super Durable Top-Coat, POLYCHEMCURE or Tamaglass.

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Airless spray	3		4-100	10-20%

Cleaning thinner 4-100.

Application remarks

Stir well before application and while painting.
Maintain appropriate ventilation level.
Apply in temperatures above 10°C and 5°C above dew point.
Maximum allowed humidity – 90%.
Application in two coats makes drying and thickness control easier.

Caution ,Warning & General comments

See safety data sheet on page 9.

EPITAMARIN Solecoat

HIGH-BUILD MASTIC EPOXY PRIMER FOR APPLICATION ON RUST

Product code No.	843-463 Aluminum 843-458 Grey 843-473 Red Oxide 843-448 Black
Product Description	Two-component, surface tolerant high build and high solids epoxy for application on metal. Can be used as primer and top-coat after blasting or partial surface preparation.
Special features	Excellent anti-corrosive resistance in industrial and marine environment above and below the water line. Resistant to maximum constant dry heat up to 120°C (yellowing without affecting the protective properties of the film may occur in prolonged constant heat).
Suggested uses	Primer and top-coat on steel after mechanical cleaning to ST-2. Can be applied on old synthetic, epoxy and phenol paints. Epoxy Solecoat red & grey are approved for the carriage of edible products.

Technical data

Color	Aluminum, Red Oxide, Black, Grey 7023, Grey 9001.
Gloss at 60°C	Satin.
Solid content by volume	75%
Recommended dry film thickness	80-150 microns.
Calculated spreading rate*	5-9.4 respectively. (sq. m/liter)
Recommended thinner	4-100
Touch dry**	4 hours.
Hard coat**	24 hours.
Dry to recoat	12 hours min.; 90 days max.
Dry to dip	5 days at least.

Two pack product

Mixing ratio by weight	A:B = 1:1
Mixing ratio by volume	A:B = 1:1
Induction period before application**	15 minutes.
Pot life after mixing**	6 hours.
Shelf life**	24 months.

Surface preparation and specification

Remove contaminants, oil, dirt and salts. Remove loose rust and paint using a steel brush or other effective means to ST-2 per Swedish standard. Blasting to SA2.5 to achieve a profile of 60-70 microns is preferable. Apply one primer coat, 80-150 microns thick, per specification requirements. Can be applied as a primer for synthetic, epoxy and polyurethane paints, such as Super Durable Top-Coat (for synthetic paints, refer to recommended dry to recoat times), POLYCHEMCURE, Multi-Poxy and Tamaglass.

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			4-100	10-15%
	Regular spray	5-6	0.021"-0.023"	4-100	Up to 5%
	Airless spray	5	1.8	4-100	10-15%

Cleaning thinner 4-100

Application remarks

Stir well before application and while painting.
For optimal results, use airless equipment of 1:30 compression ratio at least

Caution ,Warning & General comments

See safety data sheet on page 9.

MULTI - POXY

SURFACE TOLERANT EPOXY MASTIC

Product code No.	640-499												
Product Description	Two-component, high-build and high solids, surface tolerant epoxy for heavy industry maintenance applications. Protects from wear, moisture and contact with chemicals. Suitable for application on stable rust, moist surfaces and old paint coats. Dries in a wide temperature range.												
Suggested uses	Designed for application in the heavy industry. Suitable for application on properly prepared concrete, poured concrete, steel structures, galvanized steel, machinery and equipment, tank exteriors and interiors, objects immersed in both fresh water and sea water. Note: These are typical uses and are not aimed at limiting the use of this product.												
Technical data													
Color	Grey, red oxide and RAL shades chart upon request. Epoxy paints fade after exposure to sunlight. Yellowing is normal in epoxy products. Use of machines that emit CO and CO2 during application may cause further yellowing.												
Bases (part A)	White, deep, clear bases.												
Curing agent (part B)	Quick – winter; slow – summer.												
Gloss at 60°C	Satin/ semi-gloss.												
Solid content by volume	82±2%												
Recommended dry film thickness	80-150 microns.												
Calculated spreading rate*	5.4-10 (sq. m/liter)												
Recommended thinner	4-100												
Mixing ratio	A:B = 2:1 by volume												
Thinning as needed	Airless 0-5%; air spray 5-20%; brush/roller 0-10%.												
Pot life after mixing**	With winter curing agent – 2 hours; summer curing agent – 3 hours.												
V.O.C.	166 g/liter												
Drying times	0°C	10°C	25°C	32°C									
Touch dry (hours)	20	10	5	3									
Hard coat (hours)	80	28	16	4									
Dry to recoat	<table><tr><td></td><td>Minimum</td><td>Maximum</td></tr><tr><td>Multi-Poxy/Multi-Poxy</td><td>9 hours</td><td>60 days</td></tr><tr><td>Multi-Poxy/Tamaglass</td><td>9 hours</td><td>60 days</td></tr></table> Dry to recoat time varies according to surface temperature, air motion, relative humidity and coat thickness.					Minimum	Maximum	Multi-Poxy/Multi-Poxy	9 hours	60 days	Multi-Poxy/Tamaglass	9 hours	60 days
	Minimum	Maximum											
Multi-Poxy/Multi-Poxy	9 hours	60 days											
Multi-Poxy/Tamaglass	9 hours	60 days											
Recommended top-coats	TAMAGLASS, TAMAGLASS SUPER												
Shelf life**	24 months.												
Surface preparation and specification													

Surface preparation and specification

Ascertain that all surfaces are clean, intact and free of any dirt, dust, waxes, oils, powders and any other contaminant that may affect adhesion of the new coat. The surface may be damp but not wet. Exposed surfaces must be treated correctly before product application.

Ferrous metal: Blast new metal to SA2.5 (per Swedish Standard), to obtain roughness depth of 30-50 microns. Paint the surface before rust forms on it. **Stable rust:** Where blasting is impractical, remove loose rust and iron oxides through mechanical filing to ST-2 at least. For immersion application purposes, blast all metal surfaces.

Galvanization and new aluminum surfaces: The only recommended surface preparation is surface roughening through light blasting to 15 microns profile depth at least. Use pressurized water to rinse dust and zinc salts and wait until completely dry. Use strong thinner (such as 4-100), or other suitable chemicals (Tambour Ecology) to rinse off oils. Surface preparation that does not include mechanical roughening may significantly affect system's durability.

MULTI - POXY (continued from page 41)

Surface preparation and specification

Surfaces with old paint: Hand or power washing to remove contaminants is recommended. Use degreaser to remove any oil. Rinse traces of cleaning agents thoroughly and dry the surface. Remove loose paint coats, rust and corrosion by scraping, blasting, (or another method) to ST2 at least (per Swedish Standard). We recommend using emery cloth to remove gloss of existing paint, to obtain matt gloss of this paint. We recommend application of a 30% diluted coat 40 microns thick, using thinner 4-100. After a sticky film is obtained, apply a full coat (wet on wet). Building surfaces (concrete): Cure new concrete for 30 days at least, at 22°C, before application. Completely remove cement water, level projections and mortar spatters. Rake mortar joints clean and remove soluble salts. Apply Epicatalac clear.

Paint application

Mix Part A (epoxy resin) and Part B (cure) according to the mixing ratio by volume, separately. Add part B to part A and mix. For optimal application, apply at 10-32°C. At temperatures exceeding 55°C, sagging may occur. Surface temperature must be 3°C above dew point at least. Spray/Airless spray: flush airless lines with thinner 4-100. Use only clean equipment. Thin only if needed, according to manufacturer's instructions. Apply a wet coat in even, parallel passes with 50% overlap to avoid bare areas and pinholes. Required nozzle orifice: 0.021"-0.023". Pressure: 2500-3000 PSI.

Shelf life

Application remarks

Store in protected, cooled area (above 10°C). Stir well before application and while painting. Do not apply when temperature falls below 10°C. Available in various colors, per request in quantities of 400 liters at least.

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product.

Warning

General comments

Never mix this material with others when not specifically recommended by us.

Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

*

Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.

**

At 25°C and 85% relative humidity.

MULTI-POXY ALUMINUM

SURFACE TOLERANT EPOXY MASTIC ALUMINUM

Product code No.	640-600
Product Description	Two-component, high-build and solids epoxy aluminum mastic for heavy industry construction and maintenance applications on a wide range of substrates. Protects from wear, moisture, corrosive fumes and contact with chemicals. Suitable for application on stable rust, moist surfaces and old paint coats. Dries in a wide temperature range. Contains aluminum particles that enhance its anti-corrosive resistance.
Suggested uses	Designed for application on heavy industry objects, steel constructions, galvanized steel, machinery and equipment, tank exteriors and interiors, objects immersed in fresh water, piping and damp and wet workshop surfaces. Note: These are typical uses and are not aimed at limiting the use of this product. This product is not suitable for potable water

Technical data

Color	Aluminum. Epoxy paints fade after exposure to sunlight. Yellowing is normal in epoxy products. Use of machines that emit CO and CO2 during application may cause further yellowing.			
Gloss at 60°C	Satin.			
Solid content by volume	82±2%			
Recommended dry film thickness	150-200 microns.			
Calculated spreading rate*	4.1-6.6 (sq. m/liter)			
Recommended thinner	4-100			
Mixing ratio by volume	A:B = 2:1			
Thinning as needed	Airless 0-5%; air spray 5-20%; brush/roller 0-10%.			
Pot life after mixing**	2-3 hours.			
V.O.C.	166 g/liter			
Drying times	0°C	10°C	25°C	32°C
Touch dry (hours)	20	10	4	2
Hard coat (hours)	80	28	16	10
Dry to recoat	Product	Minimum		Maximum
	Multi-Poxy/Multi-Poxy	9 hours		60 days
	Multi-Poxy/Tamaglass	9 hours		60 days
	Dry to recoat time varies according to surface temperature, air motion, relative humidity and coat thickness.			
Recommended top-coats	TAMAGLASS, TAMAGLASS SUPER..			
Shelf life**	24 months.			

Surface preparation and specification

Ascertain that all surfaces are clean, intact and free of any dirt, dust, waxes, oils, powders and any other contaminant that may affect adhesion of the new coat. The surface may be damp but not wet. Exposed surfaces must be treated correctly before product application.

Ferrous metal: Blast new metal to SA2.5 (per Swedish Standard), to obtain roughness depth of 30-50 microns. Paint the surface before rust forms on it. Stable rust: Where blasting is impractical, remove loose rust and iron oxides through mechanical filing to ST-2 at least. For immersion application purposes, sandblast all metal surfaces to ST-2.5 at least (per Swedish Standard).

Galvanization and new aluminum surfaces: The only recommended surface preparation is surface roughening through light blasting to

MULTI-POXY ALUMINUM (continued from page 43)

15 microns profile depth at least. Use pressurized water to rinse dust and zinc salts and wait until completely dry. Use a strong thinner (such as 4-100), or other suitable chemical detergent (Tambour Ecology) to rinse off oils. Surface preparation that does not include mechanical roughening may significantly affect system's durability.

Surface preparation and specification

Surfaces with old paint: Hand or power washing to remove contaminants is recommended. Use degreaser to remove any oil. Rinse traces of cleaning agents thoroughly and dry the surface. Remove loose paint coats, rust and corrosion by scraping, sandblasting, (or another method) to ST2 at least. We recommend using emery cloth to remove gloss of existing paint and roughen paint surface. We recommend application of a 30% diluted coat 49 microns thick, using thinner 4-100. After a sticky film is obtained, apply a full coat (wet on wet).

Paint application

Mix Part A (epoxy resin) and Part B (cure) according to the mixing ratio by volume, separately. Add part B to part A and mix. For optimal application, apply at 10-32°C. At temperatures exceeding 50°C, sagging may occur. Surface temperature must be 3°C above dew point at least.

Brush/Roller: Apply a full and even coat. To ensure sufficient coat thickness, we recommend application of two coats.

Spray/Airless spray: Flush airless lines with thinner 4-100. Use only clean equipment. Thin only if needed, according to manufacturer's instructions. Apply a wet coat in even, parallel passes with 50% overlap to avoid bare areas and pinholes.

Required nozzle orifice: 0.021"-0.023".

Pressure: 2500-3000 PSI.

Storage Caution

Store in protected area at temperatures ranging from 4-38°C.

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product.

Warning

Never mix this material with others when not specifically recommended by us.

General comments

Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

*

Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.

**

At 25°C and 85% relative humidity.

AFRAPOXY SLE

Product code No.	Red oxide 843-400										
Product Description	Solvent-free, high-build, epoxy polyamine.										
Special features	Applied up to a dry film thickness of 400 microns in one coat. Thus reducing labor costs and application times. High resistance to chemicals and extreme corrosive conditions.										
Suggested uses	High-build top-coat where superior protection from chemicals and wear, combined with high elasticity are required, such as objects and tanks subjected to constant vibrations, transported tankers, carriages, etc., sewage systems and perpetually wet and saline environments.										
Technical data											
Color	Red oxide and other colors per request (the original color may yellow upon exposure to light, without affecting the product's properties).										
Gloss at 60°C	Semi-gloss.										
Solid content by volume	92%										
Recommended dry film thickness	200-400 microns.										
Calculated spreading rate*	2.3-4.6 (sq. m/liter)										
Recommended thinner	4-100										
Touch dry**	6 hours.										
Hard coat**	24 hours.										
Dry to recoat	24 hours.										
Two pack product											
Mixing ratio by weight	A:B = 2:1										
Induction period before application**	15 minutes.										
Pot life after mixing**	1-2 hours.										
Shelf life**	24 months.										
Surface preparation and specification	Blast to Sa-2.5 (per Swedish Standard) and a 70 microns roughness at least. apply on primers such as: Epoxy Primer EA-9, Epitamarin solecoat, aluminum										
Paint application	<table><tr><td>Method</td><td>Pressure (atm.)</td><td>Nozzle Orifice</td><td>Thinner</td><td>Thinning Volume (%)</td></tr><tr><td>Airless spray</td><td>6</td><td>0.021"-0.036"</td><td>4-100</td><td>0-10%</td></tr></table>	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)	Airless spray	6	0.021"-0.036"	4-100	0-10%
Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)							
Airless spray	6	0.021"-0.036"	4-100	0-10%							
Cleaning thinner	4-100										
Application remarks	Stir well before application and while painting. Maintain required ventilation. Apply at temperatures above 10°C and 5°C above dew point. Maximum allowed humidity – 90%. Application in two coats makes drying and thickness control easier. Can be applied directly on Sa-2.5, but application over an epoxy primer yields better results. The film is relatively elastic and tends to change hue upon exposure to exterior light.										
Caution	Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet. Do not inhale fumes when spraying this product.										
Warning	Never mix this material with others when not specifically recommended by us.										
General comments	See safety data sheet on page 9.										

**AFRAPOXY SL-6****Product code No.** 577-065**Product Description****Special features**

Two-component (part A and part B), solvent-free, high-build epoxy coating. Excellent resistance to tap water, sea water, industrial treated water, various acids and alkalis. Superior resistance to crude oil, oils, kerosene. High resistance to wear and mechanical damage. Approved for contact with food and potable water.

Suggested uses

Protection of steel and concrete structures in the chemistry, oil and food industries. Designed to protect piping, water conduits and tanks, industrial effluents drainage systems. Formulated for application below water level at sea and in the Dead Sea. Airless spray application in 200-500 microns thick coats, thus reducing significantly both application costs and times.

Technical data**Color**

Light brown. Color changes when exposed to light without affecting its other properties.

Gloss at 60°C

Semi-gloss.

Solid content by volume

92%

Recommended dry**film thickness**

200-500 microns.

Calculated spreading rate*

1.8-4.6 (respectively) (sq. m/liter)

Recommended thinner

4-100

Touch dry**

3-4 hours.

Hard coat**

24 hours.

Dry to recoat

16-24 hours.

Two pack product**Mixing ratio by weight**

A:B = 2:1

Induction period**before application****

15 minutes.

Pot life after mixing**

2 hours.

Shelf life**

24 months.

Surface preparation and specification

Ferrous metals: Blast to Sa-2.5 (per Swedish Standard) to a depth of 5 microns at least and apply Epoxy Solecoat or Multi-Poxy.

Concrete: Roughen concrete surface and remove cement water and loose particles. Apply EPICATALAC Clear. Application of a 30-50 microns thick coat of Tamaglass top-coat retains color and recoatability for prolonged time.

Paint application

Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
Brush/roller			4-100	Up to 5%
Airless spray	5-6	0.023"	4-100	5-10%

Cleaning thinner

4-100

Application remarks

Stir well before application and while painting.

Do not apply when temperature falls below 10°C.

Note short pot life after mixing, especially at high temperatures.

Flush paint residue from equipment and pipes immediately after application is completed.

Caution , Warning & General comments

See safety data sheet on page 9.

NON-SKIDING PAINT

Product code No.	649-304				
Product Description	Two-component, epoxy coating, applied with addition of aggregates to provide a highly durable protective coat that prevents skidding.				
Special features	Conforms to military standard for anti-skid deck paint system, with 100% solids contents. Excellent durability and wear resistance properties. Long-term cosmetic appearance. U.V. resistance. Excellent protection against corrosion and chemicals. Undercutting resistant. Low solar absorption. Excellent non-skid performance on aircraft landing areas, tank decks, transport vehicles even in wet and oily conditions.				
Suggested uses	Designed for application on transport vehicles (military and civilian) skid's deck and potentially wet floors and decks, to prevent slipping and skidding.				
Technical data					
Color	Dust yellow (additional colors available upon request).				
Solid content by volume	100%				
Recommended dry film thickness	150-300 microns.				
Calculated spreading rate*	3.5-7 (sq. m/liter)				
Mixing ratio by volume	A:B = 3:1				
Pot life after mixing**	4 hours.				
Drying time					
Touch dry**	5 hours.				
Hard coat**	16 hours.				
Shelf life**	12 months.				
Surface preparation and specification	Remove oil and dirt. Blast to Sa-2.5 (per Swedish Standard), profile depth - 50 microns. Apply EPOGAL Primer, TAMAPOXY SP, EA-9 Primer, aggregates, Rust Block, Solecoat. For anti-skid system use anti-skid paint containing TAMAPOXY SP.				
Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			4-100	0-7%
	Airless spray	5-6	0.021"-0.036"	4-100	10-15%
Cleaning thinner	4-100				
Application remarks	Stir well before application and while painting. Maintain required ventilation conditions. Apply when temperature rises above 10°C and 5°C above dew point. Maximum allowed humidity – 90%. Application in two coats makes drying and thickness control easier.				
Caution	Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet. Do not inhale fumes when spraying this product.				
Warning	Never mix this material with others when not specifically recommended by us.				
General comments	See safety data sheet on page 9.				

ZINC-RICH EPOXY PRIMER H.S.

Per standard S.S.P.C.

Product code No. 576-130

Product Description Two-component, high solid zinc-rich, (part A + part B) epoxy primer. Conforms to composition and performance requirements of Steel Structure Painting Council (S.S.P.C.) Paint 20 standard.

Special features Superior anti-corrosive cathodic protection. Quick drying. Suitable as a welding primer. (in 20 microns D.F.T)

Suggested uses Primer for metal structures in severely corrosive environment.

Technical data

Color Dark grey.

Gloss at 60°C Matt.

Solid content by volume 62±2%

Recommended dry film thickness 60-75 microns.

Calculated spreading rate* 8.3-10.3 (sq. m/liter)

Recommended thinner 4-100

Drying times at 25°C

Touch dry** 15 minutes.

Hard coat** 24 hours.

Dry to recoat 4 hours min.; max. 21 days.

Two pack product

Mixing ratio by weight A:B = 12.6:1

Mixing ratio by volume A:B = 4:1

Induction period before application** 15 minutes.

Pot life after mixing at 25°C** 6 hours.

Shelf life** 12 months.

Surface preparation and specification

Paint system Blast to Sa-2.5 (per Swedish Standard) to achieve a 50-70 microns profile.

Used as a primer for epoxy and polyurethane top-coats, such as POLYCHEMCURE, Multi-Poxy, Soleccoat, Tamaglass.

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
Brush/roller				4-100	3-5%
Airless spray	4-5		0.021"-0.023"	4-100	0-10%

Cleaning thinner 4-100

Application remarks Stir well before application and while painting.

Do not apply when temperature falls below 10°C.

Caution Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product.

Warning Never mix this material with others when not specifically recommended by us.

General comments See safety data sheet on page 9.

ZINC SILICATE (INORGANIC)

Product code No. 477-040

Product Description Two-component (part A + part B) zinc-ethyl silicate-type primer. Forms a continuous layer of metallic zinc that provides cathodic protection to metal (as in hot galvanization).

Special features Superior anti-corrosive primer for protection of steel. Resistant to dry heat at temperatures up to 450°C.

Suggested uses In clean or mildly corrosive environments, may be applied in a single 75 microns thick coat. In acidic or alkaline environments, must be coated with a top-coat such as chlorinated rubber, vinyl, epoxy or Polyurethane.

Technical data

Color Bluish-Grey.

Gloss at 60°C Matt.

Solid content by volume 69%

Recommended dry

film thickness 75 microns.

Calculated spreading rate* 9.2 (sq. m/liter)

Touch dry** 5 minutes.

Hard coat** 6 months.

Dry to recoat 24 hours

Two pack product

Mixing ratio by weight A:B = 266:100

V.O.C. MIXED 298 g/liter

Shelf life** 12 months.

Surface preparation and specification

Blast to Sa-2.5 (per Swedish Standard) and profile of 25-50 microns. Apply one coat only. Dry film thickness of this product shall not exceed 120 microns, to avoid possible formation of "mud cracking".

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			280	5%
	Airless spray	5-6	0.021"	280	5%

Cleaning thinner 280

Application remarks Stir well before application and while painting.

This paint is supplied in two parts. Part A is the binder and part B is zinc powder. Start by mixing part A in a mechanical mixer, slowly add zinc powder and mix thoroughly until a homogeneous mixture, free of lumps, is obtained. Filter through a 30-mesh sieve before application.

When applying through airless spray, ascertain that the appliance suits this paint type, i.e., capable of resisting abrasion and equipped with a pressure pot and a stirrer. Do not apply when humidity is below 50%.

Top coating

The dried film of Zinc Silicate is very porous, containing a large amount of air in the pores. If it is top-coated, air may be entrapped or thinner may be released into the film, which may lead to blisters formation (boiling).

To avoid this, spray a diluted coat of the desired paint, diluted up to 30%, in the form of thin mist, to ensure maximum penetration into the pores of the Zinc Silicate film and expulsion of the entrapped air. Then a full top-coat, in the desired thickness may be applied.

Recoating aged zinc silicate. Flush with pressurized fresh water to remove deposited salts. Wait for complete drying and apply the recommended paint system.

ZINC SILICATE (INORGANIC) (continued from page 49)

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet. Do not inhale fumes when spraying this product.

Warning

General comments

Never mix this material with others when not specifically recommended by us. Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

* Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.

** At 25°C and 85% relative humidity.

INSTRUCTIONS FOR PROPER USE

Product Description

Two-component primer, designed for anti-corrosive priming of steel. The protection is provided by a continuous metallic film, which upon contact with ferrous substrate provides cathodic protection to the metal. The continuity of the zinc film is achieved through the extremely high content of metallic zinc particles and consequent low content of binder, thus creating the essential contact between the zinc particles.

Special properties and application

a. In clean or mildly corrosive environments, Zinc Silicate can serve as a single-coat protective primer, provided that the film thickness is 60 microns at least. Zinc metal is quickly attacked by highly acidic or alkaline environments or by immersion in sea-water. If the paint is intended for use in such environmental conditions, it is essential to top-coat it with a suitable chemical resisting top-coat (such as chlorinated rubber, vinyl, or epoxy).

b. Heat resistance: The binder of this primer is inorganic silicate. In contrast to organic binders in normal paints, this composition provides dry heat resistance up to 400-450°C.

Drying mechanism

The ethyl silicate based binder reacts after application with atmospheric moisture. This reaction increases the specific weight of the polymer while releasing organic fractions. After a few hours, depending on the relative humidity, an inorganic polymeric silica matrix is formed.

Surface preparation

Since this cathodic protection is based on an electro-chemical mechanism, it is essential to provide direct intimate contact between the coat and the metal. Even in the presence of a sound primer, other than Zinc Silicate (such as shop primer, it is essential to remove it completely. Prepare surface by blasting to near white metal (Sa-2.5 per Swedish Standard) for normal exterior resistance and to white metal (Sa 3) where the object is intended for immersion resistance. The desirable metal profile after sandblasting is 25-50 microns. Remove dust and other contaminants before application. Apply Zinc Silicate as soon as possible after cleaning to avoid rust onset and contamination. Never leave cleaned surface exposed overnight.

Paint preparation

To achieve high zinc particles content, work with a very low viscosity binder. Yet, as specific weight of zinc is very high, it tends to settle rapidly in thin medium. Therefore, the product is supplied in two parts. Ascertain that the packaging is tightly closed to prevent moisture penetration. Part A is the zinc powder (discard the small bag of desiccant inside the zinc powder before mixing part A with part B) is the binder and part B

ZINC SILICATE (INORGANIC) (continued from page 50)

Mixing procedure	Start stirring part A in a mechanical mixer. Add the zinc powder (part B) slowly into part A, while mixing. Rapid addition may cause lumps formation due to insufficient wetting of the pigment. Continue stirring until a completely homogeneous and smooth mixture is obtained. Strain through a 30-60 mesh sieve before application, to remove any lumps and granules. Thin, as needed, using only thinner 280 (about 10-30%, according to volume) and no other thinner.
Painting equipment	You can apply this paint using airless sprayers, designed to spray this product. Due to high wear rate, use sprayers with high wear resistance and a pressure pot with a mixer. Small areas may be painted by brush.
Application	This paint is very sensitive to application conditions and any deviation may cause surface defects described below.
Film thickness	Recommended dry film thickness is 75 microns in one coat. Do not apply dry thickness coats exceeding 120 microns to avoid spontaneous "mud cracking". Control applied wet thickness constantly, because it is very difficult to correct any deviation in film thickness, due to poor adhesion of the coats after the primer dries. Where dry thickness is lower than the recommended thickness, compensate during application of the following coats (chlorinated rubber, vinyl or epoxy). In case of mud cracking, remove loose coats and repair by applying a Zinc Rich Epoxy coat. It is best to perform this repair using a brush or by spraying a thinned coat, while avoiding unnecessary overlaps. In case of Over Spray, the painted surface is very rough and covered by a film; the paint is uneven and lacks mechanical properties. Remove the powdery spray with emery cloth and smooth the surface evenly. We then recommend rinsing with water.
Over spray	May occur due to several causes: a. Insufficient thinning. b. Excessive distance between the spray nozzles to the surface. c. Application during hot and dry weather or when the metal plate is very hot.
Drying conditions	As stated above, the drying mechanism is based on chemical reaction with water vapors in the air. Therefore, it is not recommended to apply this paint in relative humidity below 50% and at environmental temperatures over 40°C. When application must be performed at relative humidity below 50%, spray water mist on the surface after the paint is dry to touch (about 4 hours), to speed the paint's hardening. This paint requires 7 days of drying to develop maximum resistance to solvents. Do not apply when rain, heavy dew or frost are expected during or within two hours after application. Under correct conditions, the paint dries to touch after a few minutes and to treatment after 24 hours. Drying time for top-coating is 24 hours min.

ZINC GRAPHITE

Product code No. 477-020
Product Description Two-component (part A + part B) based on special resins that contain zinc and graphite. Conforms to Shell Company paint standards.

Special features Resistant to heat up to 250°C.

Suggested uses Painting chimneys.

Technical data

Color Dark grey.

Gloss at 60°C Matt.

Solid content by volume 60%

Recommended dry film thickness 75-100 microns.

Calculated spreading rate* 6-8 (sq. m/liter)

Recommended thinner Tambour mineral spirit.

Touch dry** 2 hours.

Hard coat** 24 hours.

Dry to recoat 16-24 hours.

Two pack product

Mixing ratio by weight A:B = 100:169

Induction period before application** No limits.

Pot life after mixing** 72 hours.

Shelf life** 24 months.

Surface preparation and specification

Blasting (preferable) or mechanical cleaning. Apply one even coat at the recommended D.F.T.

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			Tambour mineral spirit	0-5%

Cleaning thinner Tambour mineral spirit.

Application remarks Stir well before application and while painting.

Caution Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product.

Warning Never mix this material with others when not specifically recommended by us.

General comments Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

* Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.

** At 25°C and 85% relative humidity.

AROCOAT HB

Product code No. 640-060

Product Description Two-component (part A and part B), high-build, anti-corrosive paint, based on epoxy resins and coal tar.

Special features High-build paint for excellent anti-corrosive coating in marine and chemicals industry environments.

Suggested uses Designed for water towers, underground structures, drainage systems, effluents conduits. Interior coating of crude oil tanks, exterior coating for underground containers.

Technical data

Color Black.

Gloss at 60°C Semi-gloss.

Solid content by volume 64%

Recommended dry film thickness 200 microns.

Calculated spreading rate* 3.2 (sq. m/liter)

Recommended thinner 4-100

Touch dry** 7 hours.

Hard coat** 24-48 hours.

Dry to recoat 16-24 hours.

Two pack product

Mixing ratio by weight A:B = 100:88.

Mixing ratio by volume A:B = 1:1

Induction period before application** 30 minutes.

Pot life after mixing** 8 hours.

Shelf life** 24 months.

Surface preparation and specification

Ferrous metals: Blast to Sa-2.5 (per Swedish standard). Apply primer such as: Epoxy EA-9 or Epitamarin solecoat

Concrete: light blasting (preferable), steel brush cleaning or diluted acid treatment and waiting till completely dry. Primer: EPICATALAC CLEAR.

Paint application

Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
Airless spray	4-5	0.026-0.030" /65-80°	4-100	5-10%

Cleaning thinner 4-100

Application remarks

Stir well before application and while painting.

Do not apply when temperature falls below 10°C.

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product.

Warning

Never mix this material with others when not specifically recommended by us

General comments

See safety data sheet on page 9.

EPOTRAN 400

Product code No.	660-029
Product Description	Two-component (part A and part B), high-build and solids paint, based on epoxy resins and coal tar.
Special features	Provides excellent anti-corrosive resistance to marine and chemicals industry environments in one, high-build coat.
Suggested uses	Water reservoirs, steel constructions immersed in water, sewage systems, and underground tanks, concrete and steel, in urban and industrial usage.

Technical data

Color	Black.
Gloss at 60°C	Satin.
Solid content by volume	83±2%
Recommended dry film thickness	400 microns.
Calculated spreading rate*	2 (sq. m/liter)
Recommended thinner	4-100
Touch dry**	7 hours.
Hard coat**	24 hours.
Dry to recoat	16-24 hours.

Two pack product

Mixing ratio by weight	A:B = 1:1.2
Mixing ratio by volume	A:B = 1:1.1
Induction period before application**	30 minutes.
Pot life after mixing**	8 hours.
Shelf life**	24 months.

Surface preparation and specification

Steel: Blast to Sa-2.5 (per Swedish Standard) and apply EA-9 Primer or Epitamarin solecoat aluminum
Concrete: Light blasting or mechanical means to roughen concrete surface and remove cement water and loose layers. Apply over EPICATALAC
Clear while it is still tacky.

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Airless spray	5-6	0.021"-0.028"	4-100	Up to 3%

Cleaning thinner

Application remarks

Caution

Stir well before application and while painting.
Do not apply when temperature falls below 10°C.
Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product.

Warning

General comments

Never mix this material with others when not specifically recommended by us
See safety data sheet on page 9.

AFRALASTIC BLACK HE-55

Product code No.	577-096															
Product Description	Two-component (part A and part B), high-build paint, based on coal tar, epoxy and polyurethane. Solvents free.															
Special features	Highly flexible and elastic with about 150% relative elongation. Can bridge over normal stress cracks. Superior resistance to water, tap water, solutions and various chemicals.															
Suggested uses	Specifically suitable for coating concrete structures and other surfaces which tend to crack. Can also coat industrial structures, water and sewage facilities located above and underground.															
Technical data																
Color	Black.															
Gloss at 60°C	Satin.															
Solid content by volume	95%															
Recommended dry film thickness	250-500 microns.															
Calculated spreading rate*	1.9-3.8 (sq. m/liter)															
Recommended thinner	4-100															
Touch dry**	24 hours.															
Hard coat**	36 hours (possible slight stickiness disappears in final drying).															
Dry to recoat	24 hours.															
Two pack product																
Mixing ratio by weight	A:B = 2:1															
Induction period before application**	15 minutes.															
Pot life after mixing**	2 hours.															
Shelf life**	12 months.															
Surface preparation and specification																
Concrete surfaces: Smooth out bumps and break open air pockets. Remove loose material and smooth surface through mechanical means, preferably by blasting. Apply EPICATALAC Clear thinned 30-50% with 4-100 thinner. 2-3 hours later, while the EPICATALAC is still tacky, apply AFRALASTIC HE-55.																
Ferrous metals: Blast to Sa-2.5 (per Swedish Standard). Apply a coat of Epoxy Primer EA-9, 40 microns dry thickness or Epitamarin solecoat aluminum																
Paint application	<table><tr><td>Method</td><td>Pressure (atm.)</td><td>Nozzle Orifice</td><td>Thinner</td><td>Thinning Volume (%)</td></tr><tr><td>Brush/roller</td><td></td><td></td><td>4-100</td><td>Up to10%</td></tr><tr><td>Airless spray</td><td>5-6</td><td>0.023"-0.036"</td><td>4-100</td><td>5-10%</td></tr></table>	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)	Brush/roller			4-100	Up to10%	Airless spray	5-6	0.023"-0.036"	4-100	5-10%
Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)												
Brush/roller			4-100	Up to10%												
Airless spray	5-6	0.023"-0.036"	4-100	5-10%												
Cleaning thinner	4-100.															
Application remarks	Stir well before application and while painting. In winter, when temperature falls below 10°C, drying and final curing takes longer time.															
Caution	Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.															
Warning	Do not inhale fumes when spraying this product.															
General comments	Never mix this material with others when not specifically recommended by us See safety data sheet on page 9.															

AFRALASTIC WHITE 208/20

Product code No.	577-072
Product Description	Two-component (Part A + Part B), elastic, solventless, epoxy polyurethane paint.
Special features	Highly elastic. High elongation (150%) capacity. Covers normal stress cracks. Resistant to water, sea water and various chemical solutions. Seals concrete from water and gas penetration and prevents the corrosion process
Suggested uses	Especially suited for coating concrete structures and other surfaces liable to crack; for painting concrete columns bases (to prevent water penetration).

Technical data

Color	Off-white, other shades upon request.
Gloss at 60°C	Satin.
Solid content by volume	100%
Recommended dry film thickness	200-500 microns.
Calculated spreading rate*	2-5 (sq. m/liter)
Recommended thinner	4-100.
Touch dry**	7-8 hours.
Hard coat**	24-30 hours (slight stickiness is likely during the drying period).
Dry to recoat	16 hours min.
Shelf life**	12 months.

Two Pack Product

Mixing ratio by weight	A:B = 4:1
Induction period before painting**	15 minutes.
Pot life after mixing**	3-4 hours.

Surface preparation and specification

Concrete Surfaces: Grind bumps, break open air pockets, clean concrete spill and remove loose scales using mechanical means or light sandblasting (the later is preferable). Rinse off dust with a water jet and dry. Apply a coat of EPICATALAC diluted by 30% with thinner 4-100. Two hours later, (while the EPICATALAC is still tacky) apply AFRALASTIC 208/20

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			4-100	5-10%
	Airless spray	5	0.026"-0.030"/ 65-80"	4-100	Up to 10%

Cleaning thinner 4-100

Application remarks

Stir well before application and while painting.
In winter conditions, when temperatures fall below 10°C, allow longer drying and final hardening time.

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product.

Warning

General comments

Never mix this material with others when not specifically recommended by us
See safety data sheet on page 9.

EPOXY EP-2300

Product code No.	648-000				
Product Description	Two-component (part A+ part B), epoxy paint, based on epoxy resins and polyamides.				
Special features	This paint is approved for use in contact with potable water by: British Water Works Association (1963). National Water Council (U.K.) (1975). American Food and Drug Administration (FDA). Mekorot, Israeli Water Company. TAHAL, The Israel Water Planning Agency. Potable water and salt water conduits.				
Suggested uses					
Technical data					
Color	Red oxide.				
Gloss at 60°C	Glossy.				
Solid content by volume	56%				
Recommended dry film thickness	125 microns.				
Calculated spreading rate*	4.4 (sq. m/liter)				
Recommended thinner	4-100				
Touch dry**	1 hour.				
Hard coat**	16 hours.				
Dry to recoat	16-24 hours.				
Two pack product					
Mixing ratio by weight	A:B = 4.9:1.				
Mixing ratio by volume	A:B = 3:1				
Induction period before application**	15-30 minutes.				
Pot life after mixing**	8 hours.				
Shelf life**	24 months.				
Surface preparation and specification	Blast to Sa-2.5 (per Swedish standard). Apply 3 coats of Epoxy EP-2300 to obtain a 375 microns dry film thickness at least.				
Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Regular spray	4-5		4-100	15-20%
	Airless spray	4-5	0.016-0.018"/60°		4-100 Up to 5%
Cleaning thinner	4-100				
Application remarks	Stir well before application and while painting. Do not apply when temperature falls below 7°C.				
Caution	Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet. Do not inhale fumes when spraying this product.				
Warning	Never mix this material with others when not specifically recommended by us				
General comments	See safety data sheet on page 9.				

EPOXY EA-5 HS

Product code No. 644-510

Product Description Two-component (part A + part B), high-build, epoxy polyamine top-coat.

Special features Used as interior coating of fuel tanks. Approved by leading international oil companies. This paint system was approved by the Paints Research Association (certificate 539/75) for interior coating of jet fuel storage tanks, after passing the tests required by the specification.
Fuel tanks interior coating with an EA-9/EA-5 system.

Suggested uses

Technical data

Color Grey 9044

Gloss at 60°C Satin.

Solid content by volume 50%

Recommended dry

film thickness 150 microns.

Calculated spreading rate* 3.3 respectively. (sq. m/liter)

Recommended thinner 4-100

Touch dry** 3-4 hours.

Hard coat** 24 hours.

Dry to recoat 18-48 hours.

Two pack product

Mixing ratio by weight A:B = 5:1

Induction period before application** 30 minutes.

Pot life after mixing** 8 hours.

Shelf life** 24 months.

Surface preparation and specification

Apply Epoxy EA-5 paint on EA-9 primer.

Blast to Sa-2.5 (per Swedish standard).

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			4-100	5-10%
	Regular spray	4-5		4-100	15-20%
	Airless spray	4-5	0.021"-0.023"	4-100	5-10%

Cleaning thinner 4-100

Application remarks

Stir well before application and while painting.

Do not apply when temperature falls below 10°C.

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product.

Warning

Never mix this material with others when not specifically recommended by us

General comments

See safety data sheet on page 9.

WASH PRIMER MIL-C-8514

Product code No.	550-020
Product Description	Two-component (part A + part B) primer, based on vinyl resins and phosphoric acid. Provides phosphatization effect on metal.
Special features	Very quick drying. Forms a thin anti-corrosive protection layer. Excellent adhesive properties.
Suggested uses	Spray as a primer on aluminum and smooth ferrous metal (not recommended for application on galvanized steel).

Technical data

Color	Yellow.
Gloss at 60°C	Matt.
Solid content by volume	10% (A + B).
Recommended dry film thickness	7-10 microns (higher D.F.T may cause peeling).
Calculated spreading rate*	10 (sq. m/liter)
Recommended thinner	Thinner 5-9
Touch dry**	10 minutes.
Hard coat**	60 minutes.

Two pack product

Mixing ratio by weight	A:B = 1:4.
Mixing ratio by volume	A:B = 1:4
Pot life after mixing**	8 hours
Shelf life**	24 months.

Surface preparation and specification

Remove grease and oxides by chemical cleaning and apply one coat of Wash Primer.

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Regular spray	3-4			100%
	Brush	5-9	1.6"	5-9	100%

Ascertain thin coat application. Brush streaks may create thick areas.

Cleaning thinner 4-100

Application remarks

Stir well before application and while painting.
Ascertain application of one thin layer, at the recommended thickness.

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product.

Warning

General comments

Never mix this material with others when not specifically recommended by us

See safety data sheet on page 9.

EPITAMARIN UNISEAL Zn

Product code No. Brown:842-030, White: 842-036
Product Description Two-component (part A + part B), anti-corrosive epoxy primer with excellent adhesion to galvanized steel.

Special features Designed as a primer for metal and galvanized steel, for priming before application of chlorinated resins, vinyl, epoxy (not high-build) based top-coats and synthetic paints. You can apply two component epoxy and polyurethane paints on this primer at any desired time, without time limit. Approved for welding by DET NORSKE VERITAS.

Suggested uses Anti-corrosive primer for metal, galvanized steel and stainless steel (after sandblasting).

Technical data

Color Brown, white

Gloss at 60°C Matt.

Solid content by volume 31%

Recommended dry film thickness 20-30 microns.

Calculated spreading rate* 10.3-15.5 (sq. m/liter)

Recommended thinner 4-100

Touch dry** 15 minutes.

Hard coat** 24 hours.

Dry to recoat 2 hours min. (optional oven drying).

Two pack product

Mixing ratio by weight A:B = 10:1

Induction period before application** 30 minutes

Pot life after mixing** 12 hours

Shelf life** 12 months.

Surface preparation and specification

Ordinary ferrous metal: Blast to Sa-2.5 (per Swedish Standard).

Galvanized steel: Remove grease, rust and any foreign matter. Blast lightly. Cleaning with thinner 4-100 is recommended. Remove zinc oxide using Zinc Oxide Removal Paste No. 175, made by Tambour Ecology, or can be overcoated by: Super Durable Top-coat or two component top-coats, Epoxy EA-9 H.B, Multi-Poxy, PLOYCHEMCURE and Tamaglass.

Note: For large projects, testing adhesion of paint to the galvanization and surface preparation type before commencing application is recommended.

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			4-100	3-5%
	Regular spray	3-4		4-100	15-20%
	Airless spray	4-5	0.017-0.021"	4-100	0-10%

Cleaning thinner 5-

Application remarks Stir well before application and while painting.
Do not apply when temperature falls below 10°C.

Caution, Warning & General comments

See safety data sheet on page 9.

EPOGAL

Product code No. 649-050

Product Description Two-component (part A + part B), epoxy polyurethane primer, with excellent adhesion to galvanized steel. And aluminum.

Special features A primer on galvanized 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.
Two component paints can be applied on this primer at any time without maximum time limitation.

Suggested uses Protect metal structures in industrial or sea-shore environments.

Technical data

Color Beige, additional colors available upon request.

Gloss at 60°C Matt-satin.

Solid content by volume 50%

Recommended dry film thickness 30-75 microns.

Calculated spreading rate* 6.3-16.6 (sq. m/liter)

Recommended thinner 4-100

Touch dry** 2 hours.

Hard coat** 24 hours.

Dry to recoat 16 hours (min.)

Two pack product

Mixing ratio by weight A:B = 11:1

Mixing ratio by volume A:B = 9.5:1

Induction period before application** 15 minutes.

Pot life after mixing** 8 hours.

Shelf life** 24 months.

Surface preparation and specification

Remove grease, rust and any foreign matter from galvanized steel.
Clean with Ecoclean 2230, made by GES is recommended. Remove zinc oxide using Zinc Removal Paste No. 175, made by GES. Blast to 10-15 microns roughness. Note: For large projects, testing adhesion of paint to the galvanization and surface preparation type before commencing application is recommended.

Aluminum: Blast to 10-15 microns roughness. Topcoat: epoxy or polyurethane such as Epitamarin Solecoat, Multipoxy or Tamaglass.

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			4-100	5%
	Regular spray	3-4		4-100	10-15%
	Airless spray	4-5	0.021"-0.023"	4-100	0-5%

Cleaning thinner 4-100

Application remarks Stir well before application and while painting.

Do not apply when temperature falls below 10°C.

Caution, Warning &

General comments

See safety data sheet on page 9.

TAMAGLASS

Product code No.	390-xxx, 391-xxx
Product Description	Two-component, aliphatic, UV resistance polyurethane top-coat.
Special features	Superior exterior resistance. Maintains color and gloss for many years. Highly resistant to industrial and marine corrosive environment and to wear.
Suggested uses	Top-coat of a long-life, exterior system for application on steel and concrete structures in corrosive and marine environments.

Technical data

Color	RAL colors chart.
Gloss at 60°C	Glossy or silk, matt
Solid content by volume	50% min. according to the color.
Recommended dry film thickness	50 microns.
Calculated spreading rate*	9-11 (sq. m/liter)
Recommended thinner	11 or 10 at summer.
Touch dry**	4 hours.
Hard coat**	24 hours.
Dry to recoat	16-48 hours.

Two pack product

Mixing ratio by volume	A:B = 1 : :3
V.O.C. MIXED	459 g/liter
Pot life after mixing**	5-6 hours.
Shelf life**	24 months.

Surface preparation and specification

Regular Steel: Apply on epoxy primer Epitamarin Solecoat, Polychemcure, Rust Block, Multy-Poxy or another recommended epoxy primer.

Ferrous metal: Blast to Sa-2.5 (per Swedish Standard). Apply Inorganic Zinc Silicate, Zinc Rich Epoxy followed by Epitamarin Solecoat or Multi-Poxy or EA9 or EPOGAL, etc. Where blasting is impractical, remove loose rust to partial cleanliness and apply 2 coats of Epitamarin Solecoat or Multi-Poxy, 150 microns each, followed by 1-2 coats of Tamaglass.

Galvanization and new aluminum surfaces: Light blast or mechanical roughening by steel brush to a 7-12 microns profile is most recommended. Rinse off dust and zinc oxides with water and wait until completely dry. Flush grease with thinner 1-32 or thinner 21 and then apply a compatible primer, such as Epitamarin Solecoat, Multi-Poxy, UNISEAL Zn, and EPOGAL.

Surfaces with old paint: Power or hand washes to remove contaminants. Use a degreaser to remove oils when needed. Rinse off traces of cleaning agents thoroughly and dry. Rub off any loose paint coats, rust and corrosion. Use emery cloth to dull gloss of existing paint, and then apply Epitamarin Solecoat or Multi-Poxy primer.

Paint application

Part a (resin) and Part B (cure) are packed in measured quantities for mixing. Mixing ratio by volume A: B is 3:1. Mix part B into part A and stir well. For best results, apply at temperatures of 10-32°C. When applied at over 50°C, sagging may occur. Surface temperature must be 3°C above dew point at least.

Brush/roller: Apply complete and even coats. To ensure sufficient coat thickness, we recommend application of two coats, when applied by brush/roller.

Spraying/Airless spray: Flush the spraying system with thinner 11. Ascertain that the equipment is clean. Spray a wet layer in even and parallel passes with a 50% overlap to avoid exposed areas and gaps in the film.

Required nozzle orifice size: 0.013"-0.017". Presser: 2500-3000 PSI.

Caution, Warning & General comments

See safety data sheet on page 9.

TAMAGLAS ANTI GRAFFITI

Two Component Polyurethane Top Coat

Product Code 377-XXX

Product Description Two component polyurethane top coat, allowing easy removal of any graffiti.

Suggested uses Designated as a topcoat for steel and concrete structures in corrosive environments.

Special features Highly resistant to graffiti. Graffiti can be easily removed off surfaces coated with TAMAGLAS ANTI GRAFFITI, mechanically, or using a graffiti remover, without affecting it. Conforms o Standard ASTM D 6578. Highly resistant to industrial and marine corrosive environment.

Technical Specification

Color According to RAL table.

Gloss at 60°C Glossy/ satin

Calculated spreading rate 9 - 11 sq.m/liter (in one coat). (sq.m/liter)*

Touch dry** 4 hours

Hard dry** 24 hours

Dry to recoat Minimum: 12 hours,
Maximum: Unlimited, strictly maintain cleanliness of the area.

Thinner Thinner 10 (summer) or thinner 11 (winter)

Tools Cleaning Thinner 11

Two pack product

Mixing Ratio in volume A : B = 1 : 3

Pot life after mixing 5 hours

Shelf life** 24 months

Surface preparation and specification

Steel: Blast to Sa-2.5 (per Swedish standard).

at the profile depth required by the specification (40 -70 microns). Apply primer and an interim coat according to the technical specification, e.g., Epoxy Primer EA-9, MULTIPOXI, POLYCHEMCURE, Solecoat. Allow to dry to a hard coat and apply 1-2 coats of TAMAGLAS ANTI GRAFFITI, 50 microns thick per coat.

Aluminum and Galvanized Iron: abrade surface to a profile depth of 7 - 15 microns, until gloss is removed. Alternately, abrade the surface mechanically. Verify thorough removal of oils and other foreign matter. Apply 1 - 2 coats EPOGAL, 30 - 60 microns thick per coat and allow to dry to a hard coat. Apply 1 - 2 coats of TAMAGLAS ANTI GRAFFITI, 50 microns thick per coat.

Note: Surface preparation that excludes mechanical abrasion may significantly decrease the useful life span of the system. This preparation is designed to remove zinc oxides, oils and any other foreign matter. In the event that the aforementioned treatments cannot be performed, ensure complete removal of loose layers and oils off all metals with a compatible thinner. Maximum oxides removal from galvanized surfaces and aluminum should be achieved with drinking water. This option is not recommended as an alternative to the aforementioned thorough treatments and is the minimal action.

Application on Concrete: Remove loose layers, e.g., laitance and foreign particles by rinsing with a water jet at a pressure of about 150 atmospheres, or by sand blasting.

Apply one 30 microns thick coat of the binding primer AQUAPOXY M15. Allow to dry for 24 hours at least. Apply 1-2 coats of TAMAGLAS ANTI GRAFFITI, 50 microns thick per coat.

TAMAGLAS ANTI GRAFFITI (continued from page 63)

Graffiti Remover:	Graffiti Removal: Graffiti may be removed by the following means- Water Pressure: You can usually remove graffiti applied by synthetic spray, by spraying a water jet at a pressure of about 150 atmospheres.
	You may apply "TORCO S 6840", a water diluted graffiti remover, made by GES, wait for 5 – 10 minutes (read the technical sheet before use) and wipe off immediately with a water saturated cloth, or a water jet. The graffiti remover must be washed off within 10 minutes of its application to prevent any damage to the paint system. Prolonged exposure to the remover may stain the surface, affect the gloss and damage the paint system. Other Means: In many cases, graffiti can be removed by using a dry cloth, a cloth dipped in an organic thinner, e.g., isopropyl, alcohol, or detergent in low concentration. Repeated Graffiti Applications: Exceptionally aggressive graffiti materials may affect ease of removing additional graffiti layers, after the initial removal, but do not affect the paint system.
Application Directions	Mix the paint thoroughly, add part B while mixing and thin, using the suitable thinner. Close the container of part B immediately after use - air humidity affects its stability.
Tools Cleaning and Storage	Clean tools with thinner 11 immediately after application is completed. Close the container tightly to prevent air penetration. Store in a roofed, ventilated place.
Caution	Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.
Warning	Do not inhale fumes when spraying this product.
General comments	Never mix this material with others when not specifically recommended by us Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.
*	Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.
**	At 25°C and 85% relative humidity.

TAMAGLASS SUPER

Product code No. 393-xxx

Product Description Two-component, acrylic polyurethane paint. Provides superior performance in heavy duty industrial and marine environments. Long-term gloss and color retention. Good flexibility and abrasion resistance. Durable under a wide range of solvents and chemicals, and random spill and splash conditions. Low volatile organic tents.

Suggested uses Designed for application as a topcoat of a paint system for industrial structures, such as exterior steel tanks, steel structures, equipment, galvanized steel, concrete and masonry surfaces in extreme corrosive environment of prolonged exterior exposure. Not intended for immersion. Top coat for marine vessels such as boats, ships, buoys, and superstructures.

Technical data

Color RAL shades per order.

Gloss at 60°C Satin, Gloss.

Solid content by volume 50%±2%.

Recommended

dry film thickness 50-60 microns.

Calculated spreading rate* 10 – 8.3 (sq. m/liter)

Thinner- dilution & cleaning 11, 10 at summer

Mixing ratio by volume A:B = 4:1

V.O.C. MIXED 460 g/liter

Dilution The product is ready for use, if needed, dilute by about 5% of the volume. Pot life After mixing** 3 hours.

	0°C	10°C	25°C	32°C
Touch dry**				
(hours)	2.5	1.5	1.5	0.5
Hard coat**				
(hours)	24	10	5	4
Dry to recoat (min.)				
(hours)	24	10	5	4
Dry to recoat (max.)				
(days)		60	30	7

Shelf life Store in a cool and shaded area, at temperatures ranging from 4°C-38°C

Shelf life** 24 months.

Surface preparation and specification

Surfaces shall be sound, clean and free of all dirt, dust, wax, oil, powders and other contaminants which may affect adhesion of the new coat.

Prepare and prime properly bare surfaces prior to application of this product.

New Concrete: Cure new concrete for 30 days minimum at 22°C prior to application.

Remove bumps, leaks, plaster joints and soluble salts. Apply a suitable epoxy primer, such as TAMAGLASS PRIMER, EPICATALAC, MULTIPOXY, etc.

Ferrous Metal: Abrasive cleaning to SA2.5 is recommended. Apply a suitable primer coat, such as MULTIPOXY SOLECOAT, EA9, EPOGAL, etc. If abrasive cleaning is impossible, remove loose rust by partial preparation to ST-3 and apply a primer coat of MULTIPOXY SOLECOAT.

New Galvanized & Aluminum Surfaces:

Surface roughening to an average 7-12 microns profile, through light blasting or mechanical roughening with a steel brush, etc., is the most recommended preparation method. Remove dust and zinc salts by high pressure water jet at 10 atmospheres min. Allow to dry completely. Remove oils by rinsing with 1-32 thinner or thinner 21. Then, apply a suitable primer, such as MULTIPOXY, UNISEAL ZN, EPOGAL. Surface preparation without mechanical roughening will considerably reduce the life of the paint system. When mechanical roughening is impossible, clean zinc oxides, oil traces and any other foreign matter off the galvanized steel.

TAMAGLASS SUPER (continued from page 65)

Previously painted surfaces:

Rinse manually or mechanically to remove contaminants. Upon detecting oils on the surface, remove using a degreaser. Rinse off cleaners residue thoroughly and dry. Remove loose paint, rust and corrosion by scraping, sanding (or any other method) to ST-2, or sand blast to SA-2.5.

Paint application

Use sandpaper to dull gloss of existing paint. Apply MULTIPOXY primer Part A (resin) and Part B (cure) are packaged in pre-measured kits. Mixing ration of A:B is 1:9 in volume. Thoroughly mix Part B into Part A. For optimal application, apply in temperatures ranging from 10-32°C. At temperatures exceeding 50°C, runs may occur. Surface temperature must be at least 3°C above dew point.

Brush or Roller: Apply product in a full, even coat. To ensure adequate film build, two coats are recommended when applied by brush or roller.

Airless Spray: Flush airless lines with Thinner 11. Equipment must be clean prior to operation. Spray a wet coat in even, parallel passes with a 50% overlap, to avoid bare areas and pinholes.

Required nozzle size 0.013"-0.017". Pressure: 2500-3000 PSI.

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product.

Warning

General comments

Never mix this material with others when not specifically recommended by us. Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

*

Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.

**

At 25°C and 85% relative humidity.

AQUAPOXY TIE COAT 15M

Water Diluted Epoxy Mid-Coat

Product code No. 840-032

Product Description Two-component (Part A + Part B), water diluted epoxy paint used as a binding coat.

Special features Good adhesion to old paint coats of emulsion, synthetic, chlorinated rubber paints, etc.

Suggested uses Serves as a binding coat between old one-component paints to new, two-component, solvent based topcoats, such as TAMAGLASS, AUTODUR and Epoxy. It is mostly required to upgrade existing synthetic paint systems by painting them with epoxy and polyurethane paints. User and environment friendly with a low V.O.C.

Technical data

Color Light cream.

Gloss at 60°C Satin.

Solid content by volume 32% min. (A+B).

Recommended dry film thickness 25-35 microns.

Calculated spreading rate* 9-12 (sq. m/liter)

Recommended thinner Water.

Touch dry** 4 hours.

Hard coat** 24 hours.

Dry to recoat 15-24 hours.

Shelf life** 24 months.

Two Pack Product

Mixing ratio by weight A:B = 5:1

Induction period before painting** 20-30 minutes

Pot life after mixing** 4 hours

Surface preparation and specification

Ascertain that the surface is clean and free of dust, dirt, oil traces and any loose layers. It is desirable to roughen glossy surfaces. No need to remove old paint that is well adhered to the substrate.

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			Water	5-7%
	Regular spray	3	1.2	Water	10%-35%
	Airless spray	4-5 min.	21/60"	Water	Up to 5%

Cleaning thinner Water.

Application remarks Stir well before application and while painting.

Thoroughly mix Part B into Part A prior to diluting.

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product.

Warning

Never mix this material with others when not specifically recommended by us

General comments

See safety data sheet on page 9

AQUAPOXY TOP COAT 17M

Product code No. Grey 840-009, White 840-012
Product Description Two-component (Part A + Part B), water diluted epoxy topcoat.
Special features Designed as a top coat for exterior and interior painting of concrete buildings and constructions in marine and industrial environments. User and environment friendly, with low V.O.C, approved for use in "clean rooms"

Technical data

Color Grey, white, additional colors upon request.
Gloss at 60°C Over 70% (semi gloss – glossy).
Solid content by volume 40%
Recommended dry film thickness 40-50 microns.
Calculated spreading rate* 8-10 (sq. m/liter)
Recommended thinner Water.
Touch dry** 4 hours.
Hard coat** 24 hours.
Dry to recoat 15-24 hours.
Shelf life** 24 months.

Two Pack Product

Mixing ratio by weight A:B = 4:1
Induction period before painting** 30 minutes
Pot life after mixing** 4 hours
V.O.C. 48 g/liter

Surface preparation and specification

Previously Painted Surfaces (over chlorinated rubber, synthetic and "recoatable" type epoxy paints): Ascertain that the surface is clean and free of dust, dirt, oil traces and any loose layers. It is desirable to roughen the surfaces. Apply a binding primer coat of AQUAPOXY 15M.
 Concrete Walls and Floors: Remove loose layers, apply a binding primer coat of AQUAPOXY 15M

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner Thinning	
				Volume (%)	
	Brush/roller			Water	5-10%
	Regular spray	3		Water	10%-25%
	Airless spray	4-5 min.	17-21"	Water	Up to 5%

Cleaning thinner

Application remarks

Stir well before application and while painting.
 Thoroughly mix Part B into Part A prior to diluting.

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product.

Warning

General comments

Never mix this material with others when not specifically recommended by us
See safety data sheet on page 9.

EPOXY KSIR 88

High solids epoxy coating for use as high performance lining, tanks, pipelines and drinking water tanks.

Product code No. 648-007 Off White 648-009 Blue

Product Description Two-component, high solids epoxy coating for application to potable water, gas and mixed product lines. Offers excellent corrosion protection combined with good resistance to a wide range of liquids and gases including sour gas. KSIR 88 meets the requirements of BS6920 and is Water Regulation Advisory Scheme approved product with potable water. Excellent adhesion to both, grit blasted and manually prepared surfaces. Good resistance to abrasion and mechanical damage. Unaffected by fuel oil, chemical products, aviation fuel and sour gas mixtures. Excellent corrosion resistance on correctly prepared surfaces. Suitable for use up to 120°C dry heat.

Special features

Suggested uses

KSIR 88 is designed for use for drinking water tanks, swimming pools and as a high performance lining for tanks and pipelines

Technical data

Color Off White & Blue

Gloss at 60°C Satin.

Solid content by volume 65%

Recommended dry film thickness 300 microns.

Calculated spreading rate* 2.16 Respectively. (sq. m/liter)

Recommended thinner 4-100

Touch dry** 1 hour.

Hard coat** 8 hours.

Dry to recoat 6 hours min.; 48 hours max.

Two pack product

Mixing ratio by volume A:B = 3.5:1

Induction period before application** 15 minutes.

Pot life after mixing** 4 hours.

Shelf life** 24 months.

V.O.C. 300/gm/liter. Thinning for spray application will increase the applied V.O.C.

Surface preparation and specification

Steel surfaces should be abrasive blast cleaned to minimum standard Sa 2.5 Swedish Standard, profile depth of 50-75 microns. Where grit blasting cannot be carried out the steel surface should be thoroughly abraded. Concrete surfaces should be clean, dry and free from loose dirt and laitance. Approved methods of preparation are, light abrasive blasting, acid etching, scarifying, high pressure water jetting etc. the system for fresh water tanks should be 300 microns dry which can be applied in 2 coats of 150 microns each.

Paint application

Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
Brush/roller			4-100	10-15%
Regular spray	5-6	0.021"-0.023"	4-100	Up to 5%
Airless spray	5	1.8	4-100	Up to 10%

Cleaning thinner

4-100

Application remarks

Stir the content of part A, continue stirring and gradually add the total contents of part A, continue stirring, and gradually add the total contents of part A. Continue stirring until a homogeneous mix is obtained. For optimal results, use airless equipment of 1:60 compression ratio at least. Do not apply when relative humidity exceeds 90% or when the surface to be coated is less than 3°C above the dew point.

Caution, Warning & General comments

See safety data sheet on page 9.

TAMAGUARD EN-80 (Epoxy Novolac)

Product code No.
Product Description
Special features

Part A: 579-001, Part B: 579-002
 Two-component, high solids and high-build epoxy novolak..
 Used as a primer and a topcoat. Superior resistance to chemicals, acids and alkali. Designed for application at a relatively high humidity without blanching. Suitable for application in highly corrosive heavy industry environment and contact with chemicals, according to the resistance table*. Used for application on interiors of storages containers of crude oil, various hydrocarbons, thinners, sea water, process water, sewage, hot water. Resistant to high temperatures, etc. (continuous process at 120°C and brief peaks up to 150°C).

Technical data (25°C)

Colors Gray, additional colors upon request.
Gloss Semi-Gloss
% Solid content 80±2%
Dry film thickness** 75-200 microns, dry
Calculated spreading rate 4-10.7 sq. m/liter (sq. m/liter)*
Recommended thinner 4-100 for thinning and cleaning.
Touch dry** Two hours
Hard coat (25°C)** 8 hours
Dry to recoat Minimum waiting time for another coat of TAMAGUARD EN-80: 16 hours.
 Maximum waiting time for another coat of TAMAGUARD EN-80: 30 days.

Two Component Paint

Mixing ratio by volume A : B = 1:4
Pot life After mixing** 3 hours.
Shelf life** 24 months.

Surface preparation and specification

Steel Metals: Remove grease and oils by rinsing with thinner 4-100. Remove any foreign matter and dirt. Grind and polish welding seams. Smooth sharp edges. Then blast with aggregates up to Sa-2.5 degree at least, per Swedish Standard to a rough level of 60 microns at least. apply 60-80 tamaguard holding primer followed by 2 coats of 20 mic each of tamaguard EN 80
Concrete: Remove all dust and dirt. Remove grease using detergents and rinse thoroughly with tap water, until a neutral surface is obtained. Ascertain that the surface is rough (a depth of 200 microns at least), until original, stable concrete surface is obtained. Cure fresh concrete for 28 days at least. It is recommended to rinse the concrete surface with water at a pressure of 150 atmospheres at least to remove salts and then allow to dry for 48 hours. Ascertain that surface pH ranges from 6 to 10.

Paint application

Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
Brush/roller	-	-	4-100	5-10%
Regular spray	3-4	-	4-100	10-15%
Airless spray	4-5	0.017-0.025"	1-32	0-5%

Cleaning thinner

Application remarks

Thinner 4-100
 Stir well before application and while painting.
 Do not apply at temperatures below 10°C.
 Apply on galvanized steel only after applying the appropriate primer.

Caution, Warning & General comments

See safety data sheet on page 9.

TAMAGUARD EN-100 (Epoxy Novolac)

Product code No. Product Description Special features

Part A: 579-004, Part B: 579-005
Two-component, solvent free epoxy novolak.
Used as a primer and a topcoat. Superior resistance to chemicals, acids and alkali. Suitable for application in highly corrosive heavy industry environment and contact with chemicals, according to the resistance table*. Used for application on interiors of storages containers of crude oil, hydrocarbon materials, thinners, sea water, process water, sewage, hot water. Resistant to high temperatures, etc. (continuous process at 120°C and brief peaks up to 150°C). Good flexibility & excellent abrasion resistance.

Technical data (25°C)

Colors White, grey, additional colors upon request.
Gloss Gloss (loss of gloss and yellowing when exposed to sun & chemicals).
% Solid content 100%
Dry film thickness** 125 microns, dry (2-3 coats of 125 mic. Each is recommended).
Calculated spreading rate 4 sq. m/liter (sq. m/liter)*
Recommended thinner 4-100 for thinning and cleaning.
Touch dry** Two hours
Hard coat (25°C)** 8 hours
Dry to recoat Minimum waiting for another coat of TAMAGUARD EN-100: 8-16 hours.
Maximum waiting time for another coat of TAMAGUARD EN100: 24 hours.

Two Component Paint

Mixing ratio by volume A : B = 3 : 1

Pot life After mixing** 2 hours.

Shelf life** 24 months.

Surface preparation and specification

Steel Metals: Remove grease and oils by rinsing with thinner 4-100. Remove any foreign matter and dirt. Grind and polish welding seams. Smooth sharp edges. Then blast with aggregates up to Sa-2.5 degree at least, per Swedish Standard to a rough level of 60-75 microns at least. apply 60-80 Tamaguard holding primer followed by 2 coats of tamaguard EN 100

Concrete: Remove all dust and dirt. Remove grease using detergents and rinse thoroughly with tap water, until a neutral surface is obtained. Ascertain that the surface is rough (a depth of 200 microns at least), until original, stable concrete surface is obtained. Cure fresh concrete for 28 days at least. It is recommended to rinse the concrete surface with water at a pressure of 150 atmospheres at least to remove salts and then allow drying for 48 hours. Ascertain that surface pH ranges from 6 to 10.

Paint application

Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
Brush/roller	-	-	4-100	5-10%
Regular spray	3-4	-	4-100	10-15%
Airless spray	2250-3000PSI	0.017-0.025"	4-100	0-5%

Cleaning thinner

Thinner 4-100

Application remarks

Stir well before application and while painting.
Do not apply at temperatures below 10°C.
Apply on galvanized steel only after applying the appropriate primer.

Caution, Warning & General comments

See safety data sheet on page 9.

EPOXY TOPCOAT EA-4

Manufactured under license from COPON INTERNATIONAL

Product code No.	Glossy gray: 644-011 Matt white: 643-019 Matt gray: 643-021 Glossy white: 644-021
Product Description	Two-component (part A + part B), epoxy polyamine topcoat.
Special features	Excellent resistance to random contact with chemicals and to wear.
Suggested uses	Designed for coating floors and walls in chemicals, food and metal coating industries.

Technical data (25°C)

Colors	Glossy grey-blue FED 16008. Matt grey-blue FED 36293.
Gloss at 60°C	Glossy, Matt.
Solid content by volume	Glossy 46%, Matt 63%
Recommended dry film thickness	40 microns
Calculated spreading rate	Glossy - 11.5; Matt - 15.7.
Recommended thinner	4-100
Touch dry**	hour
Hard coat (25°C)**	24 hours
Dry to recoat	16-24 hours

Two Pack Product

Mixing ratio by weight	Grey-blue FED 36293 matt - A:B = 1:7.5 Grey-blue FED 16008 glossy - A:B 1:3.6
Mixing ratio by volume	Grey-blue FED 36293 matt - A:B = 1:4.4 Grey-blue FED 16008 glossy - A:B 1:2.9

Induction period before application**	30 minutes
Pot life After mixing**	8 hours.
Shelf life**	24 months.

Surface preparation and specification

Concrete: Mechanically remove loose layers and roughen. Where mechanical means are impractical, clean with diluted acid, rinse with fresh water and apply EPICATALAC Clear Primer.
Steel: Blast to Sa-2.5 (per Swedish standard), apply primer 6030 or epoxy EA9 or epitamarin solecoat

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning
Volume (%)					
	Brush/roller		4-100	5%	
	Regular spray	3-4	4-100	10%	
	Airless spray	4-5	0.015	4-100	5-10%

Cleaning thinner 4-100

Application remarks

1. Stir well before application and while painting.
2. Do not apply in thicker than 40 microns coats. Where a thicker coat is required, apply several coats.
3. Do not apply when temperature falls below 10°C.

Caution, Warning & General comments

See safety data sheet on page 9.

EPOXY COPON EA-4-2217

Manufactured Under "COPON INTERNATIONAL" License

Product code No.	644-203
Product Description	Two-component (part A + part B), epoxy coating, based on epoxy polyamine resins.
Special features	Approved by British Petroleum.
Suggested uses	Especially used as internal coating of pipes carrying, jet fuel, oil products, gas and petroleum distillates. (used at Israeli Air Force airfields and at civilian airports throughout the world.

Technical data (25°C)

Colors	Red oxide.
Gloss at 60°C	Glossy.
Solid content by volume	51%
Recommended dry film thickness	40 microns
Calculated spreading rate	12.8
Recommended thinner	4-100
Touch dry**	15-30 minutes
Hard coat (25°C)**	7 days
Dry to recoat	4 hours

Two Pack Product

Mixing ratio by weight	A:B = 1:6.1
Mixing ratio by volume	A:B = 1:4
Induction period before application**	30 minutes
Pot life After mixing**	8 hours.
Shelf life**	24 months.

Surface preparation and specification

Application of 2-3 coats of 100-125 microns total thickness is recommended.

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Regular spray	3-4		4-100	15-20%
	Airless spray	4-5	0.018-0.021"/60°	4-100	Up to 5%
Cleaning thinner	4-100				

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product.

Warning

Never mix this material with others when not specifically recommended by us

General comments

See safety data sheet on page 9.

TAMAGUARD HOLDING PRIMER HT

Product code No.	Part A: 649091 Part B: 649092
Product Description	Two-component, high-build epoxy Polyamide primer for steel
Special features	Used as a holding primer for phenolic and novolak paint systems. High resistance to steel tanks. Excellent resistance to water, process water and sea water. Designed for application as a primer for internal tanks storing chemicals and other petrochemicals prior to application Tamaguard EN 80/100 or other epoxy with high resistance to chemicals. . Suitable for application on steel constructions such as bridges, tanks ,and other constructions in industrial & marine atmosphere and as a primer for application on interiors of storages containers of crude oil, various hydrocarbons, thinners, sea water, process water, sewage, hot water. Resistant to high temperatures, etc. (continuous process at 120°C and brief peaks up to 150°C).
Technical data (25°C)	
Colors	Red Oxide, additional colors upon request.
Gloss	Semi-Gloss
% Solid content	48±2%
Recommended dry film thickness	40-60 microns as a holding primer. Can be applied up to 80-120 as a midcoat.
Calculated spreading rate	8-12 sq. m/liter
Recommended thinner	4-100 for thinning and cleaning.
Touch dry**	2 hours
Hard coat (25°C)**	8 hours
Dry to recoat	Minimum for TAMAGUARD 12 hours. Maximum 7 days.
Two Component Paint	
Mixing ratio by volume	A : B = 1:4
Pot life After mixing**	8 hours.
Shelf life**	24 months.
Surface preparation and specification	
Steel Metals	Remove grease and oils by rinsing with thinner 4-100. Remove any foreign matter and dirt. Grind and polish welding seams. Smooth sharp edges. Then blast with aggregates up to Sa-2.5 degree at least, per Swedish Standard to a rough level of 60 microns at least. Tamaguard Holding Prime HT is used as a primer for paint systems such as: Tamaguard EN80 & EN100, Afrapoxy SL6, Epoxy 308 and other high build such as Multipoxy, Epitamarin Solecoat & Epotran 400.
Concrete	Remove all dust and dirt. Remove grease using detergents and rinse thoroughly with tap water, until a neutral surface is obtained. Ascertain that the surface is rough (a depth of 200 microns at least), until original, stable concrete surface is obtained. Cure fresh concrete for 28 days at least. It is recommended to rinse the concrete surface with water at a pressure of 150 atmospheres at least to remove salts and then allow to dry for 48 hours. Ascertain that surface pH ranges from 6 to 10.

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TAMAGUARD HOLDING PRIMER HT (Continued From p. 74)

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			4-100	5-10%
	Regular spray	3-4		4-100	10-15%
	Airless spray	4-5	0.017-0.025"	4-100	0-5%

Cleaning thinner
Application remarks

1. Stir well before application and while painting.
2. Do not apply at temperatures below 10°C.

Caution

3. Apply on galvanized steel only after applying the appropriate primer. Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Warning

Do not inhale fumes when spraying this product.

Never mix this material with others when not specifically recommended by us.

General comments

Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

* Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.

** At 25°C and 85% relative humidity.

GALVAZINC

Per standard S.S.P.C. 20

Product code No.	477 012
Product Description	One-component, epoxy zinc rich primer for use as a cold galvanized. Conforms to composition and performance requirements of Steel Structure Painting Council (S.S.P.C.) Paint 20 standard. Minimum content of zinc in the dry film – 90%.
Special features	Grants anti-corrosion and cathodic protection for long term, Quick drying. Suitable as a multipurpose primer on steel. May be top coated with epoxies, vinyls, modified acrylics.
Suggested uses	Suitable for repairing weldings and galvanized steel (after preparation). To be used as an anti corrosive primer on steel constructions in heavy industrial and marine environment.

Technical data

Colors	Grey
Gloss at 60°C	Matt
Solid content by volume	40%
Recommended dry film thickness	40-60 microns
Calculated spreading rate	6.6-10 (sq.m/liter)
Recommended thinner	4-100

Drying times at 25°C

Touch dry**	10 minutes.
Hard coat (25°C)**	
Dry to recoat	8 hours min.; max. 7days.
Shelf life**	12 months

Surface preparation and specification

Blast to Sa-2.5 (per Swedish Standard) to achieve a 40-70 microns profile. Weldings must be blasted and clean prior to application.

Paint system	Used as a primer for epoxy and one component paints, such as Rust Block, POLYCHEMCURE, Multi-Poxy, Solecoat,, Uniseal ZN as well as Monocoat FDo Galvaccoat. D.F.T.of the next coat must be no more then 60-70 microns.
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Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			4-100	10%
	Airless spray	4-5	0.018"-0.021"	4-100	0-5%

Cleaning thinner 4-100

Application remarks

1. Stir well before application and while painting.
2. Do not apply when temperature falls below 15°C.

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product.

Warning

Never mix this material with others when not specifically recommended by us

General comments

See safety data sheet on page 9.

EPITAMARIN DIVINEX A.B

Product code No. Red 847 004
Grey 847 007

Product Description A two- component, high build, recoatable epoxy coating. Can be top coated with no time limit. Used as a high-build intermediate coating for underwater and above water line, for epoxy, c/r, vinyl and polyurethane topcoats. Recommended for use on steel constructions. Designed for use in severe corrosive environment. Suitable as a tie coat/sealer between coaltar epoxy and epoxy primers and antifoulings.

Technical data (At 25°C & 65% RH)

Gloss Flat
Color Red, Grey
Specific gravity-Kg/lit 1.22
Volume solid 45%
film thickness-dry 100 microns
film thickness-wet 230 microns
Theoretical coverage 4.50 m²/lit
Flash point 17°C
Drying times
Touch dry 1 hour
Hard coat 24 hours
Shelf life 12 months
V.O.C 530 g/liter

Application Details

Application Method	Airless Spray	Brush/Roller
Mixing Ratio A:B by weight	16:1	16:1
Mixing Ratio A:B by volume	14:1	14:1
Quantity of thinner (max. volume)	0-5% (4-100)	0-5% (4-100)
Recommended Nozzle Orifice	0.023"	
Recommended Inlet Pressure	5 atm	
Cleaning Thinner	4-100	
Recoating Interval	12 hours	
Pot-life	8 hours	

Mixing two component product, supplied 5 or 18 or 20 liters kits, which contain the proper ratio of ingredients. The entire contents of each container must be mixed together.
Power mix Part A at slow speed to obtain a smooth homogeneous condition. After mixing part A add part B slowly with continued slow speed agitation. Then continue to mix slowly for 5 minutes. Allow an additional 15 minutes induction time before application.
The thinner addition (if necessary) should be made only after the two components are thoroughly mixed.

Drying time at 50 mic dft

Air Temperature	Touch Dry	Over coating Interval	
		Min (hours)	Max
5°C	2 hours	48	Indefinite
10°C	1 hour	36	Indefinite
20°C	45 min.	24	Indefinite
30°C	30 min.	24	Indefinite

Surface Preparation Surface properly primed with Epitamarin EA9 Aluminum or Epitamarin Solecoat. Area should be clean and dry prior to application.
As a tie coat: The shop primer or coaltar epoxy surface should be dry and clean of any foreign matter prior to application.

Application Condition Area should be clean and dry prior to application. Temperature should be above the dew point during application.

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**EPITAMARIN DIVINEX N.B** (Continued From p. 77)**Storage and Packing**

Store in cool and well ventilated place. Container must be kept tightly closed.

Packaging A+B: 5 Ltr or 18 liters

Remarks

This product will not cure adequately below 0°C. The numerical information quoted in the data sheet is subject to normal manufacturing tolerance. Practical covering can vary depending on application condition, structure and weather conditions. The volume solids figure is the percentage of dry film obtained from a given wet film thickness under specified application rate and conditions. The intervals given assume preparation consistent with good painting practice.

Safety Precautions

Refer to P.P.A. 3/1. Before and during use observe all safety labels on packing and paint containers. Consult Tamarin Material Safety Data Sheet. Avoid direct contact with skin and eyes (Gloves, goggles, face mask, barrier cream, etc.). Provide adequate ventilation.

If Product comes in contact with skin wash with warm water and soap. If eyes are contaminated flush with water for 10 minutes and obtain medical advice.

Basic Safety Precautions

This product contains flammable materials. Keep away from sparks and open flames. No smoking should be permitted in the area. Observe all precautionary notices on containers.

Additional safety information is available on request.

EPOGAL FD

Product code No.	Part A: 649-156 Part B: 649-199			
Product Description	Two-component (part A + part B), epoxy primer, fast drying with excellent adhesion to galvanized substrate. Its properties are similar to that of EPOGAL, with faster drying and higher solids content.			
Special features	Applied as a fast drying high-build primer on galvanized steel and ferrous metal for synthetic top-coats (e.g., Super Durable Top-Coat) and epoxy and polyurethane top-coats (e.g., Tamaglass).			
Technical data				
Color	Beige, additional colors available upon request.			
Gloss at 60°C	Matt-satin.			
Solid content by volume	67±2%			
Recommended dry film thickness	60-150 microns.			
Calculated spreading rate	4.5-11.2 (sq.m/liter)			
Recommended thinner	4-100			
Touch dry**	30 minutes.			
Hard coat**	8 hours.			
Dry to recoat	4 hours (min.). 3 months (max.).			
Two Pack Product				
Mixing ratio by volume	A:B = 6:1			
Pot life After mixing**	6 hours.			
Shelf life**	24 months.			
Mixing	two component product, supplied 5 or 18 or 20 liters kits, which contain the proper ratio of ingredients. The entire contents of each container must be mixed together. Power mix Part A at slow speed to obtain a smooth homogeneous condition. After mixing part A add part B slowly with continued slow speed agitation. Then continue to mix slowly for 5 minutes. Allow an additional 15 minutes induction time before application. The thinner addition (if necessary) should be made only after the two components are thoroughly mixed.			
Surface preparation and specification				
Galvanized metal	Remove grease, rust and any foreign matter from galvanized steel. Cleaning with Detergent BC-70, made by Tambour Ecology is recommended. Remove zinc oxide using Zinc Removal Paste No. 175, made by Tambour Ecology. Blast to 10-15 microns roughness. Blast to a roughness degree of 15 microns at least, until all zinc oxides and galvanization shine are removed, closely vacuuming the dust.			
Steel	Clean oils. Blast to Sa-2.5 degree per Swedish Standard. Roughness depth 50 microns at least. Note: For partial surface preparation, test paint adhesion to the galvanization type and compatibility with the surface preparation quality prior to application.			
Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner Thinning Volume (%)
	Brush/roller			4-100 10%
	Regular spray	3-4		4-100 10-20%
	Airless spray	4-5	0.021"-0.023"	4-100 0-15%
Cleaning thinner	4-100			
Application remarks	1. Stir well before application and while painting. 2. Do not apply when temperature falls below 10°C. 3. Apply at a temperature of 5°C above dew point.			
Caution, Warning & General comments	See safety data sheet on page 9.			

Maintenance

Maintenance

One component primers and top coats for metal, such as alkyd, vinyl resins and chlorinated rubber.

Designed for application by brush, roller, spraying and air less spraying.

These paints are designated for painting constructions and building structures in urban and marine environment and are used as maintenance paints for the industry.

Topcoats are available in ready-made colors or RAL colors, upon request.

Antirust primer

one component primer for ferrous metal in an urban environment, fight the rust

Fast drying system

Primer and top coat for metal, designed for same day application and drying provides an especially cost effective application process.

Fast drying primer: fast drying, high build primer protects metal from corrosion fast drying top coat:

glossy, fast drying top coat.

Super durable system

A glossy system, designed for superb, long term protection of metal in moderate industrial environments.

Super durable primer HB13: contains anti-corrosive zinc chromate pigments.

Super Durable friendly primer: contains environment friendly, anti-corrosive pigments.

Super durable top coat: an especially high gloss top coat for long term resistance.

Monocoat

A revolutionary paint combination of both primer and top coat, designed for application in one coat on any metal. Provides good protection to the metal in stain gloss and enables an extremely quick work process.

In addition to these paint systems, TAMBOUR offers exclusive paints for specific purposes (zinc rich primer for galvanization and more)



Monocoat

ANTIRUST

Product code No.	White: 270-000, Red oxide: 270-001, Grey: 270-002
Product Description	Synthetic primer for protecting interior and exterior metal objects against rust
Suggested uses	For painting house railings, houses and other steel structures.
Technical data	
Color	Red oxide, gray.
Gloss at 60°C	Matt.
Solid content by volume	45%
Recommended dry film thickness	35 microns.
Calculated spreading rate*	12.8. (sq. m/liter)
Recommended thinner	Tambour Mineral spirit or thinner18.
Touch dry**	2 hours.
Hard coat**	8 hours.
Dry to recoat	16 hours.
Shelf life**	24 Months.

Surface preparation and specification

Clean off any grease or dirt. Remove rust and flaky material by mechanical or chemical means. Neutralize remaining rust with Tambour Rust Converter (R.C.T.) code number 687-050.

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			Mineral spirit	
				Tambour	5%
	Regular spray	3-4	1.6	18	20%
	Airless spray	4-5	0.018"/30°-60°	18	5-10%

Cleaning thinner Tambour mineral spirit.

Application remarks

Stir well before application and while painting.

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product.

Warning

Never mix this material with others when not specifically recommended by us.

General comments

Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

* Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.

** At 25°C and 85% relative humidity.

FAST DRYING PRIMER

Product code No.	436-560 Red Oxide, 436-561 Dark Grey, 436-562 Off-White, 436-563 Yellow Oxide				
Product Description	One-component, fast drying, high build, anti-corrosive primer, provides a highly economical painting process.				
Special features	Used as the primer in a quick application system together with “Fast Drying Top-Coat” for completing the painting process during one day. Contains anti-corrosive pigments of zinc phosphate type and provides superior protection against rust. Enables application of a single 70 micron thick coat, thus saving the number of primer coats and application costs. Applied by spraying and brushing. User and environment friendly.				
Suggested uses	For ferrous metal items, in an urban, light industry environment, such as bars, constructions and metal for construction, and in the rail industry. Used as a primer in a quick application system.				
Technical data					
Color	Red oxide, dark grey, off-white, yellow oxide.				
Gloss at 60°C	Matt.				
Solid content by volume	48±2%				
Recommended dry film thickness	30-60 microns.				
Calculated spreading rate*	8-16 (according to recommended dry film thickness) (sq. m/liter)				
Recommended thinner	For spraying: 1-32; for brushing: 18.				
Touch dry**	30 minutes.				
Hard coat**	12 hours.				
Dry to recoat	1 hour. To obtain maximal gloss, apply Fast Drying Top-Coat after 5 hours				
Shelf life**	24 months.				
Surface preparation and specification					
Blast to Sa2.5 (per Swedish Standard) at least. Where sandblasting is impossible, remove rust and loose layers mechanically, to ST-3 (per Swedish Standard). Remove any oils and foreign matter.					
Paint system	Primer: apply 1-2 coats of Fast Drying primer. Top-coat: to obtain an especially quick application process, it is recommended to use in combination with Fast Drying Top-Coat.				
Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			18	Up to 10%
	Regular spray	2-3		1-32	Up to 15%
	Airless spray	3-6	17-21"	1-32	Up to 7%
Cleaning thinner	Tambour Mineral spirit or Thinner 1-32				
Application remarks	Stir well before application and while painting.				
Caution	Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet. Do not inhale fumes when spraying this product.				
Warning	Never mix this material with others when not specifically recommended by us.				
General comments	Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.				
*	Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.				
**	At 25°C and 85% relative humidity.				

FAST DRYING TOPCOAT

Product code No.	436-xxx
Product Description	Glossy, fast drying topcoat. Enables a highly economical painting process.
Special features	Very fast drying top-coat for a short application process. The quick drying prevents dust and dirt pick-up and provides a decorative look. Applied by spraying and brush. Minimal sagging and dropping.
Suggested uses	Designed for quick and economical application, where the metal items must be transported quickly. For ferrous metal items and constructions, in an urban, light industry environment.

Technical data

Color	Industrial colors table, RAL colors table.
Gloss at 60°C	75±5% (glossy)
Solid content by volume	45±2%
Recommended dry	
Film thickness	35-40 microns.
Calculated spreading rate*	About 12 (depending on the color) (sq. m/liter)
Recommended thinner	For spraying: 1-32; for brush: 18.
Touch dry**	30 minutes.
Hard coat**	5 hours.
Dry to recoat	Up to 1 - 4 hours, or after 16 hours. To obtain maximal gloss, apply Fast Drying Top-Coat after 5 hours.
Shelf life**	24 months.

Surface preparation and specification

	Blast to Sa2.5 (per Swedish Standard).
	Where abrading is impossible, remove rust and loose layers mechanically, to ST-3 (per Swedish Standard). Remove any oils and foreign matter.
Paint system	Primer: to obtain an extremely quick drying process apply Fast Drying Primer. May be applied as a top-coat on all Tambour synthetic paints.

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			18	Up to 10%
	Regular spray	3-4		1-32	Up to 10%
	Airless spray	3-4	15-21"	1-32	Up to 5%

Cleaning thinner Thinner 1-32 or thinner 18.

Application remarks Stir well before application and while painting.

Caution Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.
Do not inhale fumes when spraying this product.

Warning Never mix this material with others when not specifically recommended by us.

General comments Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

* Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.

** At 25°C and 85% relative humidity.

SUPER DURABLE PRIMER

Product code No.	429-520 white, 429-521 red, 429-522 grey
Product Description	One-component, high build, primer provides high resistance to rust over many years.
Special features	Superior, anti corrosive, user and environment primer, based on phosphate, provides long term protection against rust. High-build, may be applied in one coat, 70 microns thick, thus saving a number of coats and application time. Designed for application on partial surface preparation, including stable rust at ST3 (per Swedish standard).
Suggested uses	For ferrous metal structures and constructions, exterior application on containers in dry and marine, heavy industry environments, for quality maintenance application.

Technical data

Color	Red oxide, grey, off-white.
Gloss at 60°C	Matt.
Solid content by volume	50±2%
Recommended dry Film thickness	35-70 microns.
Calculated spreading rate*	7.1-14.3 (sq. m/liter)
Recommended thinner	For spraying: 1-32; for brush: 18.
Touch dry**	1 hour.
Hard coat**	12 hours.
Dry to recoat	2 hours.
Shelf life**	24 months.

Surface preparation and specification

Ferrous metal:	Blast to Sa2.5 (per Swedish standard). Where Abrading is impossible, remove rust and loose layers mechanically, using emery cloth, steel-wire brush or disk, to ST-3 (per Swedish Standard). Remove any dust, oils and foreign matter.
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Paint system	Primer: apply 1-2 coats of Super Durable primer. Top-coat: to obtain high resistance, apply Super Durable Top-Coat. This primer is compatible with all Tambour made synthetic top-coats.
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Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			18	Up to 10%
	Regular spray	2-3		1-32	Up to 15%
	Airless spray	3-6	17-21"	1-32	Up to 7%

Cleaning thinner	Thinner 1-32 or thinner 18.
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Application remarks	Stir well before application and while painting.
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Caution	Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet. Do not inhale fumes when spraying this product.
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Warning	Never mix this material with others when not specifically recommended by us.
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General comments	Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.
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*	Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.
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**	At 25°C and 85% relative humidity.
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FRIENDLY SUPER DURABLE PRIMER

Product code No.	429-520 white 429-521 red 429-522 grey				
Product Description	One-component, high build, primer provides high resistance to rust over many years.				
Special features	Superior, anti corrosive, user and environment friendly primer, based on phosphate, provides long term protection against rust. High-build, may be applied in one coat, 70 microns thick, thus saving a number of coats and application time. Designed for application on partial surface preparation, including stable rust at ST3 (per Swedish standard).				
Suggested uses	For ferrous metal structures and constructions, exterior application on containers in dry and marine, heavy industry environments, for quality maintenance application.				
Technical data					
Color	Red oxide, grey, off-white.				
Gloss at 60°C	Matt				
Solid content by volume	50±2%				
Recommended dry film thickness	35-70 microns.				
Calculated spreading rate	7.1-14.3 (sq.m/liter)				
Recommended thinner	For spraying: 1-32; for brush: 18.				
Touch dry**	1 hour				
Hard coat**	12 hours.				
Dry to recoat	2 hours				
Shelf life**	24 months.				
Surface preparation and specification					
Ferrous metal:	Blast to Sa2.5 (per Swedish standard). Where Abrading is impossible, remove rust and loose layers mechanically, using emery cloth, steel-wire brush or disk, to ST-3 (per Swedish Standard). Remove any dust, oils and foreign matter.				
Paint system	Primer: apply 1-2 coats of Environment Friendly Super Durable primer. Top-coat: to obtain high resistance, apply Super Durable Top-Coat. This primer is compatible with all Tambour made synthetic top-coats.				
Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			18	up to 10%
	Regular spray	2-3		1-32	up to 15%
	Airless spray	3-6	17-21"	1-32	up to 7%
Cleaning thinner	Thinner 1-32 or thinner 18.				
Application remarks	Stir well before application and while painting.				
Caution	Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet. Do not inhale fumes when spraying this product.				
Warning	Never mix this material with others when not specifically recommended by us				
General comments	See safety data sheet on page 9.				

SUPER DURABLE TOPCOAT

Product code No.	429-xxx				
Product Description	High-gloss top-coat, durable for many years, user and environment friendly.				
Special features	Superior, long-term resistance to urban, dry and marine industrial environments. Special high gloss. Chromate and lead free. Applied by spraying and brush. Heat resistant, up to 80°C.				
Suggested uses	Top-coat over Super Durable Primer, for application on ferrous metal structures and constructions, exterior application on containers and steel items in heavy industry environment, and in the rail industry.				
Technical data					
Color	Industrial colors table and RAL colors table .				
Gloss at 60°C	High gloss.				
Solid content by volume	47±2%				
Recommended dry					
Film thickness	40 microns.				
Calculated spreading rate*	About 12 (depending on the color). (sq. m/liter)				
Recommended thinner	For spraying: 1-32; for brush: 18.				
Touch dry**	2 hours.				
Hard coat**	16 hours.				
Dry to recoat	16 hours.				
Shelf life**	24 months.				
Surface preparation and specification					
Blast to Sa2.5 at least (per Swedish standard).					
Where abrading is impossible, roughen and remove rust and loose layers mechanically. Remove any dust, oils and foreign matter.					
Paint system	Primer: compatible for application on all Tambour synthetic primers. Top-coat: to obtain high resistance, apply on 1-2 coats of Super Durable primer				
Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			18	Up to 10%
	Regular spray	3-4		1-32	Up to 10%
	Airless spray	3-4	15-21"	1-32	Up to 5%
Cleaning thinner	Thinner 1-32 or thinner 18.				
Application remarks	Stir well before application and while painting.				
Caution	Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet. Do not inhale fumes when spraying this product.				
Warning	Never mix this material with others when not specifically recommended by us.				
General comments	Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.				
*	Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.				
**	At 25°C and 85% relative humidity.				

GALVANIZED PRIMER

Product code No. 461-600 white, 461-693 orange

Product Description One-component, high build, vinyl primer and topcoat. Provides excellent adhesion to ferrous metals and galvanized steel. In most cases, may be applied over old synthetic paints, without a tie coat. Chromate and lead free.

Special features Can be used as a single paint in a system when applied in two coats of a 70 microns total thickness. Excellent elasticity. No time limit on paint renovation. GALVACOAT primer and a synthetic top-coat can be applied on the same day.

Suggested uses Galvanized surfaces protection (such as constructions, railing, sheet metal, ventilation ducts, etc.) in industrial and marine environment.

Technical data

Color White, orange (additional colors upon request).

Gloss at 60°C Satin.

Solid content by volume 38%

Recommended dry film thickness 30-70 microns.

Calculated spreading rate* 5.4-12.7 (respectively) (sq. m/liter)

Recommended thinner 1-32

Touch dry** 1 hour.

Hard coat** 18 hours.

Dry to recoat 6 hours.

Shelf life** 24 months.

Surface preparation and specification

Galvanized steel: The most recommended surface preparation is light sandblasting to obtain roughened surface profile of 7-12 microns, or mechanically, using steel-wire brushes etc. Remove any dust and zinc salts by rinsing with pressurized water and wait until completely dry. Remove oils by rinsing with thinner 1-32 or thinner 21. Surface preparation that does not include mechanical roughening, will significantly reduce the longevity of the system. When it is impossible to perform mechanical roughening, clean galvanized metal from any zinc oxides and oils and any other foreign matter. It is recommended to clean using Ardrex G-551 solvent, or BC-70 detergent, made by Tambour Ecology. Remove zinc oxides, using Paste for Removing Oxides No. 175 made by Tambour Ecology. Where impossible, ascertain rinsing with water under pressure, at least (we do not recommend this option).

Rusty galvanized steel: Remove loose rust in addition to the aforementioned preparations. Recommended surface preparation degree is Sa2.5. (per Swedish Standard) If impossible, roughen mechanically and clean.

Old synthetic paints: Surface preparation – clean surface thoroughly, remove loose scales through gentle filing or rinsing with water under pressure, until a stable surface is obtained, followed by a practical preliminary test of the product's adhesion capacity.

Top-coats: Top-coats such as Super Durable Top-Coat, Fast Drying Top-Coat, Poliur and TAMAPLAST Super may be applied.

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			1-32	10%
	Regular spray	3-4		1-32	10%
	Airless spray	3-4	0.015 – 0.021"	1-32	0-5%

Cleaning thinner Thinner 1-32 or thinner 18.

Application remarks Stir well before application and while painting. Testing paint adhesion to the galvanization type is recommended.

Caution Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet. Do not inhale fumes when spraying this product.

Warning Never mix this material with others when not specifically recommended by us.

General comments Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

* Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.

** At 25°C and 85% relative humidity.

MONOCOAT F.D

Product code No.	462-xxx																				
Product Description	Synthetic, one-component, high build, paint, used as a primer and top-coat. for direct application on ferrous metal, galvanized steel and aluminum.																				
Special features	Excellent adhesion to galvanized steel – contains special resins designed to enhance adhesion to all types of galvanized steel.																				
Suggested uses	Provides a highly economical and quick application process, where same day application and transportation of metal objects is required. Designed for smithy and light maintenance application on ferrous metal constructions and galvanized objects (including stable treated rust at ST-2 class) in an urban and light industry environments. Prevent direct contact of this product with chemicals and acid or alkali and application on concrete.																				
Technical data																					
Color	Industrial/ RAL colors range.																				
Gloss at 60°C	Over 50% (satin).																				
Solid content by volume	38±2																				
Recommended dryfilm thickness	40-60 microns (you can obtain a final thickness of 100 microns by applying “wet on wet” coats in 15 minutes intervals).																				
Calculated spreading rate*	10-6 (according to the coat thickness and color)																				
Recommended thinner	For spraying: 1-32; for brush: 18.																				
Touch dry**	15 minutes.																				
Hard coat**	12 hours.																				
Dry to recoat	for an additional coat of MONOCOAT FD: 15 minutes & up.																				
Shelf life**	24 months.																				
Surface preparation and specification																					
	Metal and Steel: Blast the area to Sa2.5 (per Swedish Standard). Where blasting is impractical, roughen mechanically to ST-3.																				
Galvanized Iron & Aluminum:	(with untreated surface) blast and roughen surface to a profile depth of 7-15 microns, 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. Rusty Metal: remove all loose rust using mechanical means to ST-3 (per Swedish Standard). Rinse with fresh water, allow to dry and apply the paint.																				
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																				
Paint application																					
Volume (%)	<table><tr><td>Method</td><td>Pressure (atm.)</td><td>Nozzle Orifice</td><td>Thinner</td><td>Thinning</td></tr><tr><td>Brush/roller</td><td></td><td></td><td>18</td><td>Up to 10%</td></tr><tr><td>Regular spray</td><td>3-5</td><td></td><td>1-32</td><td>Up to 15%</td></tr><tr><td>Airless spray</td><td>3-5</td><td>15-21”</td><td>1-32</td><td>Up to 7%</td></tr></table>	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning	Brush/roller			18	Up to 10%	Regular spray	3-5		1-32	Up to 15%	Airless spray	3-5	15-21”	1-32	Up to 7%
Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning																	
Brush/roller			18	Up to 10%																	
Regular spray	3-5		1-32	Up to 15%																	
Airless spray	3-5	15-21”	1-32	Up to 7%																	
Cleaning thinner	Thinner 1-32 or thinner 18.																				
Application remarks	Stir well before application and while painting. The thermoplastic properties of this product allow it to soften under heat without affecting its resistance.																				
Caution, Warning & General comments	See safety data sheet on page 9.																				

MONOCOAT F.D – METALLIC EFFECTS (Sparks – Glittery Effect, RAL Metallic)

Product code No.	464-XXX															
Product Description	Synthetic, one-component, paint, based on special metallic pigments, used as a top-coat to obtain a glittering metallic effect or a fine, highly elegant effect.															
Special features	Brilliant metallic effect in several textures to obtain an elegant look; For optimal results, apply through spray; Exceptionally fast drying; Good resistance to urban and light industrial corrosion; Retains original color and look for long terms.															
Suggested uses	Provides a highly economical and fast application process, where same day application and transportation of metal objects is required (while protecting the painted parts against mechanical damage). Designed for smithy and maintenance application on ferrous metal constructions and structures, concrete support pillars, lattice work, fences, banisters, gates, decorative objects (lampshades, lighting fixtures and ventilators) office equipment, electrical appliances and ferrous and galvanized metal objects in an urban and light industry environments. Prevent direct contact of this product with corrosive chemicals and acid or alkali. Do not apply directly on concrete or cement surface, unless a compatible primer is applied.															
Technical data																
Color	TAMBOUR Sparks – The Metallic and Metallic Glittering Effect RAL colors range															
Gloss at 60°C	Metallic															
Solid content by volume	40±2															
Recommended dry film thickness	As a top coat: 40-60 microns. As a primer and a top coat (directly on metal): When no primer is applied and the product is applied as both a primer and a top coat, ascertain that the total dry film thickness is over 60 microns. To reduce total cost of the paint system, it is desirable to apply a primer. The total thickness of the primer should be determined in a specification according to the infrastructure and environment type. ("wet on wet" application at 15 minutes intervals will yield a final thickness of up to 80 microns).															
Calculated spreading rate*	6-10 according to the coat thickness 40-60 microns, respectively. (sq. m/liter)															
Recommended thinner	For spraying: 1-32; for brush: 18.															
Drying Times **	Touch dry: 15 minutes; Handling: 1-2 hours; Hard coat: 12 hours Dry to recoat: for one additional coat of MONOCOAT FD: 15 mn and up.															
Shelf life**	24 months.															
Surface preparation and specification																
	Metal and Steel: Roughen metal through blasting to Sa2.5 (per Swedish Standard). Ascertain 30-40 microns roughness depth for a typical 120 dry film thickness system. Where blasting is impractical, roughen mechanically to ST-3.															
Galvanized Steel & Aluminum:	(with untreated surface) blast and roughen surface to a profile depth of 7-15 microns (sand blast), 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.															
Rusty Metal:	remove all loose rust using mechanical means to ST-3 (per Swedish Standard). Rinse with fresh water, allow to dry and apply the paint. Primer application is Mandatory.															
Concrete:	Allow to cure for 28 days. Remove loose particles and rinse with water at 120 atmospheres pressure. Allow to dry completely. In this case, apply GALVACOAT Primer for Concrete or MONOCOAT or Bonding Primer, 60 microns thick.															
Paint system	To obtain optimal resistance results, apply MONOCOAT F.D. Metallic Effects on top of a 40 microns thick primer coat (dry film) at least. Suitable primers include GALVACOAT, MONOCOAT, SUPER DURABLE PRIMER, FAST DRYING PRIMER & ANTIRUST.															
Paint application	<table><tr><td>Method</td><td>Pressure (atm.)</td><td>Nozzle Orifice</td><td>Thinner</td><td>Thinning Volume (%)</td></tr><tr><td>Brush/roller</td><td></td><td></td><td>18</td><td>Up to 10%</td></tr><tr><td>Regular spray</td><td>3-5</td><td></td><td>1-32</td><td>Up to 15%</td></tr></table> Optimal uniformity is obtained through spraying, by diluting up to 25%. Brush application is primarily suitable for narrow surfaces (lattice works, banisters, etc.).	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)	Brush/roller			18	Up to 10%	Regular spray	3-5		1-32	Up to 15%
Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)												
Brush/roller			18	Up to 10%												
Regular spray	3-5		1-32	Up to 15%												
Cleaning thinner	Thinner 1-32 or thinner 18															

(continued on page 22)

MONOCOAT F.D – METALLIC EFFECTS (continued from p.21)**Application remarks****Caution**

Stir well before application and while painting.

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Warning

Do not inhale fumes when spraying this product.

General comments

Never mix this material with others when not specifically recommended by us.

Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

* Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.

** At 25°C and 85% relative humidity.

ZINCOAT

Product code No.	477-001
Product Description	Superior anti-corrosive, zinc-rich, synthetic paint.
Special features	Superior, anti corrosive steel protection. Can be applied on steel after simple mechanical rust removal. Delays spreading of existing rust. Resistant to extreme weather conditions and to temperatures of up to 300°C.
Suggested uses	For repair of defective galvanized steel.

Technical data

Color	Grey.
Gloss at 60°C	Matt.
Solid content by volume	50%
Recommended dry Film thickness	30 microns.
Calculated spreading rate*	16.6 (sq. m/liter)
Recommended thinner	Tambour mineral spirit.
Touch dry**	30 minutes.
Hard coat**	24 hours.
Dry to recoat	24 hours.
Shelf life**	6 Months.

Surface preparation and specification

Blasting (preferred) or mechanical cleaning with a steel brush to remove loose rust. For heat resistance purposes, apply Zincoat in two thin coats, each 30 microns thick when dry. Wait about one week before first heating

Paint application	Method	Pressure (atm.)	Thinner	Thinning Volume (%)
	Brush/roller		Mineral Spirit	
			Tambour	5%
	Regular spray	4-5	1-32 or 18	15-20%

Cleaning thinner	Tambour mineral spirit.
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Application remarks	Stir well before application and while painting. Open the lid cautiously, due to possible gas formation.
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Caution	Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet. Do not inhale fumes when spraying this product.
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Warning	Never mix this material with others when not specifically recommended by us.
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General comments	Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.
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*	Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.
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**	At 25°C and 85% relative humidity.
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SILICONE ALUMINUM 540

Product code No. 602-020

Product Description One component aluminum paint for metal. Heat resistant up to 540°C. For maintenance and new structures. Based on silicone resin and aluminum pigment.

Suggested uses Designed for chimneys, furnaces, water-heaters, heat exhausts and steel heated to 540°C.

Technical data

Color Aluminum.

Solid content by volume 30%

Recommended dry

Film thickness 15-25 microns

Calculated spreading rate* 12-20 (sq. m/liter)

Recommended thinner 1-32.

Touch dry** 6 hours.

Hard coat** 24 hours. The final drying is performed at over 180°C by polymer curing in heat.

Dry to recoat 24 hours.

Shelf life** 24 Months.

Surface preparation and paint system

Clean the surface of any dirt and oils. Blast to Sa-2.5 (per Swedish Standard) or brush mechanically to ST-3. In this case, apply two coats of 40 microns total thickness. When anti-corrosive protection is required, apply a 50-75 microns thick Zinc Silicate Primer first.

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller	Suitable without thinner			
	Regular spray	40-60 PSI	1.5-2.0	1-32	Up to 5%
	Airless spray	1500-2000 PSI	0.013-0.015"	1-32	Up to 5%

Cleaning thinner Thinner 1-32

Application remarks Stir well before application and while painting. The thermoplastic properties of this product allow it to soften under heat without affecting its resistance.

Caution Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product.

Warning Never mix this material with others when not specifically recommended by us.

General comments Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

* Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.

** At 25°C and 85% relative humidity.

ACRYLIC SILICONE

Product code No.	602-
Product Description	One component acrylic paint. Resistant to constant temperature of 200°C.
Special features	Designed as a top-coat for objects subjected to hot environment, such as chimneys, external cover of furnaces, hot piping, etc. Apply over a suitable primer. High resistance to exterior, chemical and industrial environments.

Technical data

Color	RAL colors, per order.
Gloss at 60°C	Semi-gloss.
Solid content by volume	40%
Resistance to temperature	Constant conditions: up to 200°C. (random increase: up to 250°C).

Recommended dry Film thickness	30-40 microns.
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Calculated spreading rate*	10-13.3 (sq. m/liter)
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Drying hours	30°C	20°C	10°C
Touch dry	0.5-1	1	1-2
Transport dry	12	18+	24
Dry to recoat, min.	24	24	24

Hard coat**	Performed at over 180°C, through polymer crossing under heat.
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Shelf life**	24 Months.
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Paint application	Method	Nozzle Orifice	Thinner	Thinning Volume (%)
	Regular spray	1.5	1.04 or 1-32	0-15%, 20%
	Airless spray	15-17	1.04 or 1-32	0-15%, 5-10%
Cleaning thinner	Thinner 1-32			

Application remarks	Stir well before application and while painting. The thermoplastic properties of this product allow it to soften under heat without affecting its resistance.
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Caution	Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet. Do not inhale fumes when spraying this product.
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Warning	Never mix this material with others when not specifically recommended by us.
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General comments	Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.
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*	Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.
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**	At 25°C and 85% relative humidity.
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SOLAR COLLECTOR COATING

Product code No.	419-002
Product Description	Matt synthetic paint for solar energy collecting surfaces.
Special features	Excellent resistance to heat of up to 120°C. quick drying. Excellent absorption of solar energy.
Suggested uses	Designed as a coating for solar energy collecting surfaces.

Technical data

Color	Black
Gloss at 60°	Matt
Solid content by volume	50%
Recommended dry Film thickness	25 microns
Calculated spreading rate*	20 (sq. m/liter)
Recommended thinner	1-32.
Touch dry**	60 minutes
Hard coat**	24 hours.
Dry to recoat	24 hours.
Shelf life**	24 Months.

Surface preparation and paint system

Clean any foreign substance off surface by abrasive, blasting, chemical or mechanical means.

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			1-04	Up to 10%
	Regular spray	4	1.6	1-32	Up to 20%

Cleaning thinner Thinner 1-32

Application remarks Stir well before application and while painting. The thermoplastic properties of this product allow it to soften under heat without affecting its resistance.

Caution Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.
Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Warning Do not inhale fumes when spraying this product.
General comments Never mix this material with others when not specifically recommended by us. Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

* Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.

** At 25°C and 85% relative humidity.

STRIPPABLE PAINT

Product code No.	548-001
Product Description	Peeling paint based on air dried vinyl resin
Special features	Enables easy removal of the paint by peeling the dry paint film off the metal.
Suggested uses	Temporary anti-corrosive protection of metal objects until exposure and application of a permanent system is required, such as protection during storage at the production line, protection of machined objects, and maintaining smooth and clean surfaces. Do not apply on painted surfaces.

Technical data

Color	Blue (additional colors are available per special order).
Gloss at 60°	Satin
Solid content by volume	17%
Recommended dry Film thickness	30-120 microns. Any increase in the coat thickness enables easier peeling. The film thickness is required to ensure easy peeling of the paint, depending to the substrate's type. Apply on a small sample to determine the optimal film thickness. Not recommended for application over blasted surfaces.
Calculated spreading rate*	1.4-5.6 (sq. m/liter)
Recommended thinner	5-45
Touch dry**	15minutes
Hard coat**	6 hours.
Shelf life**	24 Months.

Surface preparation and paint system

Remove rust mechanically, aiming at the finest possible roughness. Do not apply over a blasted surface or a rough surface with a profile exceeding 10 microns.

Rinse with a thinner to remove contaminants such as dust and oils.

Paint application	Method	Pressure (atm.)	Thinner	Thinning Volume (%)
	Brush/roller		5-45	Up to 15%
	Regular spray	3-4	5-45	Up to 15%

Cleaning thinner	Thinner 4-45
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Application remarks

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product.

Warning

General comments

Never mix this material with others when not specifically recommended by us. See safety data sheet on page 9.

Paints for concrete



Tambour

Paints for concrete

Paints and coatings for concrete surfaces and walls. Designed to protect concrete from oils and chemicals, dust, washing and marketing. The coating provides a decorative look in a wide range of colors. Intended for concrete surfaces in warehouses, parking lots, garages, factory floors, offices and more.

Two component paints for floors coating

Epoxy paints line for application on concrete. Designed to make the floor washable, durable in moderate loads and lend it a uniform look. Used to refresh the color, obtain a decorative look and protect the concrete from chemicals.

Two component paints for floors coating (epoxy casting)

Glossy, high build, thinners free coating, up to 3 mm thick, excellent resistance to abrasion and chemicals, intended for floors in the chemical industry and in highly abrasive environments.



GALIT – SWIMMING POOL PAINT (for brushing only)

Product code No.	458-261
Product Description	Chlorinated resins based paint for immersion conditions.
Special Features	Excellent adhesion to concrete. Fast drying. Porous structure to prevent water blisters. Applied by brush only.
Suggested uses	For painting concrete swimming pools only.

Technical data

Color	Light blue 9386.
Gloss at 60°C	Matt - Satin.
Solid content by volume	24%
Recommended dry film thickness	40-60 microns.
Calculated spreading rate*	6-4 (sq. m/liter)
Thinner	1-04
Touch dry**	30 minutes.
Hard coat**	24 hours.
Dry to recoat	24 hours.
Shelf life**	24 months.

Surface preparation and specification

New concrete swimming pool: Paint the pool at least one month after concrete casting. During this time, fill the pool with clean water for several days, to rinse all salts and alkalis off the concrete. Etch very smooth walls using diluted hydrochloric acid (5-10%) and then rinse with pressurized water 2-3 times to remove acid residue. After rinsing it is desirable to test the pH of the surface, using litmus paper to ensure that the acidity is neutralized. Alternately, you may also etch the surface through light sandblasting, followed by thorough removal of dust and sand. Start paint application only after the pool is completely dry.

Repainting a painted pool: Apply GALIT over a small area to check adhesion of the coats and film uniformity. If the adhesion of one coat to another and the entire system to the substrate is satisfactory, proceed to prepare the surface as follows: Scrap off old, damaged or peeling paint, using hard bristled brushes or sandblasting, then rinse 2-3 time with pressurized water. Ascertain that the surface is free of any algae traces, dirt, dust and any other foreign matter prior to painting. It is recommended to wipe the surface with cloth dipped in 1-04 thinner. The recommended paint system includes, in any cased, two coats of paint at least. Color changes (retaining the overall hue) may occur over time, due to salts sedimentation, high chloride concentration and prolonged exposure to sun light. Color may be refreshed by rinsing with pressurized water or light rubbing with "Scotch".

Paint application	Application Method	Thinner	Thinning Volume (%)
Cleaning Thinner	Brush/Roller	1-04	0-5%

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product..

Warning

Never mix this material with others when not specifically recommended by us

General comments

See safety data sheet on page 9.

EPICATALAC CLEAR

Product code No.	572-110
Product Description	Two-component (Part A + Part B), epoxy varnish, based on epoxy polyamide resins.
Special Features	Excellent penetration into concrete.
Suggested uses	A binding coat for concrete, for an epoxy system on concrete, plaster, gypsum boards, etc.

Technical data

Color	Transparent.
Gloss at 60°C	Glossy.
Solid content by volume	44%
Recommended dry film thickness	20 microns.
Calculated spreading rate*	8 (sq. m/liter)
Thinner for dilution	4-100
Touch dry**	2 hours.
Hard coat**	3-4 hours.
Dry to recoat	2-4 hours or when paint is still tacky.

Two Pack Product

Mixing ratio by weight	A:B = 2.14:1
Mixing ratio by volume	A:B = 2:1
Induction period before painting**	30 minutes.
Pot life after mixing**	8 hours.
Shelf life**	24 months.

Surface preparation and specification

Allow 28 days for cure fresh concrete
Clean concrete with a steel brush or etch with acid and then rinse with water. Recommended method – light blasting.

Paint application	Application method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush / Roller			4-100	30-50%
	Regular Spray	3-4		4-100	30%-50%
	Airless Spray	4-5	0.011"-0.015"	4-100	30%-50%

Cleaning Thinner

performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product..

Warning

Never mix this material with others when not specifically recommended by us

General comments

See safety data sheet on page 9.

EPICATALAC S.L.

Product code No.	Part A: 572-101 Part B: 572-102				
Product Description	Epoxy solvent free polyamide primer for concrete floors and walls & other surfaces.				
Special Features	Excellent penetration into concrete, while reducing occurrence of typical bubbles and pin-heads in porous surfaces. High resistance to random spills of light chemicals (e.g., oils, fuels, weak acids and alkalis). Excellent resistance to contact with water. Designed for smoothing floors prior to applying thin coats of epoxy paints.				
Technical data (25°C)					
Color	Transparent – slightly yellowing in high build.				
Gloss at 60°C	Glossy.				
Solid content by volume	100%				
Recommended dry film thickness	Concrete Floors: 50-300 microns, Walls 50-100 microns.				
Calculated spreading rate	10 for a 100 microns thick coat. (sq. m/liter) 3.3 for a 300 microns thick coat (sq. m/liter)				
Recommended thinner	4-100 for thinning and cleaning.				
Touch dry**	2 hours				
Hard coat (25°C)**	72 hours				
Dry to recoat	16 hours minimum (at this stage the primer is still sticky, enabling application of the next coat). 7 days maximum.				
Mixing ratio by volume	A:B = 2:1				
Pot life After mixing**	2 hours at 25°C.				
V.O.C.	10 g/liter				
Shelf life**	24 months.				
Surface preparation and specification					
Concrete	Concrete surface must be free of dust and dirt. Remove oils with detergents and rinse thoroughly with tap water until surface is neutral. Ascertain that the surface is rough to a depth of 200 microns minimum, exposing the original, stable concrete surface. Cure fresh concrete for 28 days at least. It is recommended to rinse the concrete surface at a pressure of 150 atmospheres min., to remove salts. Allow to dry for 48 hours. Verify that surface pH is 6-10.				
Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush/roller			4-100	0-10%
	Airless spray	4-5	0.017-0.025"	4-100	0-5%
Cleaning thinner	4-100				
Application remarks	1.Stir thoroughly prior to application. 2.Do not apply at temperatures below 10°C and humidity higher than 85%.				
Caution,Warning& General comments	See safety data sheet on page 9.				

AFRAGUM TIX 30

Product code No.	White 577-233
Product Description	Two-component (Part A + Part B), solvent-less, elastomeric coat, based on tar - epoxy -polyurethane resins.
Special Features	Highly elastic, high resistance to water, alkali environment and random contact with diluted acids.
Suggested uses	Designed as a sealer of vertical and horizontal cracks and for filling concrete seams.

Technical data

Color at 60°C	White.
Gloss	
Solid content by volume	100%
dry film thickness	As required.
Calculated spreading rate*	6-7 running meters (of typical cracks).
Thinner for dilution	4-100
Touch dry**	About 30 minutes (may be slightly tacky under pressure).
Hard coat**	7 days
Dry to recoat	Between primer to topcoat – 2 hours. No interval between topcoat layers.

Two Pack Product

Mixing ratio by weight	A :B = 2:1
Color	Add color, by adding a paste in RAL colors to the mixture.

Induction period before painting**	About 20-30 minutes
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Pot life After mixing	4 hours.
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Shelf life**	6 months
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Surface preparation and specification

Open the crack and level it. Crack area shall be dry, clean, free of any loose particles. Use of a vacuum cleaner to remove dust is recommended. Apply a primer coat of EPICATALAC CLEAR (see technical sheet) and allow to dry for 2 hours before applying AFRAGUM TIX30.

Product Properties Table

a.Mechanical properties after curing at 20°C:	
Hardness	70 units Shore A.
Elongation	250%
Module at 100%	15.1 kg/sq.cm
Breaking load	24.5 kg/sq.cm
Adhesion to concrete (adhesion tested using an Alco meter).	Over 35 kg/sq.cm
b.Resistance to Chemicals	
Immersion in water for 3 months	Normal
Immersion in water at 50°C for one month	Normal
Immersion in an NaOH 10% solution for one month	Normal
Immersion in an NaOH 10% solution for 3 month	Normal
Immersion HCl 10% solution for one month	Normal
Immersion HCl 10% solution for 3 month	Normal
Absorption in water for one month	0.4%

Paint application	Flat trowel – ready for application
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Cleaning Thinner	4-100 (clean all application tools immediately).
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Application Remarks	1.Part B is an Amino material containing coal tar. Therefore, protect eyes and skin during application. Use gloves, coveralls and masks. 2.Wash hands thoroughly with soap and water after application.
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AFRAGUM TIX 30 (continued from p.88)

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product.

Warning

Never mix this material with others when not specifically recommended by us

General comments

Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

*

Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.

**

At 25°C and 85% relative humidity.

TAMAFLOOR TR

Product code No.	Part A : 577-741 Part B : 577-702
Product Description	Two-component (Part A + Part B) Glossy, solvent free epoxy coating. Used as a self leveling finish 0.6mm to 4mm thick. Can be cast as grout (epoxy concrete type) to a thickness of 5 to 15mm.
Special Features	Excellent water impermeability and good resistance to numerous chemicals, grease and solvents. Resistant to wear and mechanical stress. Easily cleaned. Highly convenient application during summer and winter. Superior self leveling properties and deep penetration into concrete floors.
Suggested uses	Designed as a high quality floors coating
Usage Instructions	Open the packaging carefully. Add part B into part A while mixing and then add the fine aggregate (sand) at the required proportion, according to the desired coat type (see below). To obtain a homogenous mixture, it is recommended to mix it in a dedicated container, equipped with a mechanical mixer.
Mixing ratio by volume	A : B = 100:60
Color	Add color, by adding a paste in RAL colors to the mixture.
Aggregate addition	Aggregate/ pigment mixing ratio: a. For self leveling coating: Epoxy(a+b) : Aggregate (size 0.1-0.4) = 2:1 b. For grout coating: Epoxy(a+b) : Aggregate (in three sizes from 0.1 to 2.5mm) = 1:5-7.
Pot life After mixing	3 hours at 23°C. Do not mix quantities which cannot be applied within the indicated pot-life. Temperatures rise rapidly in the mixing container. Rapid application of the coating on the surface enables heat dissipation and contributes to prolonged pot-life.
Recommended V.O.C.	0 g/liter
Surface preparation and specification	Allow the concrete to cure for 28 days. Surface shall be dry, clean and free of grease, laitance and loose particles. Remove all dirt and dust preferably using a vacuum cleaner. Roughen the surface when needed using shot blast, sand blast or a fraser. Maximum permitted water contents in the concrete you wish to coat is 4%.
Application of self leveling coating	Primer: Apply one coat of TAMFLOOR TR (A+B) without aggregate. Apply by using a short haired brush or roller. Cracks and Holes filling: It is recommended to prepare a mixture of one part TAMFLOOR Coating TR (A+B) and 5 parts fine aggregate and apply it directly on the primer coat. Topcoat: Apply the topcoat using a brush or a roller once the repairs are completed.
Special remarks	Direct exposure to sunlight may affect the gloss and fade the color, without affecting any other properties of the product. Gloss may be also affected during service and wear
Grout application	Primer: apply one coat of TAMFLOOR TR (A+B) without aggregate and without a thinner, about 300 microns thick. Apply a second coat of a mixture containing thin aggregate in a 7/1 ratio to the epoxy. Apply using a trowel made of plastic. You may also use a special compacting machine. There should be not interval between the coats application when the mixture does not contain thinners. Topcoat: Apply an epoxy free of aggregates coat as a sealant topcoat over the grout.
Touch dry**	8 hours.
Time to step over**	24 hours.

TAMAFLOOR TR (continued from p.90)

Hard coat**

7-14 days.

Shelf life**

24 months..

Cleaning Thinner

4-100

Mixing

two component product, supplied 5 or 18 or 20 liters kits, which contain the proper ratio of ingredients. The entire contents of each container must be mixed together.

Power mix Part A at slow speed to obtain a smooth homogeneous condition. After mixing part A add part B slowly with continued slow speed agitation. Then continue to mix slowly for 2 minutes.

The thinner addition (if necessary) should be made only after the two components are thoroughly mixed.

Application remarks

Do not apply when temperature is below 10°C and when the relative humidity exceeds 80%.

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

General comments

Do not inhale fumes when spraying this product.

Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

*

Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.

**

At 25°C and 85% relative humidity.

Electronic polyurethane paints

Electronic polyurethane paints

Two component polyurethane paints especially adapted to the hi-tech industries and to application on advanced medical equipment. May be applied on metal, non-metal and plastic. Silk smooth or rough finish

Autodur

Superior two components, acrylic polyurethane paint, designed and adapted especially for application on advanced medical equipment. Good resistance to various disinfectants and detergents as well as UV. Good adhesion to ABS and PVC plastics, without any primers. Finish: silk gloss in smooth or rough surface

Top dur

Two component polyurethane paint, developed and adapted especially for application on electronic equipment packaging. Available in various RAL colors, or at customer's request by special order: the off the shelf range of colors includes: black, white, RAL 9002, 7032, 7035 and more. Finish: silk gloss in smooth or rough surface. Excellent adhesion to aluminum, in direct application without an primer. May also be applied directly on ABS and PVC plastics. Quick drying (40 minutes)



TOPDUR

Product code No.	379-xxx – colored 399-xxx available colors				
Product Description	Two-component, polyurethane acrylic coat in satin gloss. Designed to serve as a primer and topcoat in one coat for treated aluminum, steel, and ferrous metals coated with a suitable epoxy primer.				
Special Features	Highly elastic, high resistance to water, alkali environment and random contact with diluted acids.				
Special features	Conforms to specifications of leading hi-tech corporations. Excellent hardness and resistance to scratching. Fast drying. Good adhesion to ABS, PVC, etc. Can be applied as a primer and a top coat in one layer on treated aluminum.				
Suggested uses	Designed for painting electronic packaging and plastic.				
Technical data					
Color at 60°C	Black, white, RAL7035, RAL 7032, RAL 9002 and other RAL shades or samples, by special order.				
Gloss	Satin.				
Solid content by volume	70%				
dry film thickness recommended	20-40 microns.				
Calculated spreading rate* (sq. m/liter)	10-20				
Thinner for dilution	10, 11 – according to environmental conditions				
Touch dry**	10-20 minutes				
Hard coat**	45 minutes in an accelerated process, including wait time of 15 minutes and 30 minutes in an oven, at 80°C.				
Dry to recoat	1 hours.				
Two component paint					
Mixing ratio by volume	A:B = 4:1				
Mixing ratio by weight	A :B = 5:1				
Pot life After mixing	6 hours.				
Shelf life**	24 months				
Surface preparation and specification	Surfaces shall be dry, clean and free of any dust, oil, and other contaminants. Prior to application on metals prepare surface through a conversion process and apply an epoxy primer, such as Epoxy Primer 6030. Aluminum: Conversion treatment without a primer. Plastic: clean off any oils, without a primer.				
Paint application	Application method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Regular Spray	4		10, 11	20-40%
Cleaning Thinner	11				
Application Remarks	1.Stir thoroughly before use. 2.Mix part A and part B before diluting. 3.Topcoat effect varies according to the air pressure and nozzle orifice.				
Caution, Warning & General comments	See safety data sheet on page 9.				

AUTODUR

Product code No.	392-								
Product Description features	Two-component (part A + part B), polyurethane acrylic topcoat, high gloss. Special Excellent exterior durability. Fast drying. Long term retention of original gloss and color. Abrasion resistance. Good resistance to fuel, oil, detergents and medical disinfectants.								
Suggested uses	Especially designed as a topcoat for automobiles, buses, railway cars and metal constructions which are exposed to severe climatic conditions. Suitable for medical equipment and electronic packaging products. Technical data								
Color at 60°C	White (additional colors by special order).								
Gloss	Satin or Glossy.								
Solid content by volume	44% (depending on the color).								
dry film thickness recommended	25 microns.								
Calculated spreading rate* (sq. m/liter)	About 18 (depending on the color).								
Thinner for dilution	11								
Touch dry**	30-60 minutes								
Hard coat**	16 hours at 20° or 45 minutes at 55°C.								
Dry to recoat	1 hours.								
Two component paint									
Mixing ratio by weight	A:B = 4:1 (cure cat. No. 392-082)								
Induction period before painting**.	15 minutes.								
Pot life After mixing	8 hours.								
Shelf life**	24 months								
Surface preparation and specification	Automobiles painting: Clean dust and dirt and apply COMPACT FILLER. Steel: Blast to Sa-2.5 (Swedish Standard) or suitable chemical treatment and apply epoxy primer such as STRONTIUM CHROMATE or EPOXY PRIMER 6030. Aluminum: a 20-25 microns thick coat of STRONTIUM CHROMATE PRIMER.								
Paint application	<table><tr><td>Application method</td><td>Pressure (atm.)</td><td>Thinner</td><td>Thinning Volume (%)</td></tr><tr><td>Regular Spray</td><td>3-4</td><td>11</td><td>20-30%</td></tr></table>	Application method	Pressure (atm.)	Thinner	Thinning Volume (%)	Regular Spray	3-4	11	20-30%
Application method	Pressure (atm.)	Thinner	Thinning Volume (%)						
Regular Spray	3-4	11	20-30%						
Cleaning Thinner	11								
Application Remarks	It is recommended to apply one full spray coat and then a second full coat. Keep the products packaging tightly closed. Do not apply in highly humid conditions or temperatures below 10°C.								
Caution	Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.								
Warning	Do not inhale fumes when spraying this product. Never mix this material with others when not specifically recommended by us.								
General comments	See safety data sheet on page 9.								

Paints for wood



Tambour

Paints for wood

Paints and varnishes for industrial application on furniture and wood products, in various quality and finish levels. This line includes polyurethane and acrylic based quality coating, one component, two component paints, including acid-hardened coatings.

Polyurethane varnishes

Two component, transparent, quick drying, highly elastic polyurethane top coat varnish. The use of compatible hardening agent enhances resistance to yellowing and provides superior hardness. Available in a range of colors. For interior use only.

Acrylic varnishes (duracryl)

Two component, quick drying, transparent, glossy or silk gloss varnishes, based on polyurethane – acrylic resins. Provide good resistance to chemicals, water and cleaning agents. Highly elastic. These varnishes retain the natural hue and gloss of the wood. Designed for application on parquet floors and expensive furniture. for interior use only.

Paints for wood durlux 2000

Two component, polyurethane based paint. Designed for application on MDF, fiberboard and other wood products. Quick drying, resistant to mechanical wear

Staining solutions – beitz

A range of staining solutions of superior quality, user friendly, lead free. Designed for application on any type of wood, including plywood. This line includes water diluted staining solution (W), thinner diluted solutions (S), or water and thinner diluted solutions (W/S).

Wood finish

Two component, transparent, silk gloss, varnish/ top coat, based on amino – alkyd resins, hardened by an acidic catalyst. Good resistance to humidity and detergents. For interior use only.



POLYURETHANE TOPCOAT 309/XX

Product code No.	385
Product Description	Two-component, polyurethane topcoat clear varnish for wood.
Special features	Fast drying topcoat varnish for natural wood and plywood. High hardness and resistance to household materials, for interior use.
Technical data	
Color	Clear.
Gloss at 60°C	Available at all gloss types: 90, 60, 30, 20, 10.
Solid content by volume	
Recommended	46±1% (Part A only).
Calculated spreading rate* (sq.m/liter)	100-150
Recommended thinner	Thinner 11 in winter or thinner 10 in summer at a rate of 10-30% of the volume. In especially hot days you may add up to 20% Retarder 4-39 to the thinner.
Touch dry**	10-25 minutes.
Hard coat**	4 hours.
Dry to recoat**	1 hour.
Mixing ratio	Varnish: curing agent (451 to avoid yellowing or 480) = 2:1
Pot life After mixing**	3 hours.
Shelf life**	12 months.
Surface preparation and specification	
	Apply one or two coats over a suitable primer coat through regular spay, using nozzle orifice 0.6-0.8 or airless spray equipment, using nozzle orifice 0.016-0.021 on dust-free wood. Dry to recoat times range from 15-20 minutes.
Note	Yellowing of the varnish and the wood may be avoided by adding 5% anti-yellowing additive Cat. No. 360-017 to the varnish prior to adding the cure, when using cure 451.
Caution	
	Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.
	Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.
	Do not inhale fumes when spraying this product.
	Do not inhale fumes when spraying this product.
Warning	Never mix this material with others when not specifically recommended by us.
General comments	
	Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

DUR 120 GLOSSY

Product code No.	385-020
Product Description	Two-component (Part A + Part B), clear polyurethane varnish.
Special features	Easily washable topcoat. Provides elegant look to wood. Resistant to rubbing, scratching, hot water, tea, coffee, alcohol and detergents.
Suggested uses	Designed for application on high quality furniture.

Technical data

Color	Clear
Gloss at 60°C	Glossy
Solid content by volume	
Recommended	27%
Recommended thinner	11 regular, 10 slow for summer.
Calculated spreading rate* (sq.m/liter)	6-8 (depending on wood quality)\
Touch dry**	3-4 hours.
Hard coat**	4 hours.
Dry to recoat**	24 hours.

Two Pack Product

Mixing ratio by volume	A :B – 4:1
Pot life After mixing**	About 6 hours.
Shelf life**	12 months.

Surface preparation and specification

Surface shall be dry, clean, free of all oil and grease, dust, glue traces and any other foreign material. File the surface you wish to paint thoroughly. Mix Part A with Part B: Stir part A in its container thoroughly, add part B into part A gradually, constantly stirring thoroughly. Diluting: When DUR 120 is used as a primer, dilute by 30-40% of the volume. When applied as a topcoat, dilute by 25-35% of the volume. DURLUX PRIMER (code 385-190) can be used instead of DUR 120 as a primer.

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume
	Brush			10, 11	As primer 30-40% As topcoat 25-35%
	Regular spray	3-4	1.4-1.6	10, 11	As primer 30-40% As topcoat 25-35%

Cleaning Thinner	11, clean all application equipment immediately.
Application remarks	1. Do not use linseed oil or sanding sealer prior to applying DUR 120 or DURLUX PRIMER. 2. You may color the wood prior to painting with a water based staining (allow 24 hours for drying before paint application). 3. You may add color to the DUR 120 mixture (A+B) by adding staining solutions, up to 10% by volume.

Caution, Warning & General comments

See safety data sheet on page 9.

DUR 121 MATT

Product code No. 385-030
Product Description Two-component (Part A + Part B), clear, matt polyurethane varnish.
Special features Easily washable topcoat. Provides elegant look to wood. Resistant to rubbing, scratching, hot water, tea, coffee, alcohol and detergents.
Suggested uses Designed for application on high quality furniture.

Technical data

Color Clear
Gloss at 60°C Matt.
Solid content by volume
Recommended 23%
Recommended thinner 111 regular, 10 slow for summer.
Calculated spreading rate* (sq.m/liter) 6-8 (depending on wood quality).
Touch dry** 3-4 hours.
Dry to recoat** 24 hours.

Two Pack Product

Mixing ratio by volume A :B – 4:1
Induction period before painting** **About 15 minutes.**
Pot life After mixing** About 6 hours.
Shelf life** 12 months.

Surface preparation and specification

Surface shall be dry, clean, free of all oil and grease, dust, glue traces and any other foreign material. Sand the surface you wish to paint thoroughly. Mix Part A with Part B: Stir part A in its container thoroughly, add part B into part A gradually, constantly stirring thoroughly. DURLUX PRIMER (code 385-190) can be used instead of DUR 121 as a primer.

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume %
					As primer
Brush				10, 11	30-40%
					As topcoat
Regular spray	3-4	1.4-1.6		10, 11	25-35%
					As primer
					30-40%
					As topcoat
					25-35%

Cleaning Thinner 11, clean all application equipment immediately.
Application remarks 1. Do not use linseed oil or sanding sealer prior to applying DUR 120 or DURLUX PRIMER.
 2. You may color the wood prior to painting with a water based staining (allow 24 hours for drying before paint application).
 3. You may add color to the DUR 120 mixture (A+B) by adding staining solutions, up to 10% by volume.

Caution, Warning & General comments

See safety data sheet on page 9.

DUR 125 for WOODEN FLOORS

Product code No.	388-023
Product Description	Two-component (Part A + Part B), clear, satin gloss polyurethane resins based coat.
Special features	Excellent resistance to wear, acids, alkali solutions and alcohols. Satin gloss coat, may be washed with soap water.
Suggested uses	Designed for application on wooden floors in gym halls, theater stages, etc.
Technical data	
Color	Clear
Gloss at 60°C	Satin.
Solid content by volume	
Recommended	27%
Recommended thinner	11 regular, 10 slow for summer.
Calculated spreading rate* (sq.m/liter)	6-8 (depending on wood quality)\
Touch dry**	For stepping over - 48 hours, min.
Hard coat**	Final – 7 days.
Dry to recoat**	24 hours. Between primer to topcoat: up to 48 hours.
Two Pack Product	
Mixing ratio by volume	A :B – 2:1
Pot life After mixing**	About 6 hours.
Shelf life**	12 months.
Surface preparation and specification	
Surface shall be dry, clean, free of all oil and grease, dust, glue traces and any other foreign material. Sand the surface you wish to paint thoroughly, until smooth. Do not apply linseed oil or sanding sealer on the wood.	
Mix Part A with Part B: Stir part A in its container thoroughly, add part B into part A gradually, constantly stirring thoroughly. Do not mix large quantities of the mixture. Only mix the quantity required for one day's work.	
Primer: Apply mixed DUR 120 (A+B) Code 385-020 .	
Diluting: by about 25% with thinner 11 – primer application is performed by deep penetration brushing into the wood, using a full brush and applying along the wood grain.	
Topcoat: Allow the primer coat to dry for several hours and once it is dry enough (no later than 48 hours) sand the surface, remove the dust, rub and apply DUR 125, after mixing the two components (A+B) and adding 10% thinner to the mixture. When a higher build is required, you may add a second coat of DUR 125 after an interval of 24 hours – it is recommended to sand the coat lightly, to ensure good adhesion between the layers.	
Paint application	Method Pressure (atm.) Nozzle Orifice Thinner
	Thinning Volume
Cleaning Thinner	Brush 10, 11,12
	About 10%
Application remarks	Regular spray 3-4 1.4-1.6 10, 11 ,12
	About 10%
11 (clean all application equipment immediately).	
1. Avoid staining Formica, cement and marble stairs.	
2. Strictly observe all safety measures.	
3. Provide adequate ventilation and observe fire safety rules during application.	
4. Drying times refer to temperatures over 15°C.	
5. Do not use linseed oil or sanding sealer prior to applying the paint system.	

Caution, Warning & General comments See safety data sheet on page 9.

ACRYLIC H.S. PRIMER 736

Product code No.	396-036
Product Description	Two-component (Part A + Part B) clear, polyurethane resin based primer.
features	Fast drying, excellent filling capacity, easily sanded.
Suggested uses	Designed for application as a primer for clear varnish systems, such as DURACRYL and DURLUX 2000

Technical data

Color	Clear.
Gloss at 60°C	Glossy.
Solid content by volume	28.7%
Recommended dry film thickness	240 gram/sq. meter in two coats (120 each coat).
Calculated spreading rate* (sq.m/liter)	8 -9 liter
Recommended thinner	10 or 11, 20%-30% dilution.
Touch dry**	10-15 minutes.
Hard coat**	2-3 hours.
Dry to recoat**	1 hour.

Two Pack Product

Mixing ratio by volume Primer 736: Hardner 436 = 5:1

Pot life After mixing** 4-5 hours.

Shelf life** 12 months.

Surface preparation and specification

Surface shall be clean, sanded. Apply 1-2 ACRYLIC PRIMER 736 mixed with curing agent 436 at a ratio of 5:1 and diluted with thinner 10 or 11, according to weather conditions.

Cleaning Thinner 11 (clean all application equipment immediately)..

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Warning

Do not inhale fumes when spraying this product.

Never mix this material with others when not specifically recommended by us.

General comments

reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

* Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.

** At 25°C and 85% relative humidity.

DURACRYL

Product code No.

Glossy: 396-003
Satin: 396-000
Matt: 396-044

Product Description

Special features

Two-component, (Part A + Part B), clear varnish, based on acrylic resins. Good adhesion to all wood types. Fast drying, resistant to chemicals, alcohol based cleaning materials, water and scratches. Highly elastic. Prolonged durability. Retention of wood color and gloss. Enables easy sanding and recoating both after a short drying interval and recoating after many years.

Suggested uses

Recommended for painting expensive furniture, such as pianos, kitchen and office furniture and wherever a superior coating is required to retain the natural color and beauty of the wood. Approved for coating kitchen furniture.

Technical data

Color

Clear.

Gloss at 60°C

Glossy, satin, matt..

Solid content by volume

21%

Recommended

dry film thickness

240 gram/sq.meter in two coats (120 each coat).

Calculated spreading

rate* (sq. m/liter)

6-8, depending on the wood quality.

Recommended thinner

Regular – 11, slow (for summer) – 10, 20-30%..

Touch dry**

1 hour.

Hard coat**

For sanding 4-5 hours.

Dry to recoat

30 minutes

Two Pack Product

Mixing ratio by volume

A :B – 10:1

Pot life After mixing**

24 hours.

Shelf life**

12 months.

Surface preparation and specification

Surface shall be dry, clean, free of all oil, grease, dust and any other foreign material. Sand surface thoroughly prior to application. For mixing Part A with Part B, open container of Part A carefully, stir thoroughly, add Part B gradually, constantly stirring thoroughly. Mix the components about 15-30 minutes prior to use. Mixing ratio by volume is: A = 10, B = 1. The product is usually applied in two coats. DURACRYL diluted 30% is applied as a first coat. Alternately, you may apply ACRYLIC PRIMER 736, which provides good filling and enables sanding. Allow to dry for about one hour. You may sand after about 4-5 hours. The second coat can be applied after about one hour (without sanding). Dilute the second and third coat by 20-30%.

by

Paint application

Method	Thinner	Thinning Volume(%)
Regular spray	10 (slow), 11 (regular)	First coat 30%, another coat 2-30%/
Airless spray	10 (slow), 11 (regular)	First coat 30%, another coat 2-30%/

Cleaning Thinner

11 (clean all application equipment immediately)..

DURACRYL (continued from p.115)

Application remarks

1. Do not use linseed oil or sanding sealer.
2. DURACRYL was tested at the Techion as a coating for kitchen furniture and passed all the strict tests required for such a coating.
3. Stir well before application and while painting..

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Warning

Do not inhale fumes when spraying this product.

Never mix this material with others when not specifically recommended by us.

General comments

reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

*

Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.

**

At 25°C and 85% relative humidity.

CONCENTRATED STAINING SOLUTION

Lead and Chromates Free

Product code No. 652-XXX

Product Description A series of the highest quality, lead free user friendly staining solutions. **Special**

features

Provides a decorative quality while maintaining the natural texture of the wood. Available in a wide range of colors.. Resulting hue may change according to the following parameters

- Wood type, initial wood color and its absorption capacity.
- Concentration of the staining solution – color changes according to concentration.
- Amount of staining solution applied to each surface unit. The higher the amount, the darker the color obtained.
- Number of coats.
- Application method.
- Type of varnish applied on the staining solution.

Suggested uses

Series

Wood coloring solutions.

1. W/S - Concentrated staining solutions, diluted with water or solvent W/S.
2. S - Concentrated staining solutions, diluted with solvents.
3. W - Concentrated staining solutions, diluted with water.

Recommended thinner

Tambour Code	Product Name	Recommended Thinner
W/S 5000	W/S staining solution	Water, thinner 21, 11, acetone,
W 100	W staining solution	Water
S 500	S staining solution	Thinner 21, 11, acetone.

Color

Gloss at 60°C

Per color chart or by special order.

Special staining solution

The staining solution is ready for use on the basis of water or a thinner. Tambour laboratory offers its services to supply colors which are not included in the colors catalogue.

Surface preparation and specification

The staining solutions series can be applied on any type of wood, including plywood.

Paint application

Preparation instructions

Spray, rubbing, dipping.

Carefully pour the required quantity into a suitable container and dilute as recommended (only in the case of concentrated solutions).

Recommended dilution ratio [thinner: stain]

Dark color 1:4 up to 1:9.
Light color 1:9 up to 1:100.

Spray methods

Use 0.9-1.2 mm nozzle orifice.
Application quantity: 80-100 gram/sq.meter.

Rubbing method

Dip a sponge or a cotton cloth and spread evenly, directly over the wood or the plywood.

Application quantity: 80-100 gram/sq.meter.

Pastel hues

W/S stain series and S series can be added directly to varnish at the rate of 0.5-3% of its weight. W series cannot be added to varnish.

Drying time

When using water based staining solution, wait for complete drying of the stain, according to the primer and varnish application. Allow to dry for at least 5-6 hours at 25°C and 60% relative humidity. Drying time can be reduced by drying in a stove, at 50°C max.

Shelf life

Store in shaded and ventilated areas, at temperatures ranging from 25°C to 28°C.

Shelf life**

24 months.

Caution, Warning & General comments

See safety data sheet on page 9.

VARNIT CLEAR LACQUER FOR DECKS

Product code No.	386-010															
Product Description	One component clear lacquer for wood decks															
Special features	Especially wear resistant. Maintains the natural texture of the wood. Light and easy application.															
Suggested uses	Designed for roller application on wooden decks															
Technical data																
Color	Clear.															
Gloss at 60°C	Matt															
Solid content by volume	39%+-1															
Recommended thinner	11 regular, 10 slow for summer.															
Calculated spreading rate* (sq. m/liter)	6-8, depending on the wood quality.															
Touch dry**	For stepping over - 48 hours, min.															
Hard coat**	Final – 7 days.															
Dry to recoat	24 hours. Between primer to topcoat: up to 48 hours.															
Two Pack Product																
Mixing ratio by volume	A :B – 2:1															
Pot life After mixing**	About 6 hours.															
Shelf life**	12 months.															
Mixing	two component product, supplied 5 or 18 or 20 liters kits, which contain the proper ratio of ingredients. The entire contents of each container must be mixed together. Power mix Part A at slow speed to obtain a smooth homogeneous condition. After mixing part A add part B slowly with continued slow speed agitation. Then continue to mix slowly for 5 minutes. Allow an additional 15 minutes induction time before application. The thinner addition (if necessary) should be made only after the two components are thoroughly mixed.															
Surface preparation and specification	Surface shall be dry, clean, free of all oil and grease, dust, glue traces and any other foreign material. Sand the surface you wish to paint thoroughly, until smooth. Do not apply linseed oil or sanding sealer on the wood. Mix Part A with Part B: Stir part A in its container thoroughly, add part B into part A gradually, constantly stirring thoroughly. Do not mix large quantities of the mixture. Only mix the quantity required for one day's work. Primer: Apply mixed DUR 120 (A+B) Code 385-020 . Diluting: by about 25% with thinner 11 – primer application is performed by deep penetration brushing into the wood, using a full brush and applying along the wood grain. Topcoat: Allow the primer coat to dry for several hours and once it is dry enough (no later than 48 hours) sand the surface, remove the dust, rub and apply DUR 125, after mixing the two components (A+B) and adding 10% thinner to the mixture. When a higher build is required, you may add a second coat of DUR 125 after an interval of 24 hours – it is recommended to sand the coat lightly, to ensure good adhesion between the layers.															
Paint application	<table><tr><td>Method</td><td>Pressure (atm.)</td><td>Nozzle Orifice</td><td>Thinner</td><td>Thinning Volume(%)</td></tr><tr><td>Brush</td><td></td><td></td><td>10,11,12</td><td>About 10%</td></tr><tr><td>Regular spray</td><td>3-4</td><td>1.4-1.6</td><td>10,11,12</td><td>About 10%</td></tr></table>	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume(%)	Brush			10,11,12	About 10%	Regular spray	3-4	1.4-1.6	10,11,12	About 10%
Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume(%)												
Brush			10,11,12	About 10%												
Regular spray	3-4	1.4-1.6	10,11,12	About 10%												
Cleaning Thinner	11 (clean all application equipment immediately)..															
Application remarks	1. Avoid staining Formica, cement and marble stairs. 2. Strictly observe all safety measures. 3. Provide adequate ventilation and observe fire safety rules during application. 4. Drying times refer to temperatures over 15°C. 5. Do not use linseed oil or sanding sealer prior to applying the paint system.															

STRONTIUM CHROMATE EPOXY PRIMER (continued from p.118)

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Warning

Do not inhale fumes when spraying this product.

Never mix this material with others when not specifically recommended by us.

General comments

reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

* Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.

** At 25°C and 85% relative humidity.

Fire Retarding Paints

Fire Retarding Paints

Paints and coatings in various thicknesses, applied to wood and metal objects, as fire retardants. These coat create an insulating layer capable of fire damage for up to two hours, this delay provides additional time for summoning help controlling a fire and enables organized evacuation, thus preventing injuries.

Pyroted SPX

One component, inducement, high build, matt paint to protect steel structures from collapsing (due to metal over-heating), for up to 120 minutes. Conforms to B.S 476 PA20/21. designed for application on exteriors and interiors in a range of suitable colors.

Copon LS 3000/4000

Intumescent, two component, transparent, slightly opaque, glossy, fire retarding epoxy paint. Certified by the standards institute, I.S 755. Fire rated as class IV, per B.S 476 part 6-7. Good resistance to abrasion.

LS3000 – opaque epoxy paint designed for application on metal and concrete.

LS 4000-clear epoxy paint designed for application on wood

aluminum, in direct application without an primer. Mayalso be applied directly on ABS and PVC plastics.Quick drying (40 minutes)

Acrylic LS 2000

Fire retarding, intumescent acrylic, matt silk paint. Certified by the standards institute (I.S 755). Fire rated as class IV. Conforms to B.S 476, part 7 class 1 fire rating. Designed for application on wood, concrete and metal, over a compatible primer. For interiors only.



LS 2000

Product code No.	666-115
Product Description	Fire retarding, one-component, intumescent acrylic paint.
Special Features	Conforms to standard B.S. 476, Part 7, Class 1 Fire Rating, approved by the Standards Institute as Class IV paint against spreading fires (IS 755).
Suggested uses	Protection of wood, metal, plastered or concrete walls against fire. Suitable for interior use only. The product's properties are lost upon contact with water.

Technical data

Color	White.
Gloss at 60°C	Matt - Satin.
Solid content by volume	50%
Recommended dry film thickness	75 microns, dry.
Calculated spreading rate*	6.7 (sq. m/liter)
Thinner	1-32
Touch dry**	30 minutes.
Hard coat**	24 hours.
Dry to recoat	24 hours.
Shelf life**	24 months.

Surface preparation and specification

Steel: Surfaces must be, clean and dry. Blast to Sa 2.5 (per Swedish Standard) or clean with mechanical means. Apply a primer coat of Super Durable Primer or GALVACOAT.

Concrete and Plaster: Clean lightly and remove loose cement.

Wood: Sandpaper thoroughly and apply directly without a primer. Apply 2-3 coats of LS 2000. Thin the first coat with thinner 1-32 by about 20-25% and apply the two other coats without thinning to obtain a dry film thickness of 150 microns at least. For spraying, dilute up to 10% with thinner 1-32.

Paint application	Application Method	Thinner	Thinning Volume (%)
	Regular spray	1-32	10%
Cleaning Thinner	1-32		

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product..

Warning

Never mix this material with others when not specifically recommended by us

General comments

See safety data sheet on page 9.

LS 3000

Product code No.	666-120
Product Description	Fire retarding, two-component (Part A + Part B), intumescent, clear epoxy paint.
Special Features	Conforms to standard B.S. 476, Part 7, Class 1 Fire Rating, approved by the Standards Institute as Class IV paint against spreading fires (IS 755).
Suggested uses	Protection of wood, metal, aluminum and concrete walls against fire. Good resistance to wear, chemicals, water, and thinners. Suitable for interior and exterior use. It is recommended to renew exterior paint every five years.

Technical data

Color	Gray RAL 7023.
Gloss at 60°C	Matt - Satin.
Solid content by volume	80%
Recommended dry film thickness	100 microns, dry.
Calculated spreading rate*	8 (sq. m/liter)
Touch dry**	2 hours.
Hard coat**	16 hours.
Dry to recoat	16 hours min. 7 days max.

Two Pack Product

Mixing ratio by weight	A:B = 4:1
Pot life after mixing**	1.5 - 2 hours at 25°C
Shelf life**	24 months.

Mixing

two component product, supplied 5 or 18 or 20 liters kits, which contain the proper ratio of ingredients. The entire contents of each container must be mixed together.

Power mix Part A at slow speed to obtain a smooth homogeneous condition. After mixing part A add part B slowly with continued slow speed agitation. Then continue to mix slowly for 5 minutes. Allow an additional 15 minutes induction time before application.

The thinner addition (if necessary) should be made only after the two components are thoroughly mixed.

Surface preparation and specification

Steel: Surfaces must be, clean and dry. Blast to Sa 2.5 (per Swedish Standard). Apply a coat of anti corrosive primer, such as EPOXY EA9 RED, or STRONTIUM CHROMATE EPOXY PRIMER. Then apply two or more coats of LS 3000.

Concrete: Surface shall be clean and dry. Apply one coat of clear EPICATALAC, Clear, (A+B) diluted 1:1 with thinner 4-100. Then, apply two or more coats of COPON LS 3000.

Wood: Sandpaper thoroughly and apply directly without a primer. Apply 2-3 coats of COPON LS 3000. Minimum total dry film thickness 200 microns. Thin the first coat with thinner 4-100 by about 20-30% and apply the two other coats diluted by about 5% with thinner 4-100.

Paint application	Application method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
	Brush / Roller			4-100	10%
	Regular Spray	3-4	0.015"-0.021"	4-100	10%-20%
	Airless Spray	6	0.021"-0.023"	4-100	0%-5%

Cleaning Thinner

Caution, Warning & General comments

See safety data sheet on page 9.

Military / aviation



Tambour

Military / aviation

One and two component produced, produces according to military and international standards.

Resigned for application on land, air and sea combat machines and armament, including tanks, ships and fighter plants. Superior resistance above and below the water line and climatic conditions at high altitudes.



POLYURETHANE TOP COAT FOR JET AIRCRAFT

Product code No.	390-										
Product Description	Two-component (Part A + Part B), polyurethane, aliphatic topcoat. Conforms to standard MIL-C-83286.										
Special features	Glossy topcoat. Tough and elastic. Excellent exterior durability in all weather conditions. Resistant to chemicals, fuels, oils, etc. Tested and approved as conforming to McDonnell Douglas specification requirements and to IAI specification MS-100028..										
Suggested uses	Topcoat for aviation accessories or metal structures exposed to severe climatic conditions.										
Technical data											
Color	White (additional colors according to FED STD)..										
Gloss at 60°C	Glossy (also available in matt or satin).										
Solid content by volume											
Recommended dry film thickness	42% (depending on the color). 20-30 microns.										
Calculated spreading rate* (sq.m/liter)	14-21 (depending on the color).										
Recommended thinner	11										
Touch dry**	2 hours.										
Hard coat**	12 days.										
Dry to recoat**	1-2 hours.										
Two Pack Product											
Mixing ratio by volume	A :B = 1:1 (for glossy paint).										
Induction period before painting**	15-20 minutes										
Pot life After mixing**	6 hours.										
Shelf life**	24 months.										
Mixing	two component product, supplied 5 or 18 or 20 liters kits, which contain the proper ratio of ingredients. The entire contents of each container must be mixed together. Power mix Part A at slow speed to obtain a smooth homogeneous condition. After mixing part A add part B slowly with continued slow speed agitation. Then continue to mix slowly for 5 minutes. Allow an additional 15 minutes induction time before application. The thinner addition (if necessary) should be made only after the two components are thoroughly mixed.										
Surface preparation and specification	Clean surface from oil, grease and dirt. On untreated aluminum: apply a coat of WASH PRIMER MIL-C-8514 and STRONTIUM CHROMATE EPOXY PRIMER SYSTEM MIL-P-23377.										
Paint application	<table><tr><td>Method</td><td>Pressure (atm.)</td><td>Nozzle Orifice</td><td>Thinner</td><td>Thinning Volume%</td></tr><tr><td>Brush/roller</td><td>3-4</td><td>1.6</td><td>11</td><td>10-15%</td></tr></table>	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume%	Brush/roller	3-4	1.6	11	10-15%
Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume%							
Brush/roller	3-4	1.6	11	10-15%							
Cleaning Thinner	11										
Application remarks	1. Stir thoroughly before application and while painting. 2. Do not apply when temperatures are below 10°C and high humidity. 3. Keep container of part B tightly closed at all times.										
Caution	Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.										
Warning	Do not inhale fumes when spraying this product. Never mix this material with others when not specifically recommended by us.										
General comments	See safety data sheet on page 9.										

EPOXY POLYAMIDE PAINT

Product code No.	496-xxx																				
Product Description	Two-component epoxy polyamide paint, designed as a topcoat for epoxy paint systems.																				
Special features	Excellent durability in random contact with various chemicals, solvents, sea water and sever climatic conditions. Conforms to American Standard MIL-C-22750.																				
Suggested uses	Designed as a finishing topcoat of epoxy paint system on metal objects.																				
Technical data																					
Color	Per request.																				
Gloss at 60°C	Satin, glossy, matt.																				
Solid content by volume	48%																				
Recommended dry film thickness	40 microns.																				
Calculated spreading rate* (sq.m/liter)	12																				
Touch dry**	1 hours.																				
Hard coat**	7 days.																				
Dry to recoat**	16-24 hours.																				
Two Pack Product																					
Mixing ratio by volume	A :B = 4:1																				
Induction period before painting**	30 minutes																				
Pot life After mixing**	8 hours.																				
Shelf life**	24 months.																				
Surface preparation and specification																					
Abrade to Sa-2.5 (per Swedish Standard). Apply one coat of a suitable epoxy primer, such as EPOXY PRIMER EA-9, STRONTIUM CHROMATE EPOXY PRIMER, EPOXY PRIMER 6030 or any other primer we recommend.																					
Paint application	<table><tr><td>Method</td><td>Pressure (atm.)</td><td>Nozzle Orifice</td><td>Thinner</td><td>Thinning Volume</td></tr><tr><td>Brush/roller</td><td></td><td></td><td>4-100</td><td>Up to 5%</td></tr><tr><td>Regular spray</td><td>3-4</td><td>1.6</td><td>4-100</td><td>15-20%</td></tr><tr><td>Airless spray</td><td>4-5</td><td>0.01"-0.021"</td><td>4-100</td><td>5-10%</td></tr></table>	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume	Brush/roller			4-100	Up to 5%	Regular spray	3-4	1.6	4-100	15-20%	Airless spray	4-5	0.01"-0.021"	4-100	5-10%
Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume																	
Brush/roller			4-100	Up to 5%																	
Regular spray	3-4	1.6	4-100	15-20%																	
Airless spray	4-5	0.01"-0.021"	4-100	5-10%																	
Cleaning Thinner	Epoxy thinner 4-100.																				
Application remarks	1. Stir thoroughly before application and while painting.																				
Caution	Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet. Do not inhale fumes when spraying this product.																				
Warning	Never mix this material with others when not specifically recommended by us.																				
General comments	See safety data sheet on page 9.																				

STRONTIUM CHROMATE EPOXY PRIMER

Per MIL-P-23377 Type I

Product code No.

571-020 & 571-036

Product Description

Two-component (Part A + Part B), anti-corrosive epoxy polyamide primer. Contains strontium chromate pigment. Conforms to standard MIL-P-23377. paint systems.

Special features

Excellent adhesion to light metals, such as aluminum. Tough and elastic. Resistant to humidity.

Suggested uses

Mainly used to paint aviation accessories, aluminum and light metals. Also suitable for ferrous metals.

Technical data

Color

Transparent yellow & Green.

Gloss at 60°C

Matt.

Solid content by volume

Recommended

27%

dry film thickness

20 microns.

Calculated spreading

rate* (sq.m/liter)

13.5

Recommended thinner

4-100

Touch dry**

30 minutes.

Hard coat**

16 hours.

Dry to recoat**

1 hour min., 24 hours max.

Two Pack Product

Mixing ratio by weight

A :B = 1.6:1

Mixing ratio by volume

A :B = 1:1

Induction period before painting**

15 minutes

Pot life After mixing**

8 hours.

Shelf life**

24 months.

Surface preparation and specification

Aluminum: Remove oils and oxides by filing or approved chemical treatment.. Ferrous metals: Sandblast to Sa-2.5. Apply as a primer for two-component topcoat paints, such as TAMAGLASS and POLYURETHANE PAINT FOR JET AIRCRAFT.

Paint application

Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume
Brush/roller	4-5		4-100	10-15%
Regular spray	4-5	0 .011-0.015/60"	4-100	0-5%

Cleaning Thinner

4-100.

Application remarks

1. Stir thoroughly before application and while painting.
2. Do not apply when temperatures are below 10°C.

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Do not inhale fumes when spraying this product.

Warning

Never mix this material with others when not specifically recommended by us.

STRONTIUM CHROMATE EPOXY PRIMER (continued from p.124)

General comments

Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

* Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.

** At 25°C and 85% relative humidity.

NON - SKIDDING TANK COATING

Product code No.	571-020 & 571-036
Product Description	Two-component (Part A + Part B), anti-corrosive epoxy polyamide primer. Contains strontium chromate pigment. Conforms to standard MIL-P-23377. paint systems.
Special features	Excellent adhesion to light metals, such as aluminum. Tough and elastic. Resistant to humidity.
Suggested uses	Mainly used to paint aviation accessories, aluminum and light metals. Also suitable for ferrous metals.

Technical data

Color	Transparent yellow & Green.
Gloss at 60°C	Matt.
Solid content by volume	
Recommended dry film thickness	27%
Calculated spreading rate* (sq.m/liter)	20 microns.
Recommended thinner	13.5
Touch dry**	4-100
Hard coat**	30 minutes.
Dry to recoat**	16 hours.
	1 hour min., 24 hours max.

Two Pack Product

Mixing ratio by weight	A :B = 1.6:1
Mixing ratio by volume	A :B = 1:1
Induction period before painting**	15 minutes
Pot life After mixing**	8 hours.
Shelf life**	24 months.

Surface preparation and specification

Aluminum: Remove oils and oxides by filing or approved chemical treatment.. Ferrous metals: Sandblast to Sa-2.5. Apply as a primer for two-component topcoat paints, such as TAMAGLASS and POLYURETHANE PAINT FOR JET AIRCRAFT.

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume
	Brush/roller	4-5		4-100	10-15%
	Regular spray	4-5	0 .011-0.015/60"	4-100	0-5%

Cleaning Thinner

Application remarks

1. Stir thoroughly before application and while painting.
2. Do not apply when temperatures are below 10°C.

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Warning

Do not inhale fumes when spraying this product.

Never mix this material with others when not specifically recommended by us.

TAMAGLAS SUPER TOP COAT, MATT DUST YELLOW

Product code No.	393-050 A+B, Part A 393-051, Part B 393-052
Product Description	Used as a top coat for heavy duty equipment and vehicles that require high durability.
Special features	High resistance to wear and impact. Highly durable in all weather conditions. Retains its original shade and gloss over time.
Suggested uses	Conforms to I.D.F. specification for wear resistant polyurethane paint and to I.D.F. specification for a top coat in an anti-skid paint system

Technical data

Color	Dust yellow.
Gloss at 60°C	Matt.
Solid content by volume	A:B - 1:10 in weight 1:10 in volume
spreading	10 m ² /l (in one coat)
Thinner	Thinner 10 (summer) or Thinner 11 (winter) Tools Cleaning: Thinner 11
Calculated spreading rate* (sq.m/liter)	13.5
Recommended thinner	4-100
Touch dry**	30 minutes.
Hard coat**	18 hours.
Dry to recoat**	Minimum: 12 hours; Maximum: unlimited, the surface must be clean.

Two Pack Product

Mixing ratio by weight	A :B = 1.6:1
Mixing ratio by volume	A :B = 1:1
Induction period before painting**	15 minutes
Pot life After mixing**	8 hours.
Shelf life**	24 months.

Surface preparation and specification

Aluminum: Remove oils and oxides by filing or approved chemical treatment.. Ferrous metals: Sandblast to Sa-2.5. Apply as a primer for two-component topcoat paints, such as TAMAGLASS and POLYURETHANE PAINT FOR JET AIRCRAFT.

Paint application	Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume
	Brush/roller	4-5		4-100	10-15%
	Regular spray	4-5	0.011-0.015/60"	4-100	0-5%

Cleaning Thinner

Application remarks

1. Stir thoroughly before application and while painting.
2. Do not apply when temperatures are below 10°C.

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet.

Warning

Do not inhale fumes when spraying this product.
Never mix this material with others when not specifically recommended by us.

Road marking

Road marking

Road marking paints are used to mark asphalt roads, curb stones, traffic isles and parking lots. Tambour road marking paints conform with the Israeli standard and comply with the requirements of the European standard BS-EN 1871 (2000) "Road Marking Materials – Physical Properties".

Curb stones marking paints

Glossy, high build, thinners free coating, up to 3 mm thick, excellent resistance to abrasion and chemicals, intended for floors in the chemical industry and in highly abrasive environments.

Lead free paints

Yellow, lead and toxic metals free paint for marking roads, conforms to the new Israeli standards and to specifications of the public works department.

Curb stones marking paints

Glossy, high build, thinners free coating, up to 3 mm thick, excellent resistance to abrasion and chemicals, intended for floors in the chemical industry and in highly abrasive environments.

Acrylic road marking paint)

Acrylic paint, thinned with a solvent. Provides a unique bright white color and high resistance to abrasion.

Black asphalt paint for concealment

Yellow, lead and toxic metals free paint for marking roads, conforms to the new Israeli standards and to specifications of the public works department.

Road marking paint – water diluted

Acrylic, water diluted road marking paint. Environmental and user friendly. Free of chromates and lead.

Alkydic road marking paint

Fast drying, good visibility.

CR road marking paint

Fast drying, excellent resistance to abrasion. Especially suited for inclement weather conditions.



white/YELLOW ROAD MARKING ACRYLIC PAINT (Lead-free)

Product code No.	yellow 448-102, white 448-001																												
Product Description	Fast drying, highly visible, asphalt roads marking paint, based on acrylic resins. Conforms to requirements of Israeli Standard IS 935/1 – “Road Marking: Paints for Marking under Standard Label (June, 1999 edition). Free of lead, chromates and/or any other toxic pigments.																												
Special features	Designed for painting electronic packaging and plastic.																												
Suggested uses	Designed for marking asphalt and concrete roads: long line and crossings, as well as plots in parking lots, floors of warehouses, halls, etc.																												
Technical data																													
Color at 60°C	Yellow per color 356- B.S. 381.																												
Gloss	Matt																												
Solid content by volume	52±2%																												
Solid content by weight	68±2%																												
Viscosity	80-85 KU																												
Milled grain size	60 microns min.																												
Calculated spreading rate* (sq. m/liter)	0.4-0.6 (see specification).																												
Thinner for dilution	Thinner for road marking paint (or 1-22 thinner).																												
Touch dry**	15 minutes																												
Hard coat**	20 minutes																												
Hard coat for traffic	30 minutes																												
Shelf life**	12 months																												
Surface preparation and specification																													
Clean road surface from dust, grease and any other foreign matter. Do not paint on a wet or damp surface, when rain is expected or in extreme weather conditions. (detailed and exact instructions for preparation of the road for painting are specified in Israeli Standard IS 934/1). The required amount according to standard 934/1 is 0.4 liter per square meter. Over rough aggregate (larger than 2 mm), or when small holes must be filled, use higher amounts of paint, up to 0.6 liter per one square meter. Use such higher amounts of paint for application on seams or patches.																													
Paint application	<table><tr><td colspan="2"></td><td colspan="2">Application method</td><td>Pressure (atm.)</td><td>Nozzle Orifice</td><td>Thinner</td><td>Thinning Volume (%)</td></tr><tr><td rowspan="2">Brush/roller</td><td rowspan="2">4-5</td><td rowspan="2"></td><td rowspan="2">0.018 -0.021"</td><td rowspan="2">1-22</td><td rowspan="2">0-5%</td><td rowspan="2"></td><td rowspan="2"></td></tr><tr></tr><tr><td>Airless Spray</td><td></td><td></td><td></td><td></td><td></td><td></td><td></td></tr></table>							Application method		Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)	Brush/roller	4-5		0.018 -0.021"	1-22	0-5%			Airless Spray							
		Application method		Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)																						
Brush/roller	4-5		0.018 -0.021"	1-22	0-5%																								
Airless Spray																													
Cleaning Thinner	Road marking paint thinner (or thinner 1-22).																												
Application Remarks	Stir well before application and while painting. Warning: Excessive brushing may melt the road asphalt and cause color changes in the paint (bleeding). Paint visibility at night can be enhanced by scattering glass beads designed for this purpose on the paint coat, immediately after paint application, while the paint is still wet, in quantities of 350 grams per square meter (as specified in Israeli Standard IS 934/1).																												
Caution, Warning & General comments																													
See safety data sheet on page 9.																													

ROAD MARKING PAINT (CR)

Product code No.	White: 448-951 Yellow: 448-004
Product Description	Chlorinated Rubber Alkyd Paint for marking asphalt roads. Fast drying, Excellent for dry & rainy regions. Highly visible even in poor visibility. Complies with the requirements of the European Standard BS EN 1871 (2000) "Road marking materials – Physical properties" and with the requirements of the Standard Institution of Israel (SI 935).
Special features	Excellent resistance to abrasion. Especially suited for inclement weather conditions (strong sunlight, heavy rain, day/night temperature drops).
Suggested uses	Designed for marking asphalt and concrete roads: long line and crossings, as well as plots in parking lots, floors of warehouses, halls, etc.
Technical data	
Color	White, yellow per color 356- B.S. 381. Available in other colors per request.
Gloss at 60°C	Matt
Solid content by volume	50%.
Calculated spreading rate* (sq. m/liter)	Strip of 20 meter by 10 cm wide per liter. (360 meter long per pail)
Thinner for dilution	Thinner for road marking paint (or 1-22 thinner).
Touch dry**	15 minutes
Open time for traffic**	30-45 minutes.
Shelf life**	12 months
Surface preparation and specification	Clean road surface from dust, grease and any other foreign matter. Do not paint on a wet or damp surface, when rain is expected or in extreme weather conditions. (detailed and exact instructions for preparation of the road for painting are specified in Israeli Standard IS 934/1). The required amount according to standard 934 is 0.4 liter per square meter. Over rough aggregate (larger than 2 mm), or when small holes must be filled, use higher amounts of paint, up to 0.7 liter per one square meter. Use such higher amounts of paint for application on seams or patches
Paint application	Application method Pressure (atm.) Nozzle Orifice Thinner Thinning Volume (%) Brush/roller 1-22 0-5% Airless Spray 45 0.018 -0.021" 1-22 0-5
Cleaning Thinner	Road marking paint thinner (or thinner 1-22).
Application Remarks	Stir well before application and while painting. Warning: Excessive brushing may melt the road asphalt and cause color changes in the paint (bleeding). Paint visibility at night can be enhanced by scattering glass beads designed for this purpose on the paint coat, immediately after paint application, while the paint is still wet, in quantities of 300-350 grams per square meter (as specified in Israeli Standard IS 934/1).
Caution	Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label. Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet. Do not inhale fumes when spraying this product.
Warning & General comments	See safety data sheet on page 9.

ASPHALT ROAD MARKING PAINT (ALKYD)

Product code No.
Product Description

Red 448-096, Blue 448-047, Black 448-202, Green 448-408
Paint for marking asphalt roads. Based on alkyd resins Fast drying, highly visible even in poor visibility. Conforms to requirements of Israeli Standard IS 935/1 – Road Marking: Marking Paints (June 1999, edition).

Suggested uses

Designed for marking asphalt and concrete roads: long lines and crossings. Also suitable for marking parking lots, floors of warehouses, halls, etc. Must be used according to the requirements of Israeli Standard IS 934/1 – “Road Marking: Preparing Asphalt Roads for Paint Marking and Application (April 2001 edition).

Technical data

Color

White, Yellow per color B.S. 381 - 356.

Gloss

Matt

Solid content by volume

54% ± 2%

Viscosity

80-85 KU

Milled grain size

60 microns min.

Calculated spreading

rate* (sq. m/liter)

0.4 – 0.7 liter (see details below).

Thinner for dilution

Thinner for road marking paint (or thinner 1-22).

Touch dry**

15 minutes

Open time for traffic

20 minutes

Shelf life**

12 months

Surface preparation and specification

Clean road surface from dust, grease and any other foreign matter. Do not paint on a wet or damp surface, when rain is expected or in extreme weather conditions. (detailed and exact instructions for preparation of the road for painting are specified in Israeli Standard IS 934/1).

The required amount according to standard 934 is 0.4 liter per square meter. Over rough aggregate (larger than 2 mm), or when small holes must be filled, use higher amounts of paint, up to 0.7 liter per one square meter. Use such higher amounts of paint for application on seams or patches

Paint application

Application method	Pressure (atm.)	Nozzle	Orifice	Thinner	Thinning Volume (%)
Brush/roller				1-22	0-5%
Airless Spray	4-5	0.018 - 0.021"	1-22	0-5%	

Cleaning Thinner

Thinner for road marking paint (or thinner 1-22).

Application Remarks

Stir well before application and while painting.

Warning: Excessive brushing may melt the road asphalt and cause color changes in the paint (bleeding).

Paint visibility at night can be enhanced by scattering glass beads designed for this purpose on the paint coat, immediately after paint application, while the paint is still wet, in quantities of 350 grams per square meter (as specified in Israeli Standard IS 934/1).

Caution

Any work that includes application and use of this product shall be performed according to the applicable Safety, Health and Environmental regulations. Read the safety precautions and the warnings specified in the Safety Data Sheet, available at Tambour Safety Department and indicated on the product's label.

Keep away from fire and sparks. Inedible. Provide adequate ventilation of the work space. Use appropriate protective means, as indicated in the Safety Data Sheet. Do not inhale fumes when spraying this product. Never mix this material with others when not specifically recommended by us.

Warning

General comments

Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict

ASPHALT ROAD MARKING PAINT (continued from p.98)**General comments**

conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

* Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.

** At 25°C and 85% relative humidity.

Serifon

Serafon

Specialized in developing, producing and marketing polymers and adhesives for the industry and for construction.

A wide range of ready to use adhesives, for the paper, packaging and carpentry industries are produced at the plant, including self adhering adhesives and glues for wood, carpets and decorations. In addition, the plant produces emulsions for the paint industry.

The R&D department constantly develops customized solutions for customers, as part of the comprehensive service provided by the plant of its customers.

The adhesives are combined of three main bases

Glossy, high build, thinners free coating, up to 3 mm thick, excellent resistance to abrasion and chemicals, intended for floors in the chemical industry and in highly abrasive environments.

Solvents based adhesives (contact adhesives)

Used to adhere formica to wood, carpets and P.V.C to wood or concrete, though application or spraying.

Acrylic based adhesives

Used to adhere P.V.C and linoleum to wood concrete.



FAST ADHESIVE 305

Product code No. 983-005

Product Description features

Fast, multi-purpose plastic adhesive, based on P.V.A. Short open time. **Special** Open time of 15-20 minutes (0.3mm thick coat, at 23°C and 50% relative humidity, on fir wood).

Adhesion speed of FAST ADHESIVE 305 is accelerated when the compression is performed at 20°C and at higher temperatures ranging from 60-80°C.

Suggested uses

Designed especially for general adhesion and for layering hard wood.

Application

- Stir before using the glue.
- Apply with a brush, a spatula, a manual roller or a spray can.
- Apply force during compression.
- Use a quantity of 130-200 grams per one square meter

Technical data

Solid content by volume 43-48%

Viscosity 8,000-10,000 cPs

pH 4.0-6.0

Tearing strength At least 70 kg-force/sq.c m

Shelf life

FAST ADHESIVE 305 is slightly corrosive on steel and soft metal. Therefore, store in glass, polyethylene, stainless-steel containers or metal containers with coated interiors. Protect the product from frost and freezing. Store at a temperature of 5-30°C. Keep away from direct sun light.

Shelf life**

12 months

Caution

Inedible. This glue is not defined as a hazardous material and does not contain any materials, which require special marking or warning.

Warning

Never mix this material with others when not specifically recommended by us.

General comments

Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

SLOW ADHESIVE 305

Product code No.	983-006
Product Description	Slow, multi-purpose plastic adhesive, based on P.V.A. Long open time. Special
features	The long open time enables easy and convenient application.
Suggested uses	Designed especially for general adhesion and as a glue for leather, Formica, paper, cloth, etc.
Application	- Stir before using the glue. - Apply with a brush, a spatula, a manual roller or a spray can. - Maximum adhesion force is obtained after 24 hours.
Technical data	
Solid content by volume	43-48%
Viscosity	10,000-12,000 cPs
pH	4.0-6.0.
Tearing strength	At least 70 kg-force/sq.cm
Shelf life	SLOW ADHESIVE 305 is slightly corrosive on steel and soft metal. Therefore, store in glass, polyethylene, stainless-steel containers or metal containers with coated interiors. Protect the product from frost and freezing. Store at a temperature of 5-30°C. Keep away from direct sun light.
Shelf life**	12 months
Caution	Inedible. This glue is not defined as a hazardous material and does not contain any materials which require special marking or warning. Do not inhale fumes when spraying this product.
Warning	Never mix this material with others when not specifically recommended by us.
General comments	Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.
*	Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.
**	At 25°C and 85% relative humidity.

ADHESIVE 326

Office Plastic Adhesive

Product code No. 983-007

Product Description Plastic adhesive for office and Kindergarten usages.

Special features Adheres easily to paper, leather and cloth. Washes off easily from clothes and therefore ideal for use at Kindergartens.

Suggested uses Water soluble, non-toxic adhesive. Designed especially for usage in

Technical data

Solid content by volume 23-30%

Viscosity 2,500-40,000 cPs

pH 4.0-5.7

Shelf life ADHESIVE 326 is slightly corrosive on steel and soft metal. Therefore, store in glass, polyethylene, stainless-steel containers or metal containers with coated interiors. Protect the product from frost and freezing. **Shelf life**** 12 months

Caution Inedible. This glue is not defined as a hazardous material and does not contain any materials which require special marking or warning.

Warning Never mix this material with others when not specifically recommended by us.

General comments Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

* Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.

** At 25°C and 85% relative humidity.

CARPENTER'S GLUE 307

P.V.A. and Additives Based Plastic Glue, with Powerful Adhesion Properties

Product code No. 983-008

Product Description Especially designed for extra strong adhesion of hard wood. Provides excellent results in assembly work and in joints assembly.
Special features Open time of 15-20 minutes (0.3mm thick coat, at 23°C and 50% relative humidity, on fir wood).
 Adhesion speed of CARPENTER'S GLUE 307 is accelerated when the compression is performed at 20°C and at higher temperatures ranging from 60-80°C.

Application

- Use a quantity of 130-200 grams per one square meter.
- Stir before using the glue.
- Apply with a brush, a spatula, a manual roller or a spray can.
- Compress to fix the glue.

Technical data

Solid content by volume 50% min.

Viscosity 6,500-8,500 cPs

pH 4.5-5.5

Tearing strength At least 70 kg-force/sq.cm

Shelf life CARPENTER'S GLUE 307 is slightly corrosive on steel and soft metal. Therefore, store in glass, polyethylene, stainless-steel containers or metal containers with coated interiors. Protect the product from frost and freezing. Store at a temperature of 5-30°C

Shelf life** 12 months

Caution Inedible. This glue is not defined as a hazardous material and does not contain any materials which require special marking or warning.

Warning Never mix this material with others when not specifically recommended by us.

General comments Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

* Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.

** At 25°C and 85% relative humidity.

TOP GLUE

Product code No. 983-046

Product Description A professional carpenters glue developed specifically by Serafon for fast and powerful adhesion of all wood types at carpentry shops, where high quality finish is required. TOP GLUE is based on water P.V.A emulsion, with crossing properties, can be used as water resistant wood glue. Conforms to the requirements of B3, per standard DIN 68602. TOP GLUE is suitable for drying at temperatures ranging from 20-80°C, with open time of 15-20 minutes, at 20-30°C.

Suggested uses Plywood coating and adhesion of plastic elements in a hot or cold process. Kitchen and Bathroom furniture assembly adhesive, also used for furniture assembly under HF pressure

Application

- Stir before using the glue.
- Apply TOP GLUE on a clean and dry surface, free of any dust, grease or loose foreign material.
- Ascertain the both attached surfaces are prepared and ready, then a thin coat of TOP GLUE on one of the two surfaces and press to join both surfaces. apply
- Final adhesion strength is obtained after 24 hours.
- Apply with a brush, a roller, a coating roller.

The glue is usually applied in a single coat.

- Coverage depends on the adhered material and ranges from 80-150 gram/square meter.
- During adhesion, the joined parts shall be at a temperature of 10°C at least.

Cleaning after application

Water, before the glue dries completely.

Technical data

Solid content by volume 43-47%

Viscosity 6,500-8,500 cPs

pH 2.5-4.5

Tearing strength At least 70 kg-force/sq.cm

Shelf life Store TOP GLUE at a temperature of 5-35°C. Protect the product from freezing. TOP GLUE is not hazardous.

Caution Inedible. This glue is not defined as a hazardous material and does not contain any materials which require special marking or warning.

Warning Never mix this material with others when not specifically recommended by us.

General comments Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.

* Practical spreading rate can vary, depending on the surface, the application mode, the painter's skill and weather conditions at the site. Assume approximately 75% of the calculated spreading rate.

** At 25°C and 85% relative humidity.

SERASTICK K1

Contact Glue

Product code No.

983-008

Product Description

Multi-purpose, economical contact glue. Provides powerful adhesion. Resistant to high temperatures. Tested by the Rubber Research Institute of the Technion, and found to conform to the strict requirements of the American Standard MMM-A-130B Type I for contact glues.

Suggested uses

Polychloropren solvent based contact glue. High adhesion quality for general use. Designed especially to glue a wide range of materials, such as hard fibers, chips and layered boards, lead, aluminum, cement asbestos and foamed polyurethane.

Application

- Ideal application temperatures range from 15-30°C.
- Absorbing materials require additional adhesion material, since glue penetrates the substrate at a higher rate. In this case, apply a double coat, at least.
- Stir before using the glue.
- Apply with a brush, a roller, a coating roller.
- Apply the glue on both surfaces you intend to join.
- Join surfaces through pressure application.

Technical data

Color

Yellow

Film

Solid content by volume

19-22%

Viscosity

1,400-2,000 cPs

Peeling strength

3 kg/cm at least.

Heat resistance

75°C at least.

Shelf life

Protect the product from frost and freezing. Store SERASTICK K1 at a temperature of 5-35°C.

Thinner

Use thinner K1, made by Serafon to dilute the glue and clean tools and surfaces.

Shelf life

8 months.

Caution and safety instructions

Contains: Formaldehyde, Toluene.
Highly flammable. Do not inhale, touch or swallow. Harmful in contact with the skin, irritates the eyes, the respiration system and the skin. May cause non-reversible damage. May cause increased sensitivity upon contact with the skin. Inedible. Keep in a locked place, out of the reach of children. Store the packaging in a well ventilated place. Do not empty into the drainage system. Wear protective cloths, gloves, goggles and suitable face mask. In the event of swallowing, get immediate medical help, present the product's label or packaging.

Warning

Never mix this material with others when not specifically recommended by us.

General comments

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PLASTON 33

Product code No.	983-049
Product Description	Acrylic adhesive for wall to wall cloth carpets .
Suggested uses	Wall to wall carpets adhesive.
Special features	Water based, easily applied, resistant to softeners.
Technical data	
Solid content by volume	75-80%
Viscosity	250,000 -350,000 cPs
pH	6.0-7.0
Storage	PLASTON 33 is slightly corrosive to steel and soft metal. Therefore, store in glass, polyethylene , stainless-steel containers or metal containers with internal coating. Avoid storing the product at freezing temeptratures. Store at a temperature of 10-30°C.
Shelf life	12 months.
Surface preparation and specification	Ascertain that the surface is smooth, free of any bumps or depressions, prior to adhesion, to ensure correct adhesion process. Clean the surface thoroughly from dust, grease and any foreign matter.
Application instructions	Once the surface is prepared, apply a thin coat of PLASTON 33 over the room surface and wait for about 10 minutes. Ascertain partial drying of the glue. Spread the carpet to the length of the room and wait for a few minutes. If needed, perform slight repairs to achieve perfect adjustment of the carpet. At the end of the adhesion process, press the carpet to the floor using a heavy press to prevent formation of air bubbles. Avoid stepping on the carpet for several hours after the adhesion.
Caution and safety instructions	Highly flammable. Inedible. Keep out of the reach of children Do not inhale, touch or swallow. Store the packaging in a well ventilated place. Do not empty into the drainage system. Do not induce vomiting in the event of swallowing. Get immediate medical help, present the product's label or packaging.
Warning	Never mix this material with others when not specifically recommended by us.
General comments	Data presented here is based on our best knowledge and experience. We reserve the right to update and/or alter it without prior notice. Achievement of the best desired results is subject to proper application in strict conformance to our instructions and safety measures. Before application, the user should verify that the product is indeed designed for the intended usage and that the surfaces to be painted are properly prepared, and are suitable for the product's application.