

Monocoat

▶ Product code No.	462-xxx
▶ Product Description	One-component, multi-purpose high build, single application paint, for use as a primer and top-coat all in one.
▶ Special features	Designed for galvanizing and application on ferrous metal, aluminum, Formica and concrete. Enables application of a single coat up to 90 microns. Satin gloss. Extremely efficient painting process. Excellent quick drying.
▶ Suggested uses	Provides a highly economical and quick application process, where same day application and transportation of metal objects is required. Designed for application on ferrous metal constructions and galvanized objects, in an urban, light industry and marine environments.

Technical data

▶ Color	Industrial/ RAL colors range.
▶ Gloss at 60°C	35±5% (satin).
▶ Solid content by volume	38±2
▶ Recommended dry film thickness	40-90 microns (you can obtain a final thickness of 120 microns by applying "wet on wet" coats in 15 minutes intervals).
▶ Calculated spreading rate* (sq. m/liter)	4.3-10
▶ Recommended thinner	For spraying: 1-32; for brush: 18.
▶ Touch dry**	30 minutes.
▶ Hard coat**	4 hours.
▶ Dry to recoat	For an additional coat of the same product - 15 minutes and up. For a glossy synthetic top-coat - 30 minutes and up.

Storage

▶ Shelf life**	24 months.
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Surface preparation and specification

Roughen metal through blasting 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.

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.

Mechanical filing using emery cloth to about 15 microns roughness rate. First layer (binding) one coat, thinned to 30%, with 1-32 thinner, 15-20 microns thick. Apply the second layer to recommended film thickness after touch drying.

Concrete: remove all loose layers and contaminants using mechanical means, or aggregates spraying (such as blasting).

▶ **Paint system**

A single application paint, used as both a primer and a top-coat. May be coated with a one component, glossy, synthetic top-coat when required.

▶ **Paint application**

Method	Pressure (atm.)	Nozzle Orifice	Thinner	Thinning Volume (%)
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

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 65% relative humidity.