TUFCOTE STEEL-X

TDS05-2690

DESCRIPTION	An acrylic co-polymer based coating formulated for fast drying refurbishment topcoat over steel. Available in gloss or industry standard satin finish.
TYPICAL USES	Shipping containers, waste bins and similar equipment.
ENVIRONMENT	Exterior
PERFORMANCE	Excellent adhesion and spray properties with excellent sag resistance. Rapid drying and early water resistance giving quick return to service. High performance spray application through FFLP airless equipment.
LIMITATIONS	Do not apply if the air and surface temperature during application and drying is likely to fall below 10 .
TECHNICAL DATA	Resin: Acrylic Co-polymer Solvent: Water Colour: All Colours Primer: See over. Durability: Excellent Thining and Clean Up: Water Pack Size: 20L Cure Hard @20°C: 7 days VOC: 60g/litre Vol Solids: 35 percent Touch Dry: 15 mins @25 Recoat Time: 60 mins @25 Theoretical Coverage: 10 m²/litre/coat Wet Film Thickness: 100 microns Dry Film Thickness: 35 microns
SPREAD RATE	First Coat: 10 - m²/litre/coat Practical spreading rates will vary depending on such factors as application method, ambient conditions and surface porosity and roughness.
PRODUCT CODES	05-2690, 05-690

PRIMERS AND UNDERCOATS

Substrate	Primer / Undercoat	Technical Data Sheet
Ferrous Metals	TRUEPREP EPS-10 ETCH PRIMER	See TDS55-649UP
Ferrous Metals	TRUEPREP ANTICORROSIVE PRIMER	See TDS55-720UP
Ferrous Metals	TRUEPREP DTM PRIMER	See TDS05-600

SURFACE PREPARATION

Ferrous Metals-New Unpainted

Thoroughly degrease and clean the surface as per AS 1627.1 standard. Apply TRUEPREP SURFACE CLEAN by pump spray or brush. Refer to TDS for application and dilution rates. Use water blasting to remove all cleaning products and contaminants.

Ensure all weld sections are thoroughly clean from weld splatter, flux and weld splatter. Weld splatter must be removed carefully by means or mechanical grinding or blasting. Ensure there are no areas of rough welding. All internal and external corners need to be grinded to provide a minimum radius of 2mm.

Abrasive blast clean to AS 1627.4 Class 2.5 or equivalent standard to achieve a blast profile of 25-45 microns. Apply our specified primer within 4 hours after blast cleaning to prevent flash rusting and other contamination.

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Ferrous Metals-Previously Painted Good
Allow to scrape and remove all loosely adhered paint flakes and wire brush all rusted areas.

Clean down using TRUEPREP SURFACE CLEAN by pump spray or brush. Additional scrubbing will assist in the breakdown and removal of any difficult contamination. Refer to TDS for application and dilution rates. Water blasting to remove all flaking paint, dirt, grease and contaminates. Allow to fully dry and test the surface has been degreased by wiping with clean cotton wool to ensure there is no residue. Repeat the process if necessary.

All external corners need to be grinded to provide a minimum radius of 2mm profile.

Allow for power tool clean to AS 1627.2 or equivalent such as SSPC-SP3 standard. Power tool clean to remove all loose paint, rust, and any other loose particles. Ensure that you feather all edges of existing paint to help achieve a relatively smooth finish for your primers and topcoats. Ensure when operating your power tool, avoid doing cuts, burrs and sharp ridges.

If there is evidence of rust, apply our TRUEPREP RUST KILL as per our TDS for application and all PPE gear requirements.

Ensure there is no deterioration in the condition of the surfaces to be painted, between the preparation stage and the actual application of the primer.

Apply our Specified Primer immediately to prevent any contamination or further corrosion.

Ferrous Metals-Previously Painted Poor
Allow for white Metal Blast Clean to AS 1627.4 or equivalent such as SSPC-SP5 standard.

Removal of all mill scale, rust, rust scale, paint or foreign matter by the use of abrasive propelled through nozzles of by centrifugal wheels. A white metal blast cleaned surface finish is defined as a surface with grey-white, uniform metallic colour, slightly roughened for form a suitable anchor pattern for coatings. The surface, when viewed without magnification, shall be free of all oil, grease, dirt, visible mill scale, rust, corrosion products, oxides, paint, or any other foreign matter.

Alternatively, SP12 Ultra-High - Pressure Water Jetting. Used for recoating or relining projects where an adequate profile exists.

If there is evidence of rust, apply our TRUEPREP RUST KILL as per our TDS for application and all PPE gear requirements.

Ensure there is no deterioration in the condition of the surfaces to be painted, between the preparation stage and the actual application of the primer.

Apply our Specified Primer immediately to prevent any contamination or further corrosion.

MIXING INSTRUCTIONS

Stir thoroughly with drill mixer before use.

APPLICATION

Tuff Cote Steel X can be applied directly to sound existing coatings provided the surface is clean and has been degreased and pressure washed.

SPRAY
Airless spray. Recommended tip is FFLP 310 to 413. Pump pressure of 1200 – 1500 psi.

BRUSH/ROLLER
Good quality brush, or premium quality Dacron 10-13mm sleeve

CLEAN UP
Water

APPLICATION NOTES

Application of decals overnight. Air movement (Fan assisted) assists in managing the drying process in colder humid conditions.

THINNING

Cotec Spraying thinners

ENVIRONMENTAL

This formulation uses the latest technology with low toxicity, ensuring environmental issues are not compromised. DO NOT POUR paint or wash down storm water or water courses. ALWAYS dispose of in accordance with local Government regulations. Soak up spills with absorbent material and dispose of properly. If spraying use suitable respiratory protection. Refer to the MATERIAL SAFETY DATA SHEET

COATING TECHNOLOGIES LIMITED
10 Andromeda Crescent, East Tamaki, Auckland 2013 Ph +64 9 837 0897 www.cotec.co.nz

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