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TUFCOTE WB ENAMEL

TDS05-700

DESCRIPTION	TUFCOTE WB ENAMEL offers a low VOC water-based alternative to traditional solvent based very high VOC Industrial Enamels. TUFCOTE WB ENAMEL has excellent adhesion to a variety of substrates and can be applied wet on wet to suitably prepared surfaces. It provides rapid drying that enables it to be handled within 2 hours @ 20 . Full hardness is reached in 4 days making it faster cured than traditional Alkyd and it will dry to a harder surface finish. Decals can be applied within 2 hours of drying. TUFCOTE WB ENAMEL can be supplied in all colours. Gloss and Colour retention are outstanding.
TYPICAL USES	May be used for refurbishment of suitably prepared Steel:Bridges, Exterior steel structures, Commercial roller doors, Shipping Containers, Dump Bins, Pallet Racking or Drums.
ENVIRONMENT	Exterior
PERFORMANCE	• Excellent durability and gloss retention • Excellent adhesion to properly prepared surfaces • Excellent flexibility • Excellent dirt pick up resistance • Good chemical resistance • Tough durable surface finish
LIMITATIONS	• Should not be applied if temperatures are below 10°C • Drying and appearance can be affected by application at low temperatures and high humidity. • Not suitable for surfaces where water may pond
TECHNICAL DATA	Resin: Acrylic Dispersion Solvent: Water Colour: All Colours Primer: See over. Durability: Excellent Pack Size: 10 L Cure Hard @20°C: 7 days VOC: <65g/l Vol Solids: 40 percent Touch Dry: 30 minutes @20°C Recoat Time: 2-4 Hours @20°C Max Recoat Time: 5 days @20°C RH 50% Number of Coats: 2 to 3 Theoretical Coverage: 10 m²/litre/coat Wet Film Thickness: 100 microns Dry Film Thickness: 40 microns
AVAILABLE FINISHES @60°C	**Sheen** Gloss 75+% Satin 25%
SPREAD RATE	First Coat: 10 - m²/litre/coat Second Coat: 12 - m²/litre/coat Practical spreading rates will vary depending on such factors as application method, ambient conditions and surface porosity and roughness.
PRODUCT CODES	05-700, 05-7005,05-900,05-9005

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PRIMERS AND UNDERCOATS

Substrate	Primer / Undercoat	Technical Data Sheet
Timber Joinery	TRUEPREP MULTIPURPOSE ALKYD PRIMER UNDERCOAT	See TDS55-550URO
Fibre Board Fibreglass Timber Joinery	TRUEPREP MULTIPRIME	See TDS05-100
Ferrous Metals Galvanised Steel and Zincalume	TRUEPREP ANTICORROSIVE PRIMER	See TDS55-720UP
Ferrous Metals Galvanised Steel and Zincalume Non-Ferrous Metals	TRUEPREP DTM PRIMER	See TDS05-600

SURFACE PREPARATION

Timber Joinery-New Pre-primed
Interior Uses: Liquid sugar soap or similar cleaner is a good method for cleaning all contaminates of the existing substrate. The surface will need to be thoroughly cleaned down to remove any residue left.

Exterior Uses: All surfaces must be clean, and free from dirt, grease, and any other surface contaminant. Clean with TRUEPREP SURFACE CLEAN - A powerful water based, biodegradable, degreaser. Formulated to remove grease and other contaminants from painted and other surfaces. Refer to the TDS for all general information and application.

Inspect the substrate prior to applying any coating system to ensure there is no contamination present and no surface defects exists. If there is either contaminants or defects are present, rectification process is required prior to any coating is applied.

Sand the surface to remove contaminants and provide a mechanical key for our topcoats. Wipe surface with a damp rag to remove all dust.

Timber Joinery-New Unpainted
Interior Uses: Liquid sugar soap or similar cleaner is a good method for cleaning all contaminates of the existing substrate. The surface will need to be thoroughly cleaned down to remove any residue left.

Exterior Uses: All surfaces must be clean, and free from dirt, grease, and any other surface contaminant. Clean with TRUEPREP SURFACE CLEAN - A powerful water based, biodegradable, degreaser. Formulated to remove grease and other contaminants from painted and other surfaces. Refer to the TDS for all general information and application.

Inspect the substrate prior to applying any coating system to ensure there is no contamination present and no surface defects exists. If there is either contaminants or defects are present, rectification process is required prior to any coating is applied.

Sand the surface to remove contaminants and provide a mechanical key for our topcoats. Wipe surface with a damp rag to remove all dust.

Galvanised Steel and Zincalume-Aged Unpainted Poor
If any areas of moss or mould infestation exist, treat them with TRUEPREP GREEN KILL, following instructions on TDS. Apply by flood coating to the surface and allow a minimum of 48 hours and up to four weeks for sterilization before scrubbing or water-blasting for removal of the detritus. For heavy infestations, longer dwell time or additional applications may be required.

Clean down using TRUEPREP SURFACE CLEAN applying by pump spray or broom. Additional scrubbing will assist in the breakdown and removal of any difficult contamination. Refer to TDS for application and dilution rates. Water blast or thoroughly rinse with high volume water to remove all dirt, grease and surface contamination.

Inspect the substrate prior to applying any coating system to ensure there are no surface defects exists. Repair as required.

All areas of rust or corrosion must be abraded using wire brushes, sandpaper, or Ultra-high pressure water blast to remove so little or no corrosion is left on the surface. Treat the entire surface TRUEPREP RUST KILL to remove residual rust, white rust and remaining surface contaminants and clean the metal prior to painting. Rinse clean as per manufacturers recommendations. If the substrate is not passivated in this way, it is likely that corrosion will occur under the new paint film.

Check to ensure all rusted areas have been passivated to a clean rust-free surface. If not repeat the treatment to affected areas.

When dry immediately apply Specified Primer to prevent any contamination or further corrosion.

COATING TECHNOLOGIES LIMITED
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Galvanised Steel and Zincalume-Aged Unpainted Good
If any areas of moss or mould infestation exist, treat them with TRUEPREP GREEN KILL, following instructions on TDS. Apply by flood coating to the surface and allow a minimum of 48 hours and up to four weeks for sterilization before scrubbing or water-blasting for removal of the detritus. For heavy infestations, longer dwell time or additional applications may be required.

Clean down using TRUEPREP SURFACE CLEAN applying by pump spray or broom. Additional scrubbing will assist in the breakdown and removal of any difficult contamination. Refer to TDS for application and dilution rates. Water blast or thoroughly rinse with high volume water to remove all dirt, grease and surface contamination.

Inspect the substrate prior to applying any coating system to ensure there are no surface defects exists. Repair as required.

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When dry immediately apply specified coating system to prevent any contamination or further corrosion.

MIXING INSTRUCTIONS

Mix thoroughly before use.

APPLICATION

Formulated for spray application. Can also be brush and rolled, use of Cotec Retarder may assist in lay off. Add upto 5%.

SPRAY
Pressure 2,500-2,700psi max. Beams, joinery and detailed work use a 308-408 tip. Wider profiles 412-515. 100 mesh filter at gun. If thinning is required use Cotec Spray thinners.

BRUSH/ROLLER
Wooster pro-dooz 10mm nap.

CLEAN UP
Water. Use a small amount of detergent to aid clean up.

APPLICATION NOTES

Apply only on a dry and clean surface with a temperature 3°C above the dew point to avoid condensation. In confined spaces provide
adequate ventilation during application and drying. Air movement will significantly improve dry times

THINNING

Cotec Spray 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

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