

## PROTEGALAC TF95 & TF95(L)

### DESCRIPTION

Fast drying single pack urethane alkyd finish.

### PRODUCT FEATURES AND RECOMMENDED USES

- ◆ Designed as a high quality finish for the commercial vehicle market.
- ◆ Equally suited as a high performance finish for industrial or agricultural machinery, plant and equipment.
- ◆ Below 420 gm/l VOC – complies with PG6/34b (06).
- ◆ Excellent flow, gloss and sag resistance with very high Distinction of Image.
- ◆ Excellent chemical resistance coupled with superb weather resistance and gloss retention.
- ◆ High build for durability and protection.
- ◆ Easy application using a wide range of conventional primers from the Temaspeed range.
- ◆ Resistant to splashes of diesel, petrol and hydraulic fluid (see Product Notes).

### TECHNICAL DATA

#### Volume solids

50 ± 5% (ISO 3233) depending on colour.

#### Weight solids

62 ± 5% depending on colour.

#### Viscosity

60 – 70" BSB4 @ 25°C depending on colour.

#### Specific gravity

0.99 – 1.10 depending on colour.

#### Product code

2237 series (TF95) and 2248 series (TF95(L)).

#### Recommended film thicknesses and theoretical coverage

Recommended film thicknesses		Theoretical coverage
dry	wet	
25 µm	50 µm	20.0 m <sup>2</sup> /l
35 µm	70 µm	14.3 m <sup>2</sup> /l

Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated.

#### Drying time

DFT 25 µm		+ 15 °C	+ 23 °C
Dust free		1 – 2 h	40 mins
Hard dry		overnight	2 - 3 h
Overcoating	Min	overnight	overnight
	Max	Indefinite	

Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation.

#### Finish

Full gloss

#### Colours

Full BS4800 and RAL shades, BS381C, NCS & TVT colours.

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## APPLICATION DETAILS

### Surface preparation

#### Steel Substrates

Preliminary cleaning: remove oil and grease with a suitable detergent. Remove salt and other contaminants by fresh water cleaning and allow to dry (ISO 12944-4). Blast clean to Swedish Standard SIS 05 5900 Sa 2½ or British Standard 7079 equivalent. Surface profile 25 – 50 microns.

If not blast cleaning, pre-treatment improves adhesion and reduces corrosion under the paint film. The type of pre-treatment depends on the requirements for corrosion protection e.g.

1. Zinc phosphate with Cr-VI passivation.
2. Iron phosphate with demineralised water rinsing (insufficient rinsing can lead to the osmotic formation of bubbles).
3. Alkaline or neutral degreasing.
4. Clean steel.
5. Primed with a suitable primer i.e. ProtegaPrime VRP. (Two coats of primer are recommended over a blast cleaned substrate to ensure adequate peak coverage).

#### Zinc Coated Metals

Remove all oil, grease, flux & debris with suitable detergent. Remove salts by suitable soft abrasion method, rinse with clean water & allow to dry. Prime with ProtegaPrime MPH457 two component etch primer.

#### Works primer, Fibreglass and Repaints

Flat surface thoroughly with a suitable grade abrasive paper to provide a key.

DO NOT apply over other etched or aluminium surfaces.

### Application conditions

Only apply in conditions of good ventilation which should be maintained during drying. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point.

### Mixing

Mix thoroughly before use.

### Application

Suitable for spraying by **conventional air spray** and **HVLP** when thinned (approx. 9:1 by volume) to 22 – 32 seconds BSB4 @ 25°C – note: this may render the thinned product non-compliant with PG6/34b (06). Please check the VOC content of the particular colour used and degree of thinning with Protega Coatings to ensure compliance.

**Airless/Hot airless** - ready for use as supplied. Suitable for Hot spray 60 – 80°C, with or without electrostatic, ready for use. Apply a 'mist' coat followed by a full coat. Some colours may thicken on heating and require some thinning. Hot spray gives a higher build and can lead to slower through-hardening. For multi-colour applications allow to dry at least overnight before masking, a longer time may be necessary for hot spray applications. Consult Protega Coatings if further information is required.

### Thinner

1736 Thinner.

### Cleaning of equipment

Remove remaining paint from equipment, flush thoroughly with 1736 Thinner until solvent appears uncontaminated.

### FLASH POINT

Above 32°C

### STORAGE

Store in dry, cool conditions and protect from frost.

### VOC

Volatile Organic Compound content: 368 ± 20 gm/ltr for TAL tint base, varies considerably with colour.

### HEALTH AND SAFETY

Containers are provided with safety labels, which should be observed. Further information about hazardous influences and protection are detailed in individual health and safety data sheets. A health and safety data sheet is available on request from Protega Coatings Ltd.

### PRODUCT NOTES

**Overcoating:** if primers or undercoats are de-nibbed or flatted prior to over-coating, an extended period should be allowed before application of ProtegaLac TF95 to allow the surface to harden again. Failure to allow this extra time can result in lifting and crazing.

Some colours may contain lead colourant and these are labelled ProtegaLac TF95(L).

**Splash Resistance:** When fully cured, resists splashes of diesel, petrol and hydraulic fluid. Splashes of brake fluid may cause some film softening and loss of gloss. Splashes should be immediately removed to prevent longer term film damage.

For best opacity, particularly with bright tinted colours such as bright yellows, oranges and reds, this product should be applied over a primer or intermediate coat tinted to the recommended undercoat shade – please consult Protega Coatings for details.

This information is given in good faith for the guidance of users but without warranty or liability. Any queries should be referred to our Technical Department. The above information, based on laboratory tests and practical experience, has been proved valid at the date marked on the product data sheet. When necessary verify the validity of the product data sheet. The quality of the product is ensured by our operational system, based on the requirements of the standards ISO 9001. As a manufacturer we cannot be responsible for any damages caused by using the product against our instructions or for inappropriate purposes. For professional use only.