



**STAND THE TEST OF TIME**

5-4500/06-17

**Product Specification Sheet:**

## Tinomachine Paints

**Exterior & Interior**

**Automotive and industrial solvent-based paints**

**Tinomachine Acrylic /PU Paint, series 7500**

**Tinomachine Acrylic Paint, series 4500**

**Tinomachine Paint, series 4000**

### CHARACTERISTICS

Automotive and industrial solvent-based quick drying non-yellowing high quality paints, characterized by excellent leveling & gloss, weathering and UV resistance in variable climatic conditions of urban, coastal and industrial environments.

**Tinomachine Paints** are classified as a one finish coat system with good adhesion and intercoat adhesion to metals, concrete and wood surfaces, coupled with good resistance to abrasion, alkalis, marring & staining, mineral & vegetable oils and petrol, detergent solutions and alcohol etc... as well as to heat, up to 100°C. They cure by air drying or by force drying at 60°C for 15-20 minutes.

**Tinomachine Acrylic / PU Paint, Series 7500** is formulated of acrylic and polyurethane polymers blended with synthetic alkyd resins to insure better weather, abrasion, mar and chemical resistance in aggressive and polluted industrial environments (ISO 12944-5 corrosivity category C3 & C4). It is intended for high performance applications on automotives and industrial works.

**Tinomachine Acrylic Paint, Series 4500** is an acrylic / synthetic alkyd based paints with high performance and durability intended for automotive & machinery applications and for industrial works in industrial and coastal areas with moderate salinity for medium and low durability periods (ISO 12944-5 atmospheric corrosivity category C3 & C4).

**Tinomachine Paint, Series 4000** is a synthetic alkyd based paints for automotive and machinery applications and for architectural applications in urban and industrial atmosphere as well as in coastal areas with low salinity for medium & low durability periods (ISO 12944-5 atmospheric corrosivity category C2 & C3).

### TECHNICAL DATA

Acrylic polymer, aliphatic polyurethane and alkyd fatty acids blend with weathering resistant & color stable pigments to comply with the technical requirements of ISO 12944-5 alkyd paint systems.

#### COMPOSITION

White color of:

	Acrylic PU Paint, series 7500	Acrylic Paint, series 4500	Synthetic Paint, series 4000
- Total solids by volume	39%	40%	48%
- Total solids, by weight	51%	53%	61%
- Non-volatile resin by weight	37%	35%	43%
- Pigments, by weight	14%	15%	17%
- Density	1.09	1.10	1.15





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## RECOMMENDED USES

Exterior and interior industrial coatings for automotive and machinery applications, buses, trucks, mobile reservoirs, steel structures and fixtures, office furniture, gas and hot water pipes, radiators and generators, gas cylinders, tanks, agricultural and farm equipments, ammunition and other metals as well as for concrete and wood surfaces and for all applications where non-yellowing and rapid drying properties are of major importance.

## SURFACE PREPARATION

Surfaces must be solid clean and dry, free from oils, grease, salt, dirt and other contaminants.

Rust, mill scale and all deteriorated previous coatings should be removed. Best results are obtained by abrasive blasting to international standards (Sa2½). If oxidation occurs between the time of sand blasting and priming, the surface should be reblasted and cleaned to the specified standard.

Mechanical & manual cleaning & thorough wire brushing followed by washing is usually adequate for normal jobs.

Non-disintegrated previous coatings should be slightly roughened with sand paper and tested for compatibility and adhesion.

Hot-dip-galvanized surfaces need pre-treatment and should be free from contaminants, zinc corrosion or oxidation products (white rust) zinc ash or salts. Weathered surfaces could be washed with water containing detergents, followed by thorough cleaning with hot water preferably pressurized water). Unweathered surfaces should be treated by sweep blasting using a non-metallic abrasive to clean and roughen the surface. Alternatively, the use of wash priming with TINOPRIME ACTIVATOR 7 followed by washing with hot water (preferably pressurized water) is usually suitable.

## PRIMING

Steel surfaces need priming with TINOCRYL ANTI-RUST PRIMER Nr. 16020 or TINOCHLORYLIC RUST KILLER PRIMER Nr. 15660/ 15650/ 15652/ 15670 or TINORETHANE ANTI-RUST PRIMER 15312/ 15313 in 1 or 2 coats (40-80µm d.f.t.) depending on exposure of substrate (corrosivity category) and service life required (durability).

Galvanized & aluminium surfaces need priming with TINOPRIME PRIMER 15770 or with TINOCHLORYLIC RUST KILLER PRIMER Nr. 15660/15650/15652/15670 at 40-80µm d.f.t. depending on type of finishing, durability and environment. Spot prime welds & scratches with TIPOPOXY ZINC RICH PRIMER Nr. 15400.

## THINNING

With TINOSOLVE 1020 or 1003 up to 50% depending on spraying requirements. Recommended spraying viscosity 35 seconds at 25°C, cup 4. For electrostatic spraying use TINOSOLVE 1008 or 1010 or 1018 depending on the required conductivity.

## APPLICATION

As per Code of Practice.

Prepare surface and prime as recommended above. Mix contents thoroughly, thin and apply by spray (preferably airless spray or electrostatic spray) in single or double coats. Spraying pressure 60-80 psi (4.5-5.5 kg/cm<sup>2</sup>).

This is a one finish coat spraying system. Do not re-spray after 2 hours of spraying the preceding coat to avoid wrinkling or blistering.

Total film thickness for steel protection depends on the environment and service life required. As per ISO 12944-5 technical requirements, it ranges from 80µm d.f.t. in category C2 to 240µm d.f.t. in corrosivity category C4.

Paint systems for various durability periods in different corrosivity categories are available separately.

## CONDITION OF APPLICATION

Can be applied at surface temperatures from 3°C. Apply only to surfaces with temperatures at least 3°C above the dew point. This product may be applied at relative humidity ranging from 30% to 85%. Good ventilation is necessary. The product should not be exposed to mechanical stress until fully cured.





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## APPLICATION EQUIPMENT

Brush	Recommended for coating small areas	
Roller	Typical phenolic core rollers should be used	
Conventional spray	Pressure pot equipped with dual regulators, 3/8" I.D. Minimum material hose, .070" I.D.50" fluid tip and appropriate air cap.	
Airless Spray	Pressure at nozzle	1400 - 2100 psi
	Nozzle tip	0.013" - 0.015"

## DRYING & RECOATING TIME

At 23°C and 65% R.H. a wet film of 100µm:

- Dries to touch in 5 minutes

- Dries to handle in 6-8 hours

Through drying for stacking in about 24 hours depends on temperature and film thickness applied.

## GLOSS

Gloss, semi-gloss finishes & lusterless finishes.

## COLORS

As per color card. Custom colors are available on request.

## COVERAGE

Depends on film thickness required and condition of surfaces. In normal applications, contents of 1 US gallon cover at 35µm d.f.t.

- Acrylic Paint, series 4500 = 43 sq.m.

- Paint, series 4000 = 52 sq.m.

- Acrylic / PU Paint, Series 7500 = 42 sq.m.

## PACKING

In cylindrical tin containers of the following capacities:

• 1US gallon = 3.78 L. e

• 1US quart = 0.94 L. e

• 5US gallons pail = 18.9 L. e (on request)

## CAUTION

Not recommended for surfaces subjected to constant heat above 80°C nor to vegetable oils or aromatic solvents.

## LABELLING & SAFE HANDLING

Flammable liquid, keep away from flame, high heat or sources of ignition.

Arrange for adequate ventilation upon application especially when spraying or in closed areas.

All liquid solvent bearing industrial paints need handling with care. Keep container tightly closed. Avoid contact with eyes. Do not smoke, while applying those products. It is recommended to wear suitable gloves.

Do not contaminate with surface water and do not pour into drainage system.

## WARRANTY

TINOL products are warranted to be free of material and manufacturing defects, and to give the performance required of good quality coatings of International Standards, when properly applied in accordance with the written directions and the Code of Practice.

If any product proves to contain material or manufacturing defects that substantially affect its performance, it will be either replaced free of charge or purchase price will be reimbursed. Other liabilities or claims for any consequential loss or damage are disclaimed.





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### **DISCLAIMER**

The information in this document is given to the best of Tinol's knowledge, based on laboratory testing and practical experience. Tinol's products are considered as finished goods and as such, products are often used under conditions beyond Tinol's control. Tinol cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Tinol reserves the right to change the given data without further notice.

Users should always consult Tinol for specific guidance on the general suitability of this product for their needs and specific application practices.



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