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Composition Mixture of pigments and fillers in solution of alkyd and alkyd-urethane resins in organic solvents with addition of additives and driers.

Characteristics and use The enamel is determined for top coats in interior and exterior on wood and metal surfaces. The enamel has excellent environmental resistance, quick drying, good spreading and good and easy workability. The coating film resists dry heat up to 80 °C, but with prolonged heat exposure, the shade gradually changes and the coating becomes brittle.

- ◆ very good environmental resistance
- ◆ universal applicability
- ◆ quick drying
- ◆ suitable for the tinting system HOSTEMIX

Application area Exterior and interior with medium corrosive stress (laundry rooms, cellars, industrial areas, workshops), metal and steel constructions and halls, small metal objects, metal furniture, gates, doorframes, fencing, box pallets, metal fittings, trailers and industrial objects.

Shades According to BALT, RAL, NCS and ČSN colour chart and the others according to individual customer requirements.

Physical properties	Flow time	90 - 120 s (cup Ford Ø 4 mm)
	Weight solids	48 - 53 % according to shade
	Volume solids	≥ 43 %
	Flash point	> 25 °C
	Density	1000 - 1200 kg/m ³

Emission limits	VOC: 0.47 – 0.52 kg/kg	TOC: 0.42 – 0.45 kg/kg
	This product is for professional use only. Not for DIY.	

Properties of dried coat	Hiding power	degree 1 – 2 degree 3 (shades - brightly yellow and red)
	Gloss / 60°	at least 80
	Pendulum hardness / Persoz	up 8 % after 24 h

Drying time	Surface temperature	23 °C
	Dust free	2 h
	Dry through	48 h
	Dry film thickness DFT	40 µm

Spreading capacity	Wet film thickness WFT	95 µm	190 µm
	Dry film thickness DFT	40 µm	80 µm
	Theoretical spreading capacity	10.5 m ² /l	5.3 m ² /l

Thinning TELSOL BR 5, BALTECH S6005

Surface preparation For corrosive environment C2 and C3 the surface must be before the prime coat application prepared by blast-cleaning to degree Sa 2 ½ according to EN ISO 8501-1 (welds and edges must be prepared according to EN ISO 8501-3). Galvanized and aluminous surfaces must be before the prime coat application treated according to EN ISO 12944-4, čl. 12.1. and 12.2. For corrosive environment C1 the surface must be clean, dry, free of grease and rust, mechanically cleaned to degree St 2 – St 3.

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It is necessary to clean, degrease and remove poorly adhering old coats from previously painted surfaces. To ensure compatibility of new coat with old one it is recommended to contact the producer or carry out test reference coating on surface of 1 m².

Application conditions

Stir the paint properly with a mechanical stirrer before use so that there will be no sediment on the bottom. To thin and filter if it necessary.

The temperature of the paint itself should be 15-25 °C. If the paint temperature is below 15 °C, a higher dilution is required and this can subsequently cause problems with the formation of a homogeneous paint film and a longer drying time.

For coating / spraying outside the suitable weather forecast is necessary. During rain, fog, creation of condensation water, effect of aggressive gases and during wind with strong content of dust the coating work must be suspended and can be restart after absolute drying of surface-treated material. Minimal air temperature for application is 10 °C, temperature of painted surface must be 3 °C above dew point. Temperature and relative humidity must be measured in proximity of painted surface. The surface temperature must not be higher than 40 °C. Relative humidity must not be higher than 75 %. Lower temperature and higher humidity during an application and a drying and high thickness of applied coats markedly slow down drying and hardening of the coat. Imperfectly dried surface can cause problems with adhesion of paint to surface or with adhesion between individual coats. In addition it can negatively affect overall appearance of the paint film.

Do not apply the paint on a hot summer day.

Stackability must be tested for specific conditions (climatic conditions, thickness, number of coats, the shape of the substrate, substrate type, etc.).

Workflow

1. Apply 1 to 2 coats of TELKYD P100, final dry film thickness of primer should be at least 40 - 80 µm. Optimal dry thickness of one coat is 40 µm, drying time of one coat is 24 hours. Drying on metal subjects can be accelerated by temperature increasing up to 80 °C;
2. Sanding of bonded places with sandpaper no. 280 while wet;
3. Apply 1 to 2 coats of TELKYD T330, optimal dry thickness of one coat is 35 – 40 µm, recoating is possible after 24 hours or by the system so-called "wet into wet". If next coat is applied to the already dried paint, but incompletely cured, it can cause "wrinkling" the paint. An interval for an overspray without this risk can not be accurately determined, it is dependent on purpose and area of use (e.g. a thickness of the coat, an application method, a method of dilution, local climatic conditions).

The paint is applied by cross spraying or in parallel strips to achieve a final uniform layer. First it is necessary to treat problematic places (corners, edges, welds, surface defects).

It is very important to apply each coat in a uniform layer, in a thickness specified by the specific paint system. Consumption of paint must be checked to avoid excessive thickness, to avoid splashing, cracking and solvent retention.

For larger compact areas always use the material from the same batch. Using the same batch can guarantee the same shade of the colour. We recommend mixing the content of the individual cans by homogeneous mixing.

For the finished coating system, it is advisable to establish a maintenance plan within the expected durability of the protective system according to EN ISO 12944-8:2018. The choice of the appropriate type (level) of maintenance is then mainly dependent on the state of corrosion attack (ISO 4628-3).

Optimal thickness of system

The optimal thickness and composition of the paint system depends on the aggressivity of atmosphere and on the expected durability of a protective system. The selection of an appropriate system should be in accordance with EN ISO 12944-5: 2018.

Product may be specified in another film thickness than indicated depending on purpose and area of use. Therefore this can alter spreading rate, drying time, overcoating interval and the expected durability of a protective system.

Application

Airless spraying (3 – 5 % thinning)

Conventional spraying (recommended viscosity 25 – 30 s / cup Ford Ø 4 mm; 6 - 12 % thinning)

Brush and roller (recommended viscosity 60 - 80 s / cup Ford Ø 4 mm; 3 - 6 % thinning)

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Application by brush and by roller is recommended only for small areas and for corrections. If a brush or roller is used for application, multiple coats will be required to maintain the specified coating thickness.

Application data

Data for conventional spraying

Spraying gun e.g. EST 115, EcoGun 116, EcoGun 246
Nozzle according to desired capacity 1.2-1.6; Air pressure 2.5 – 3 atm.

Data for airless/airmix spraying, e.g. EcoPump VP 55 310 in combination with air-assist spray gun 2100 (DÜRR). Spray data are only indicative and subject to adjustment to the type of spraying equipment used.

Nozzle	Pressure on nozzle	Spraying angle	Filter of spraying gun
0.009 inch (0.23 mm) AirMix	15 Mpa (150 atm) air assist 1.5 atm	20 – 60°	yellow 100/149 (mesh/μm)
0.011 inch (0.28 mm) Airless	17 Mpa (170 atm)	20 – 60°	

It is not recommended using free adjustable nozzle.

Handling

Read the instructions in the Safety Data Sheet before use and follow all safety instructions and regulations. The product contains organic solvents. Follow basic hygiene rules. Do not eat, drink or smoke while using this product. Avoid contact with eyes, skin or clothing. Wear protective gloves, eye protection, protective clothing. Ensure effective ventilation of the workplace.

Packing

20 l (tinted product)

Storability

The product keeps the product qualities 3 years from production date in original closed container. Shades tinted according to the customer's wishes have a warranty period of only 12 months from the date of tinting. To store in dry storage at the temperature 5 to 25 °C. Flammable liquid II. hazard class.

Disposal of packing and waste

Hand over the used, properly empty packing at the collection point of the packing waste. Dispose the packing with the product rest at the place determined by the town for disposal of hazardous waste or hand over to the person authorized for hazardous waste disposal. Further see the product safety data sheet.

These data are only for information and their accuracy is influenced by the properties of individual materials and unpredictable factors during application. The user is responsible for correct use of the product according to the direction for use and for correct application of painting system, i.e. he must always evaluate all conditions of application, which could influence final quality of the top treatment. Therefore, we always recommend to the user to carry out the test for actual working conditions and type of surface applied. Above mentioned data are data, which influence individual working conditions and therefore they do not establish a legal claim. It is necessary to consult information outside the terms of this catalogue sheet with the producer.

The producer stipulates the right for the change in the catalogue sheets without previous notification.