



**tkrom®**  
pinturas

## PRODUCT

### TKROM SYNTHETIC ENAMEL WITH POLYURETHANE

## CONTAINERS

Metallic: 4 L, 750 ML, 250 ML

## PRODUCT DESCRIPTION

General-purpose synthetic enamel formulated with alkyd and polyurethane resins. High performance, great brushability, hardness and scratch resistance. It provides both indoor and outdoor surfaces smooth, hard and elastic finishes that are highly decorative and resistant. Anti-corrosion action.

## APPLICATION FIELD

### For Outdoor and Indoor use.

Suitable for all types of duly-prepared iron, wood and masonry surfaces. This product, which is very easy to apply and is offered in a great variety of colours, is perfect for DIY works.

**Pre-primed metal.**

**Wood.**

## PROPERTIES

- Odourless once dry.
- Great applicability.
- No cracking.
- No paint bubbling.
- Durability of initial gloss.
- Great penetrating power.
- Extremely resistant to atmospheric agents.

Available in version **TKROMATIC**

## TECHNICAL DATA

APPEARANCE OF THE DRY FILM	VALUE	STANDARD	REPORT
<b>COLOUR</b>	Colour chart and colours w/sample		
<b>20° GLOSS</b>	GLOSSY = 73-7 SATIN = n/a MATT = n/a	UNE-EN ISO 2813	IL-6325-01
<b>60° GLOSS</b>	GLOSSY = 73-7 SATIN = 26-28 MATT = 3-5	UNE-EN ISO 2813	IL-6325-01
<b>85° GLOSS</b>	GLOSSY = 73-7 SATIN = 63-65 MATT = 13-15	UNE-EN ISO 2813	IL-6325-01
<b>OPACITY</b>	95-97% / Class 3	UNE-EN ISO 6504-3 / UNE-EN 13300	IL-6325-05

PHYSICAL PROPERTIES	VALUE	STANDARD	REPORT
DENSITY	GLOSSY = 1.15-1.19 g/ml SATIN = 1.25-1.29 g/ml MATT = 1.28-1.32 g/ml	UNE-EN ISO 2811-1	IL-6325-06
VISCOSITY (ISO)	GLOSSY= 94-96 KU SATIN = 87-89 KU MATT = 87-89 KU	IN-HOUSE TRIAL	
GRIND FINENESS (GRANULOMETRY)	15-25 microns / Fine / S1 Fine	UNE-EN ISO 1524/ UNE-EN 13300 / UNE-EN 1062-1	IL-6325-09
RELATED TO THE FORMULATION	VALUE	STANDARD	REPORT
NON-VOLATILE MATTER CONTENT (MASS)	GLOSSY = 64-66 % SATIN = 65-67 % MATT = 66-68 %	UNE-EN ISO 3251	IL-6325-10
NON-VOLATILE MATTER CONTENT (VOLUME)	GLOSSY = 44-46 % SATIN = 41-43 % MATT = 41-43 %	UNE-EN ISO 23811	
MAXIMUM VOC CONTENT ALLOWED	500 g/L	2004/42/II A classification	
MAXIMUM VOC CONTENT OF THE PRODUCT	500 g/L	2004/42/II A classification	

APPLICATION PROPERTIES	VALUE	STANDARD	REPORT
<b>THEORETICAL PERFORMANCE</b>	GLOSSY = 9-11 m <sup>2</sup> /L - 7-9 m <sup>2</sup> /kg 45 µm dry SATIN = 8-10 m <sup>2</sup> /L - 6-8 m <sup>2</sup> /kg 45µm dry MATT = 8-10 m <sup>2</sup> /L - 6-8 m <sup>2</sup> /kg45µm dry	UNE-EN ISO 23811	
<b>INITIAL DRY-TO-TOUCH TIME</b>	GLOSSY = 25 min SATIN = 10 min MATT = 10 min	UNE-EN ISO 9117-4	
<b>NON-TACKY FINISH DRY TIME</b>	GLOSSY = 1h 50 min SATIN = 1h 25 min MATT = 1h 20 min	UNE-EN ISO 9117-4	
<b>HARDENING TIME</b>	GLOSSY = 3h 25 min SATIN = 2h 50 min MATT = 2h 50 min	UNE-EN ISO 9117-4	
<b>REPAINTING TIME</b>	GLOSSY = 6 h SATIN = 6 h MATT = 6 h	UNE-EN ISO 9117-4	
<b>DILUTION</b>	5-20 %	ACCORDING TO APPLICATION SYSTEM	
<b>THINNER</b>	TKROM Solvent 345 Synthetic and greasy / TKROM Turpentine		

## SURFACE CONDITION

<b>SUBSTRATE TEMP.</b>	Min. +5 °C / Max. +35 °C
<b>AMBIENT TEMP.</b>	5 °C / 35 °C
<b>MOISTURE CONT.</b>	Dry surface with <5 % moisture.
<b>SUBSTRATE</b>	For cement mortars, wait until completely set (at least 28 days). For cement-based products, allow it to dry for at least 4 days before coating.
<b>DEW POINT</b>	Surface temperature should be at least 3 °C above dew temperature to reduce the risk of detachment or efflorescence.

## SURFACE PREPARATION

### OVERVIEW

**Painted surfaces:** *Spoiled paint* must be removed by stripping or mechanical means until leaving the surface in good conditions. Then, follow the preparation instructions according to the surface type. For *paint in good conditions* with a satin or glossy finish, it is recommended to prime the surface to improve adhesion.

**New surfaces:** Follow the preparation instructions according to the surface type.

Once prepared, the surface must be dry and free of any substance that could compromise adhesion (grease, oils, dust, resins, salts, oxide, exudations, efflorescence, etc.)

Then apply TKROM Synthetic Enamel with Polyurethane (TDS-6325) as a finish coat. For outdoor applications it is recommended to apply two finish coats.

### NEW OR AGED WOOD

Remove cracked and not correctly adhered areas.

Use putty to correct imperfections and irregularities.

Sand the wood surface in the direction of the grain.

The moisture content of wood must be less than 15 %.

TKROM Universal Sealing Primer (TDS-6203) can also be applied for sealing the wood, guaranteeing great filling power. Sand gently before applying the finishing enamel.

### IRON OR STEEL

• Since the surface must be free of mill scale, rust and external materials with poor adhesion, remove them with a mechanical wire brush. It is recommended to reach a St. 2 degree of cleanliness, following the indications of the ISO 8501 standard.

• To ensure adhesion, surface must be roughened by mechanical means following the indications of the ISO 8501 standard, until reaching the degree of cleanliness Sa 2 ½ (abrasive blast) or St. 3 (mechanical grinding wheel).

Apply one or two coats of protective primer before applying a TKROM synthetic primer (TDS-6201) finish coat. For outdoor use, using a primer with anticorrosive pigments (such as the TKROM anti-corrosion synthetic primer TDS-6218) is best.

### GALVANISED STEEL AND PVC

Sand the surface with an abrasive pad until it becomes matt to improve adhesion.

Degrease the surface with an ammonia-based detergent.

Apply one coat of TKROM Multipurpose Primer (TDS-6204), especially designed for difficult-to-adhere surfaces.

### POLYCARBONATE, POLYESTER, ALUMINIUM

Sand the surface with an abrasive pad until it becomes matt to improve adhesion.

Degrease the surface with TKROM Universal Solvent 302 (TDS-6961).

For aluminium surfaces, degrease with TKROM Bodywork Nitro Solvent 305 (TDS-6902).

Apply one coat of Multipurpose Primer (TDS-6204), especially indicated for difficult-to-adhere surfaces.

### MASONRY

Type of surface: plastering mortars, plasterboard plates, concrete, fibre cement, and other construction materials. Regardless of the surface to be painted, the appearance must be homogeneous, and all possible differences in texture, gloss, absorption, etc. must be corrected.

Apply TKROM Universal Sealing Primer (TDS-6203) as a primer for this type of surface.

In case of doubts regarding the treatment of the above-mentioned surfaces or the painting of other specific materials not included in this sheet, please, consult the appropriate treatment with technical personnel accredited by EUPINCA, S.A

## APPLICATION SYSTEM

SYSTEM	PRODUCT	THEORETICAL PERFORMANCE	DILUTION	COATS
WOOD	TKROM Universal Sealing Primer TDS-6203	5-7 m <sup>2</sup> /l	5-10 % TKROM Solvent 345 Synthetic and Greasy	1 or 2
IRON / STEEL	TKROM Synthetic Primer TDS- 6201	6-8 m <sup>2</sup> /l	5-15 % TKROM Solvent 345, synthetic and greasy / TKROM Universal Solvent 302	1 or 2
IRON / STEEL	TKROM Anti-Corrosion Synthetic Primer  TDS-6218	6-8 m <sup>2</sup> /l	5-15 % TKROM Solvent 345, synthetic and greasy / TKROM Universal Solvent 302	1 or 2
DIFFICULT-TO- ADHERE SURFACES (PVC, galvanised steel, aluminium, etc.)	TKROM MULTIPURPOSE Primer TDS-6204	6-8 m <sup>2</sup> /l	5-25 % TKROM Solvent 302 Universal	1
MASONRY	TKROM Universal Sealing Primer TDS-6203	5-7 m <sup>2</sup> /l	5-10 % TKROM Solvent 345 Synthetic and Greasy	1 or 2
FINISH	TKROM Enamel with Polyurethane	8-10 m <sup>2</sup> /l	5-25 % TKROM Solvent 345, synthetic and greasy / TKROM Turpentine	1 or 2

## APPLICATION PROCESSES

PRODUCT  
PREPARATION

Shake until completely homogenising the product.  
Reshake periodically.  
Adjust viscosity.  
In case of long processes, readjust viscosity since evaporation will occur.  
In case of using an excessively strong solvent, it is recommended to decrease the proportion.

## APPLICATION

Application by brush, roller and spray gun. Apply uniformly and spread thoroughly in order to obtain a 75-micron wet film, and avoid long drying times, wrinkles, stuck dirt, etc.  
For brush or roller application, dilute the product with a small amount of Tkrom Synthetic Solvent 345 or Tkrom Turpentine Solvent 390.  
For spray gun application, dilute the product in 15 to 20% with Tkrom Synthetic Solvent 345 to a viscosity of 25 seconds at 25 °C in a Ford cup no. 4.  
Use a nozzle with a diameter of 1.5-1.8 mm and 2.5-3.5 kg/cm<sup>2</sup> of air pressure.  
For application with an airless gun, use 0.3-0.4 mm nozzles with pressure at 100-120 bars, 5-10 % dilution with Tkrom Synthetic Solvent 345, and an application angle of 75°-80°.

TOOL  
CLEANING

All used tools must be immediately cleaned after use with any of the solvents recommended for dilution, or with TKROM UNIVERSAL SOLVENT 302 (TDS6961).

## WAITING TIMES

Dry at 20 °C and with 65 % relative humidity: The product dries to the touch in 60 minutes. Non-tacky dry in 3-4 hours. It can be repainted after 12 hours.

## SAFETY

For any information regarding safety issues in the use, storage, transport, and disposal of this product, users should consult the labelling and the latest version of its Safety Data Sheet, which includes the physical, ecological, and toxicological data, as well as other issues on the matter.

SAFETY DATA SHEET	LoW CODE	TYPE OF WASTE
MSDS-6325	08 01 11	HAZARDOUS

## STORAGE

The shelf-life of the product in the original unopened container at ambient temperatures not exceeding 30 °C or reaching less than 5 °C shall be 24 months from the manufacture date. Store in a cool and dry place and keep the original container well-closed, undamaged, and protected from frost and direct sunlight.

## TARIFF HEADING

TARIC code: 3208 90 91

**Note: Data contained in this technical sheet may be modified according to possible variations in formulation and, in any case, they express indicative values that do not exempt from carrying out the appropriate tests of product suitability for a specific work.**