



# TARA PAINTS & CHEMICALS

(An ISO 9001:2015 Certified Company)

A - 423 / 14, Mahagujarat Industrial Estate, Sarkhej - Bavla Road, Lane Behind Satyam Arcade,  
Village : Moraiya, Ahmedabad - 382 210, Gujarat (India)

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## ETCH PRIMER

- 1) **Introduction** TARALAC<sup>®</sup> Etch Primer is a vinyl based zinc chromate two component primer used to inhibit corrosion and promote adhesion to metal substrates including anodized aluminum, stainless steel, and de-oiled washed galvanized steel.
- 2) **Range of application** TARALAC<sup>®</sup> Etch Primer is designed to prime and seal old and new properly prepared, metal surfaces prior to the application of TARALAC<sup>®</sup> topcoats or TARALAC<sup>®</sup> finish primers. This products is ideal for masts, parts and thin gauge metal where minimal faring is required. It may be top coated or primed depending on the application requirements. Etch primer may be used above and below the waterline.
- 3) **Color** Colors of mixture: Yellow Green  
Base material: Yellow Green  
Hardner : Clear
- 4) **Coverage** Volume Solids catalyzed without reduction 12%  
*Note: Coverage rates are figured for the based and Hardner. Reducer is added as percent of total quantity of base & Hardner*

	m <sup>2</sup> / liter	m <sup>2</sup> / gal	sq.ft/ gal	Rec.DFT in µm(mils)
<b>Theoretical</b>	15	57	633	8(0.3)
<b>Practical</b>				
Conventional Air Spray Equipment	7.5	28.6	308	8(0.3)
HVLP Air Spray Equipment	8.6	33	354	8(0.3)
Brush / Roller and Airmix Equipment	12.9	50	530	8(0.3)

- 5) **Substrate treatment** pre- The substrate must be clean, dry and free from dust, grease ,oil and other contamination. TARALAC<sup>®</sup> Etch primer may be applied directly to the properly cleaned and prepared Aluminum or Steel substrate.  
To achieve optimum adhesion and performance :  
**Steel** should be prepared by sandblasting to near white metal, Sa2.5 (SSPC-SP10-85) or ground 36 to 60 grit to a 50-100 micron (2-4 mils) profile.  
**Aluminum**  
When applying topcoat over Etch Primer the surface should grit.  
When applying Finish Primer over Etch Primer the surface should be sanded with 80-180 grit or grit blasted.  
May be used to clean the surface prior to applying Etch Primer  
DO NOT use treatment under Etch Primer  
Contact your TARALAC<sup>®</sup> Representative to discuss chemical treatment options

All the information given here are as per the results obtained in laboratory & are given in good faith to guide the user but without any warranty, the actual application results might vary depending on the conditions. We are not responsible for any loss, injury or damage resulting from the use of this information



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- 6) **Trade names** to clean the metal substrate before application of Etch Primer.  
Base Material TARALAC® Etch Primer Yellow  
Hardner TARALAC® Etch Primer Hardner  
Reducer TARALAC® 091
- 7) **Mixing Ratio**  
1 parts by volume TARALAC® Etch Primer Base  
1 part by volume TARALAC® Etch Primer Hardner

**Wash 15 minutes after mixing base and Hardner before adding the reducer**  
**Note: It is necessary to use 091 reducer in this product at the mix ratio indicated above.**

- 8) **Application**
- |                                |   |
|--------------------------------|---|
| Viscosity DIN 4 (Zahn #2)      | approx. 15-30 sec(xx sec)   |
| Fluid Nozzle Size Pressure Pot | 1.0 to 1.4 mm (0.040 to 0.059)-<br>Conventional & HVLP                              |
| Fluid Nozzle Size Siphon Cup   | 1.6 mm (0.060)- Conventional & HVLP   |
| Atomizing Pressure             | 3.0 to 3.5 bar (43 to 51 PSI)-<br>Conventional & HVLP                               |
| Pot Pressure                   | 0.7 to 1.5 bar (10 to 15 PSI)-<br>Conventional & HVLP                               |
| Airmix Equipment               | 0.18 to 0.28 mm (0.007 to 0.011)<br>Inlet pressure 3.0 to 5.0 bar (42 to 70<br>PSI) |

- Spray Apply 1 cross coat to a dry film thickness (DFT) of 6-12 microns (0.25-0.5 mil).  
Minimum recommendation film is 6 microns (0.25 mil)DFT. Maximum  
recommendation film thickness during a spray application is 1 coat totaling 12  
microns (0.5 mil) DFT.  
Due to the characteristics of the products the wet film thickness is not measurable.  
Make sure to achieve a close layer.
- Brush Only for small areas or repair.

**IMPORTANT NOTE:** Do not apply this product over the maximum recommended film thickness. The  
coating should be applied in an even transparent film.



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<b>9) Pot life and Drying</b>		Optimal application environment range-min. 15°C (60°F) 40% RH, up to max. 30°C (85°F) 80% RH			
Temperature for minimum recoat time	15°C (60°F)	20°C (68°F)	25°C (77°F)	30°C (85°F)	Max Dry Time
Pot Life-approx	12 hrs	12 hrs	12 hrs	12 hrs	N/A
Dust Free	15 min	15 min	10 min	10 min	
Tape Dry	30 min	30 min	30 min	30 min	N/A
Fully Cured	2 days	2 days	1 day	1 day	N/A
Overcoat with another product including. Sanding is required after max time	4 hrs minimum	4 hrs minimum	3 hrs minimum	3 hrs minimum	6 hrs minimum

Note: The above chart reflects approximate minimum and maximum time. Surface temperature , air flow , direct or non-direct sunlight, quantity and or choice of reducer, and film thickness will effect actual tack up, recoat, overcoat ,and drying times during application. During the drying phase the minimum temperature is 15°C (60°F). Ideal temperature: 25°C (77°F). The minimum application condition should be 3°C (5.4°F)above dew point