



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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Directions for Use P.U. Metal finish

PU Metal Coat coating can be done in various ways depending on the application & budget. There is no specific way for coating of PU, but certain do & don't are there which should be kept in mind while applying PU. However the best result can be obtained when the coating is done on non absorbent surface (i.e PU primer or Polyester putty). However there is no single procedure for the PU metal finish to be applied. We are giving herewith the general procedure

1st step in Coating of Metal finish always begins with Surface preparation. Surface to be coated should always be free of rust, dust, grease or oil. It should have profile of at least sa (2½) to which the paint can get adhesion. After achieving a profile of sa (2 ½) the primer should be applied within 2 hours. The surface should be made rough with the help of abrasive material or sand blasted to achieve the desired profile. System of coating should be selected depending on the type of substrate.

Note:

1. Top coat should not be applied on Top Coat.
2. Stain can be incorporated in any of the stage from bottom to top coat, but it will be always be better to apply it directly on the wood.



AUTO REFINISH

System 1 (M.S., Cast Iron)	System 2 (M.S., Cast Iron, Galvanised.)	System 3 (M.S., Cast Iron, Galvanised.)	System 4 (M.S., Cast Iron, Galvanised.)
1 st Coat of Synthetic Primer (Auto oil primer, Red oxide, Zinc Chromate, etc.) or 1K Primer	1 st Coat Epoxy Primer	1 st Coat Epoxy Primer	1 st Coat Epoxy Primer
Apply NC Putty after 6 hours & level the surface by sanding wet or dry.	Apply NC Putty after 6-12 hours & level the surface by sanding wet or dry.	Apply Polyester putty after 6-12 hours & level the surface by sanding wet or dry.	Apply Polyester putty after 6-12 hours & level the surface by sanding wet or dry.
NC primer or 1K primer should be applied & all minor surface defects is to be removed.	2 nd Coat Epoxy Primer or NC Primer or 1K Primer to remove all minor surface defects is to be removed.	2 nd Coat Epoxy Primer or 1K Primer & all minor surface defects is to be removed.	2 nd Coat PU Primer & all minor surface defects is to be removed.
Surface is ready for the topcoat only after 72 hrs of Primer Application	If Epoxy Primer is applied Top coat can be applied after 8 hours	If Epoxy Primer is applied Top coat can be applied after 8 hours	If Epoxy Primer is applied Top coat can be applied after 8 hours
Surface is now ready for the top coat.	If NC primer apply Top coat after 72 hrs.	Surface is now ready for the top coat.	Surface is now ready for the top coat.
	Surface is now ready for the top coat.		
Finish : Average Costing : Very Good Time taken : 6 – 8 days	Finish : Good Costing : Medium Time taken : 4 – 8 days	Finish : Excellent Costing : High Time taken : 3 – 5 days	Finish : Excellent Costing : Very High Time taken : 3 – 5 days

Top coat can be applied depending on the type of coating required.

If metallic finish or pearls finishes are there then the system 2 coat system is to be applied.

If Solid colors are there then single coat or 2 coat both systems can be applied depending on the type of finish required.

However there are multiple procedures which can be applied considering the type of finish, Cost & Time factors available.



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AUTO O.E.M FINISH

<u>System 1</u> <u>(M.S., Cast Iron)</u>	<u>System 2</u> <u>(M.S., Cast Iron, Galvanized.)</u>	<u>System 3</u> <u>(M.S., Cast Iron, Galvanized.)</u>	<u>System 4</u> <u>(M.S., Cast Iron, Galvanized.)</u>
1 st Coat Epoxy Primer	1 st Coat Epoxy Primer	1 st Coat Stoving Primer	1 st Coat Stoving Primer
Apply Polyester putty after 6-12 hours & level the surface by sanding wet or dry.	Apply Polyester putty after 6-12 hours & level the surface by sanding wet or dry.	Apply Polyester putty & level the surface by sanding wet or dry.	Apply Polyester putty & level the surface by sanding wet or dry.
2 nd Coat Epoxy Primer & all minor surface defects is to be removed.	2 nd Coat PU Primer & all minor surface defects is to be removed.	2 nd Coat Epoxy or PU Primer & all minor surface defects is to be removed.	2 nd Coat Epoxy or PU Primer & all minor surface defects is to be removed along with the stoving.
Surface is now ready for the top coat.	If Epoxy Primer is applied Top coat can be applied after 8 hours	Surface is now ready for the top coat after 8 hours	Surface is now ready for the top coat.
	Surface is now ready for the top coat.		
Finish : Excellent Costing : High Time taken : 3 – 5 days	Finish : Excellent Costing : Very High Time taken : 3 – 5 days	Finish : Excellent Costing : Average Time taken : 2 – 3 days	Finish : Excellent Costing : Average Time taken : 1 – 2 days

However there are other primers that are also applied in OEM finish such as CED., AED or electrophorating.

If metallic finish or pearls finishes are there then the system 2 coat system is to be applied.

If Solid colors are there then single coat or 2 coat both systems can be applied depending on the type of finish required.

However there are multiple procedures which can be applied considering the type of finish, Cost & Time factors available & recommendation of the Manufacturer.

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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MACHINERY OR GENERAL METAL COAT

System 1 (M.S., Cast Iron)	System 2 (M.S., Cast Iron, Galvanised,)	System 3 (M.S., Cast Iron, Galvanised,)	System 4 (M.S., Cast Iron)
1 st Coat of Synthetic Primer (Auto oil primer, Red oxide, Zinc Chromate, etc.)	1 st Coat Epoxy Primer	1 st Coat Epoxy Primer	1 st Coat HB PU primer
Apply NC Putty after 6 hours & level the surface by sanding wet or dry.	Apply NC Putty after 6-12 hours & level the surface by sanding wet or dry.	Apply NC Putty after 6-12 hours & level the surface by sanding wet or dry.	Apply NC Putty after 6-12 hours & level the surface by sanding wet or dry.
NC primer should be applied & all minor surface defects is to be removed.	2 nd Coat Epoxy Primer or NC Primer or 1K Primer to remove all minor surface defects is to be removed.	2 nd Coat HB Primer or epoxy primer	2 nd Coat HB Primer or epoxy primer
	If Epoxy Primer is applied Top coat can be applied after 8 hours	If Epoxy Primer is applied Top coat can be applied after 8 hours	Surface is now ready for top coat.
	If NC primer apply Top coat after 72 hrs.		
	Surface is now ready for the top coat.	Surface is now ready for the top coat.	

HB Top coats & Primers are usually preferred by the Machinery Manufacturer. However using HB primer or Top coat gives good finish but a less service life than HS PU grade.



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GLASS & METAL COAT

<u>System 1</u>	<u>System 2</u>	<u>System 3</u>	<u>System 4</u>

TARALAC®