

SAXON TC-250

DESCRIPTION

SAXON TC-250 is a two-component, high-build semi-gloss aliphatic acrylic polyurethane finish.

COLOUR AND PRODUCT PRESENTATION

| | |
|--------------|--|
| Colour range | See Saxon Colour Chart (other colours available on request) |
| Size | 5litre - 10 litre drum - 20 litre drum (large size available on request) |
| Semi-gloss | (Flat availability on request for limited colours) |

- ✦ Easy application by brush, roller and airless spray
- ✦ Unlimited recoatable
- ✦ Excellent resistance to atmospheric exposure conditions
- ✦ Good color and gloss retention (aluminum version becomes grey)
- ✦ Cures at temperatures down to -5°C (23°F)
- ✦ Tough and abrasion resistant
- ✦ Resistant to splash of mineral and vegetable oils, paraffins, aliphatic petroleum products and mild chemicals
- ✦ Can be recoated even after long atmospheric exposure

MAIN PROPERTIES

| PREPARED MIX PRODUCT | |
|--------------------------------|---|
| Application | Roller, brush or spray gun/machine |
| Touch Dry | 1 hour depending on ambient temperature |
| Recoatable | 6 hours, Drying times will be significantly longer in cold, damp conditions, full cure in 4 days. |
| Coverage | White: 11.6 m ² /l for 50 µm (465 ft ² /US gal for 2.0 mils) Aluminum: 9.6 m ² /l for 50 µm (385 ft ² /US gal for 2.0 mils) This number will be lower on highly porous surfaces |
| Recommended dry film thickness | 50 - 75 µm (2.0 - 3.0 mils) depending on system |
| Shelf Life | Base: at least 36 months when stored cool and dry Hardener: at least 24 months when stored cool and dry |
| Pot life | 5 hours at 20°C (68°F) |

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES



Substrate conditions

- ✦ Previous coat (epoxy or polyurethane) must be dry and free from any contamination
- ✦ Surface of previous coat should be sufficiently roughened if necessary

Substrate temperature and application conditions

- ✦ Substrate temperature during application and curing down to -5°C (23°F) is acceptable; provided the substrate is free from ice and dry
- ✦ Substrate temperature during application and curing should be at least 3°C (5°F) above dew point
- ✦ Relative humidity during application and curing should not exceed 85%
- ✦ Premature exposure to early condensation and rain may cause color and gloss change

PREPARATION

New surfaces

Apply to a clean dry surface. Ensure any rust or damp is removed prior to application. All surfaces must be sound, suitably dry and free from anything that will interfere with the adhesion of the materials to be applied. Surfaces with suction (porous surfaces) should be treated with an application of previous coating recommended by the manufacturer based on surface conditions.

Previously painted surfaces

All surfaces must be sound, suitably dry and free from any contamination that will interfere with the adhesion of the materials to be applied. Remove all loose, failing or unsuitable material by scraping or brushing with a stiff bristle brush (do not use wire brush) to a sound edge. Dirt, fungus, rust, or any other contaminant growth must be removed, and the areas treated before applying the coating. For surfaces in poor condition mechanical means may be necessary like pressure washing with a minimum 1500 psi, a proprietary paint removal system, wet or dry grit blasting. Care must be taken not to damage the underlying surface.

Mixing ratio by volume: base to hardener 88:12

- ✦ The temperature of the mixed base and hardener should be above 10°C (50°F), otherwise extra thinner may be required to obtain application viscosity
- ✦ Adding too much thinner results in reduced sag resistance
- ✦ Thinner should be added after mixing the components
- ✦ Aluminum version has lower gloss than the standard version and the color could be different by application method.

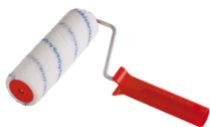
COATING SYSTEM

APPLICATION

Stir well before and during use.



ROLLER



Apply using a roller, using it directly from the drum ensuring the entire sleeve is covered. Work in a methodical, systematic manner maintaining a manageable wet edge blending the material to achieve the desired pattern whilst still wet. Maintaining a continuous wet edge (approximately 1 m²)

BRUSH



Before use, flick the bristles back and forth to remove dust. Make sure you remove excess liquid before painting. Fill the brush by dipping in up to half the length of the bristles. Tap it gently against the side of the can: don't wipe the brush hard against the lip. The bristles should flex only slightly as you brush – don't over press – let the paint flow from the brush.

Start at the top and work down, painting with light even strokes, working back into the wet edge. If you are painting a large area by brush, apply paint to an area about 50cm x 50cm, then brush the paint in horizontal strokes to even the paint out and finish off with light vertical strokes all in one direction. If you are using a brush and roller, paint the edges of the area first.

SPRAY



For best results in terms of finish, coverage, speed of application and low overspray, the following set up is recommended.

Use conventional spray equipment i.e., GC 200/24 2HP compressor or larger, that can continuously deliver a minimum of 80psi at 4-5 cubic feet per minute on a 3 meters (maximum) length airline to the spray gun. A GC 330 hopper feed spray gun with a 3mm air cap and tip size of 3-4mm tip size. Apply at 40psi air flow/spraying pressure with an 18" (450mm) distance from gun tip to surface being coated (target). Cover areas not to be sprayed with masking tape and wet strength masking paper or film. Spray using a circular or 'cross hatch' method, i.e. horizontally and vertically to achieve a full, uniform and even texture overall. Clean the tip and air cap frequently during use to prevent blocking.

Other painting methods and pumps can be used. Please contact Saxon Technical Support for further information.

CLEANING

Return excess material/paint to container. Wash with clean water immediately after use.



HEALTH AND SAFETY RECOMMENDATIONS Please refer to the Safety, Health and Environmental Information on the container. When preparing the surfaces avoid the inhalation of dust and/or metal particles. Wear a suitable facemask and recommended safety personal protection. Material Safety Data Sheets for this is available freely available at Saxon Paints website.

STORAGE Store in secure dry conditions. Keep out of reach of children. Containers should be kept closed during storage. Do not empty into drains, water rivers or access routes to septic drums.

ADDITIONAL DATA

Spreading rate and film thickness – White

| DFT | Theoretical spreading rate |
|------------------|--|
| 50 µm (2.0 mils) | 11.6 m ² /l (465 ft ² /US gal) |
| 75 µm (3.0 mils) | 7.7 m ² /l (310 ft ² /US gal) |

Spreading rate and film thickness – Aluminum

| DFT | Theoretical spreading rate |
|------------------|---|
| 50 µm (2.0 mils) | 9.6 m ² /l (385 ft ² /US gal) |
| 75 µm (3.0 mils) | 6.4 m ² /l (257 ft ² /US gal) |

Overcoating interval for DFT up to 75 µm (3.0 mils)

| Overcoating with... | Interval | -5°C (23°F) | 0°C (32°F) | 10°C (50°F) | 20°C (68°F) | 30°C (86°F) | 40°C (104°F) |
|---------------------|----------|-------------|------------|-------------|-------------|-------------|--------------|
| itself | Minimum | 24 hours | 16 hours | 8 hours | 6 hours | 5 hours | 3 hours |
| | Maximum | Unlimited | Unlimited | Unlimited | Unlimited | Unlimited | Unlimited |

Note: Surface should be dry and free from any contamination

Curing time for DFT up to 75 µm (3.0 mils)

| Substrate temperature | Dry to handle | Full cure |
|-----------------------|---------------|-----------|
| -5°C (23°F) | 24 hours | 15 days |
| 0°C (32°F) | 16 hours | 11 days |
| 10°C (50°F) | 8 hours | 6 days |
| 20°C (68°F) | 6 hours | 4 days |
| 30°C (86°F) | 5 hours | 3 days |
| 40°C (104°F) | 3 hours | 48 hours |

Notes:

- Adequate ventilation must be maintained during application and curing
- Premature exposure to early condensation and rain may cause color and gloss change



| Pot life (at application viscosity) | |
|-------------------------------------|----------|
| Mixed product temperature | Pot life |
| 10°C (50°F) | 7 hours |
| 20°C (68°F) | 5 hours |
| 30°C (86°F) | 3 hours |
| 40°C (104°F) | 2 hours |

For further information contact Saxon Paints

GENERAL INFORMATION

Apply all products in accordance with BS 6150: 2006 Code of practice for painting of buildings and BS 8000: Part 12: 1989 Code of practice for decorative wallcoverings and painting.

Every care is taken to ensure that all information provided on this Technical Data Sheet is accurate. Final results cannot be guaranteed by the manufacturer as it has no control over the conditions under which its products are applied.

For help or more information contact Saxon Paints or visit our website at www.saxonpaints.com Before using this product please ensure you have the latest information. The information is correct at date of issue February 2022.

WARRANTY

SAXON PAINTS warrant its title to the product, that the quality of the product conforms to Saxon Paints' specifications for such product in effect at the time of manufacture and that the product shall be delivered free of the rightful claim of any third person for infringement of any patent covering the product. This product is for professional use only. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly and according to Saxon Paints' technical documentation. Applicators and operators shall use appropriate personal protection equipment when using this product. This guideline is given based on the current knowledge of the product. These are the only warranties that Saxon Paints makes and all other express or implied warranties, under statute or arising otherwise in law, from a course of dealing or usage of trade, including without limitation, any other warranty of fitness for a particular purpose or use, are disclaimed by Saxon Paints. Any claim under this warranty must be made by Buyer to Saxon Paints in writing within five (5) days of Buyer's discovery of the claimed defect, but in no event later than the expiration of the applicable shelf life of the product, or one year from the date of the delivery of the product to the Buyer, whichever is earlier. Buyer's failure to notify Saxon Paints of such non-conformance as required herein shall bar Buyer from recovery under this warranty Any suggested deviation to suit the site conditions shall be forwarded to the responsible Saxon Paints' representative for approval before commencing the work.

LIMITATIONS OF LIABILITY

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