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TECHNICAL DATA SHEET

TETRAMETAL 521

Product description

TETRAMETAL 521 is a general purpose, fast drying, semi-gloss alkyd enamel paint.

Intended uses

It is recommended for use on metal structures, on interior and exterior primed surfaces as well as for the repainting of old similar surfaces. It resists exposure to mild corrosive environments.

Product data

Indicative film thickness, dry:	50 µm			
Indicative film thickness, wet:	107 µm			
Theoretical coverage 50µm:	9,3 m²/l			
Suggested dry film thickness:	40-60 µm			
Gloss (GU 60 °)	Semi Gloss (50-60)			
Solids by volume	47 %			
Density	1,16-1,20 gr/ml			
Indicative drying times and overcoating/ Relative humidity 50%±5	°C	Touch Dry, Minutes	Hard Dry, Hours	Overcoating, Hours
	15°	30min	2h	24h
	25°	20min	1,5h	16h
Colours	Wide range of colours available via TETRALUX tinting system.			
VOC (Volatile Organic Compounds)	EU limit value for this product Category A/i, Type:SB, One-pack performance coatings, is 500g/l (2010). This product contains max 499g/l			

Surface preparation

Surfaces must be clean, dry and free of oily substances and deposits of other materials which will prevent or affect adhesion.



Before applying the undercoat: surfaces must be assessed and treated accordingly, sandblasting to Sa2½ level (EN ISO 8501-1:2007) is recommended while for surfaces to be prepared by hand they should be prepared to a minimum St3 level (EN ISO 8501-1:2007) at the time of painting.

Recommended undercoat

B PRIMER 121

Application

Apply one layer for DFT 40-60µm. Its composition allows the required thickness to be achieved in one layer without sagging during application.

Application methods

The product can be applied by:

Air spray: 1,4-1,6mm, 2 - 2.5 bar (29 - 36 psi)

Airless spray: 0,015-0,018", 150 bar (2175psi)

Brush and Roller. Recommended for small areas. Care must be taken to achieve the specified dry film thickness.

Thinner solvent

Thinners: No802, 806, 803

Air spray: 10-15% (V)

Airless spray: 5-10% (V)

Caution: Recoating after 24 hours with No803 and with No802, 806 after 2-3 days

Brush and Roller: 5-10% (V), preferably with No803

Cleaning solvent

Thinners No802, 806

Additional notes

Certain shades for example, yellows, oranges and reds may require additional coat to achieve full opacity.

Application conditions

In conditions of high relative humidity (80-85%), good ventilation conditions are essential. Substrate temperature shall be at least 3°C above the dew point and always above 0°C. Application at ambient air temperatures below 5°C is not recommended.

**Safety**

Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult TETRALUX Safety Data Sheets and follow all local or national safety regulations.

Remarks**Caution**

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. Applicators and operators shall use appropriate personal protection equipment when using this product.

Storage

Keep the containers in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.