



FEATURES

It is a top quality alkyd gloss finish especially developed to with stand the most severe condition of tropical climate. It is made from medium oil alkyd and light fasted pigments. This enamel has excellent gloss retention and resistance to fungus attack.

It is most suitable for the application of woods,metal,both exterior and interior.It is also ideal for the uses as marine enamel,heavy machineries,bridges,towers,trucks,tractors,public transport vehicles etc.

Where toughness and durability are of primer importance

TECHNICAL INFORMATION

Type	Alkyd Enamel for Decorative	
Color	Please refer 4 Seasons catalog	
Film appearance	Gloss Finish	
Solid by volume	43	%
Solid by weight	57.	%
Flash point	40%	°C
Volatile organic compounds (VOCs)	-	gram / liter
Wet film thickness	70	microns
Dry film thickness	30	microns
Theoretical coverage.	13	sqm / liter / coat
	50	sqm / gallon / coat

Remark - Actual Surface coverage will depend on surface irregularities, Mixing, Application Condition method and technique; as well as the structure and dimensions of the object to be coated.

Touch dry (25-30°C)	1.5-2	hours.
Recoat dry (25-30°C)	6-8	hours.
Full cure (25-30°C)	7-10	days.

REFERENCE STANDARD

TIS 327-2553(2010) , TIS 2625-2557(2014)

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APPLICATION

Tools	Roller, Brush, Spray	
Thinner No.	TOA Thinner No.23 , TOA Thinner No.21	
Dilution (%)	10 -15	%

APPLICATION SYSTEM

Surface Preparation

Old surface (Steel)

Polishing the paint film peeling out and clean the dust, rust and grease-free

Old surface (Wood)

Polishing the paint film peeling out and clean the dust and grease-free

New surface

Steel substrate must be prepared ,free from rust,millscale,dirt,loose particles,and waxy contaminate.

Wood substrate must be prepared ,free from dirt,loose particles,and waxy contaminate.

Coating system

Primer

Steel

: 4 SEASONS RED OXIDE PRIMER 1-2 coat . (40 μ per coat)

Alloy

: Apply 1 coat TOA Wash Primer for galvanized steel and aluminium alloy surface (10 μ per coat)

: 4 SEASONS RED OXIDE PRIMER 1-2 coat . (40 μ per coat)



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<p>Wood</p>	<p>4Season Wood Primer (F-1600) or TOA Aluminium Wood Primer (G-1601) is required for new resinous wood. (40 μ per coat)</p>
<p>Topcoat</p>	<p>Apply 4 Season Enamel gloss 2 coat (30 μ per coat)</p>
<p>Recommendation</p>	<p>: The temperature of the substrate should be minimum 10 °C and at least 3 °C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. Good ventilation is required in confined areas to ensure correct drying.</p>
<p>HANDLING AND STORAGE</p>	
<p>Storage condition</p>	<p>: The product must be stored in accordance with national regulations. Keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed.</p>
<p>Shelf life</p>	<p>: 60 month 30 °C</p>
<p>HEALTH AND SAFETY</p>	
	<p>: Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.</p> <p>: For detailed information on the health and safety hazards and precautions for use of this product we refer to the Material Safety Data Sheet.</p>
<p>DISCLAIMER</p>	
	<p>: The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, we cannot guarantee anything only the quality of the product itself. We reserve the right to change the given data without notice.</p>