



GENERAL:

TEDAC® is easy to install, but its application does require some specific knowledge and experience. Therefore, do not start application of the TEDAC® coating until you have at least familiarised yourself with the following. In some cases we will be happy to provide you with a demonstration of the (processing of the) coating on-site for you and your associates.

Use of cleaning agents:

The surface to be coated must be dry and free of all types of oils, film layers, grease, silicones and wax. The surface may not be cleaned using cleaning agents or solvents that may leave behind traces or a thin residue after cleaning. TEDAC® coating that is applied to a contaminated surface will not adhere sufficiently and its protective properties may therefore be affected. If TEDAC® coating is applied to surfaces on which residual cleaning agents have been left behind, the coating may also display white spots over time.

Often on **new materials** it is not necessary to use a strong all-purpose cleaning agent, and this may damage the surface. Therefore, we recommend that you use the specially developed **TEDAC® Mild Cleaner** on new surfaces.

TEDAC® Normal Cleaner is used on all **used materials**, unless these are severely fouled.

For severe fouling (e.g. when cleaning yellowed Trespa or removing resins or tar) we recommend using our **TEDAC® Extra Strong Cleaner**.

If there is silicone on the surface to be treated, and this silicone cannot be removed using TEDAC® Normal Cleaner, the surface should be treated with a silicone remover.

To ensure that the surface to be treated is free of all possible forms of contamination, it is important that the surface is cleaned with a powerful degreaser one last time immediately before application of the TEDAC® treatment. For this, we recommend you use the specially developed **TEDAC® Degreaser**.

The cleanliness of the surface can be tested before applying the TEDAC® coating. Apply a drop of distilled water to a PH strip and hold the strip against the surface. If there is no change in colour, the surface is sufficiently clean. If the PH strip changes colour, the cleaning procedure has to be repeated.

ADDITIVES:

TEDAC® coating is supplied with TEDAC® Hardener and TEDAC® Thinner. These products should be added before applying the TEDAC® coating. Add TEDAC® Hardener and TEDAC® Thinner to the TEDAC® coating in a ratio of 100 (TEDAC® coating) : 20 TEDAC® Hardener) : 25 TEDAC® Thinner. To 1 litre of TEDAC® coating, you therefore add 200 ml of TEDAC® Hardener and 250 ml of TEDAC® Thinner. This mixture should be **stirred (not shaken)** for two (2) minutes.



ATTENTION:

Newly-painted surfaces:

Layers of paint that are treated with TEDAC® coating, must have dried fully in accordance with the manufacturer's instructions. The paint must be fully free of silicone, as silicone may hinder optimum adhesion of the TEDAC® coating. By testing a small and inconspicuous area you can check whether this causes a crackle or spider's web pattern. If that is the case you are advised to remove the TEDAC® coating. In this situation, do not apply any TEDAC® coating. The paint concerned and TEDAC® coating are clearly not compatible. If the layer of paint is compatible with TEDAC® coating and the surface to be treated is clean, you can move to the application phase.

If the surface has been exposed to weather conditions and dirt a particular time after cleaning, first clean the surface again thoroughly as described above.

Old painted surfaces:

All old loose and oxidised paint must first be removed. If necessary, touch up in places and allow the paint to dry in accordance with the supplier's specifications before applying TEDAC® coating.

Degraded surfaces can be cleaned using the specially developed TEDAC® Cleaners described above. It is recommended that you test a small area of the surface beforehand.

Continually dampen the surface to be cleaned and ensure that the surface remains wet during cleaning. Use a non-scratch sponge to which the cleaning agent is applied. Clean and thoroughly rinse a small area before moving on to the next section. The cleaning agent should not dry on the surface. Ensure that the surface is free of grease and clean thoroughly between cracks and crevices. Not all surfaces react to cleaning in the same way.

Ensure that all cleaning products and processes are suitable for the surface to be cleaned. If you are in doubt, please get in touch with your supplier.

Application:

TEDAC® coating can be used directly on painted, treated or untreated surfaces as a *top coat*. TEDAC® coating can be applied using a **brush, roller or professional spraying equipment**. Recommended application equipment for TEDAC® coating:

- HVLP spray system with a nozzle between 1.0 and 1.8 mm with a pressure from 2.5 to 3.5 bar
- Airless or Airmix spray system with a nozzle between 0.5 and 0.8 mm with a pressure from 3 to 5 bar
- **TEDAC® roller**
- Brush



Temperature and humidity:

The **ambient temperature** for application of TEDAC® coating can vary between 10°C and 30°C, with an optimum temperature between 18 and 25°C.

For the best result with TEDAC® coating, the **surface temperature** should be between 15°C and 35°C and the **product temperature** of TEDAC® coating should be between 15°C and 30°C. When processing TEDAC® coating at a surface temperature above 25°C, it is advisable to add additional TEDAC® Thinner to the TEDAC® coating.

Humidity is also an important factor in the application of TEDAC® coating. Do not carry out any work at a **relative humidity** higher than 85%.

Neither should work with TEDAC® coating be carried out at temperatures that are lower than 15% above the **due point**.

We recommend that you get in touch with your supplier if you are in doubt about processing TEDAC® products around the border values listed above.

Processing time (pot life)/evaporation rate/drying time/setting time

After mixing the components, the prepared product remains processable for a maximum of **eight (8) hours**. After that you should not use TEDAC® coating and additives any more! Higher temperatures than indicated above may speed up setting.

The **evaporation rate** of TEDAC® coating is ±5 minutes. **Drying** of TEDAC® coating at normal ambient temperature takes around ±45 to 60 minutes. Using **forced drying** (at temperatures of 60°C to 80°C) it is possible to achieve a reduction in drying time to ±15 to 30 minutes.

The full **setting** takes ±7 days at a minimum temperature of 15°C. If the drying temperature falls below 15°C, this can delay or halt setting. Infrared drying is permitted and shortens the setting time.

Working conditions:

Ensure sufficient ventilation during application of TEDAC® coating and associated products in order to enable removal of steam and mist during application. You should also take the necessary precautions to prevent inhalation of mist and steam. Any conditions and sources that may cause a fire should be excluded.

Consult the relevant TEDAC® Product **Safety Data Sheet** particularities regarding respirators and protecting clothing/gloves.



Working method:

Spray the surface from top to bottom and then work back and forth in a horizontal pattern (criss-cross motion). Overlapping is permitted with TEDAC® coating so long as you ensure that overlapping takes place before the coating dries.

For applications that require the application of multiple layers of coating, the following applies: the layers that follow after the first layer must be applied within 5 to 10 minutes, depending on the conditions, such as temperature, etc. This is a question of experience which you will acquire in the application of TEDAC® coating.

After using the spray system, it is advised that you rinse this with a special solution. For this, we recommend you use the specially developed **TEDAC® Sprayer Cleaner**.

If TEDAC® coating is overcoated with another product, TEDAC® coating must have set fully before it can be overcoated (light abrasion and/or alternative pretreatment is required before another product can be applied).

Consumption

The theoretical **consumption** of TEDAC® coating varies between 350 and 450 m²/kg at a film thickness of 1 μ. The film thickness after setting usually depends on the substrate and the choice of TEDAC® Gloss or TEDAC® Matt, but is generally between 15 μ and 35 μ. As has already been mentioned, other factors, including temperature, humidity and equipment used also play an important part. These factors also affect the viscosity.



Degree of gloss:

TEDAC[®] coating is available in two basic versions: **TEDAC[®] Gloss** and **TEDAC[®] Matt.**

TEDAC[®] Gloss is high gloss and has a gloss level of 82–84%. TEDAC[®] Matt has a gloss level of 1–2%. By mixing the two versions at a particular ration it is possible to achieve the desired level of gloss.

The ratio of TEDAC[®] Gloss : TEDAC[®] Matt of 50:50 results in a gloss level of ±30%.

The table below shows the correct mixtures to achieve particular degrees of gloss.

Mixture	Measuring angle	Degree of gloss	
		WHITE	BLACK
Layer thickness = 20 μ			
100G0M	60°	84	82
80G20M	60°	72	70
70G30M	60°	60	61
60G40M	60°	45	41
55G45M	60°	32	32
50G50M	60°	28	28
45G55M	60°	21	18
40G60M	60°	19	15
30G70M	60°	9	11
20G80M	60°	6	5
0G100M	60°	2	1