

<b>General Description</b>	<ul style="list-style-type: none"> <li>- TAM 395 is a combination of coaltar pitch and epoxy polyamine with bisphenol A curing agent. We specially designed it for the shipping/marine industry.</li> <li>- Minimum surface preparation is SWEEP BLAST, ideally is a full blast</li> <li>- Can be applied in high humidity conditions</li> <li>- TAM 395 can be applied to the C5-M marine environment (bottom and bottom on ships)</li> <li>- Can be applied up to 1 x 400 micron, with one instance application only</li> </ul>
<b>Characteristics Product</b>	<ul style="list-style-type: none"> <li>- Good anti-corrosion</li> <li>- Resistant to seawater</li> <li>- High Build Coating</li> <li>- Resistant to abrasion</li> <li>- Resistant to chemical polluted water</li> <li>- Surface tolerance</li> <li>- It takes a minimum of 24 hours for overcoating, in order to get a good adhesive</li> <li>- Economical product</li> <li>- Products that have field tested proven to be very strong and good</li> </ul>
<b>Typical Uses</b>	<ul style="list-style-type: none"> <li>- For applications in marine or shipping industry, barges, tugboats, and ballast tanks</li> <li>- Dump truck, under the cab and bed</li> <li>- Linings for water tanks, sewage and more</li> </ul>
<b>Specification Data</b>	
Colors	Black
Volume solids	74 ± 1 %
Curing System	Chemical Reaction Base & Activator
Typical thickness	200 - 400 microns DFT (270-541 micron WFT)
Thickness Recommendation	1 x 300 micron DFT (405 micron WFT)
Theoretical Coverage	3.7 – 1.8 sq.m/liter at 200 - 400 microns DFT
Practical Coverage	2.2 – 1.1 sq.m/liter at 200 - 400 micron DFT at loss factor 40%
Dry Temperature Resistance	Continue (93° C) Intermittent (121° C)
Temperature	The maximum temperature on the surface is 40°C
Mixing comparison	4 : 1 (four to one between Base & Activator)
Thinner	TAM 120, Maximum use of 3-8% for dilution and ease of application (if needed)
Cleaner	TAM 120
Pot life/Dry time after mixing	2 hours (35° C)
Packing size	
Product net weight	20 liter /cans
Flash point	1.26 kg/liter Maximum 21° C, where 100% solvent saturation is achieved in a closed room
Storage	Store at room temperature and dry
Shelf life	12 months from the time of delivery in a closed warehouse

**Method of Application**

Airless spray

Recommended

- Tip ranges 0,38-0,53mm
- Total output fluid pressure minimum 2500 psi
- A blotter test must be carried out on the compressor for 1 minute to find out if there is oil and water contamination from the compressor

Roll

Conventional spray

Can be used

Can be used, generally required dilution with thinner (3-8%)

**Drying time**

Substrate temperature	Touch dry	Hard dry	Overcoating Interval with Appropriate primers	
			Minimum	Maximum
35° C	3 hours	12 hours	24 hours	7 days

**Surface Preparation**

Minimum **surface preparation: Sweep Blast** (Sa 1/SSPC SP7/NACE 4 - Light blast cleaning) or NACE SSPC SP 11 Power cleaning to Bare Metal

Recommended: Full blast NACE 2/ SSPC SP10/ISO 8501-1 Sa 2.5, desired Surface profile 50 micron-75 micron

- For surface profile 50 micron: 16/40 mesh silica sand, 30 mesh garnet, 36-grit aluminium oxide, or G-40 chilled iron or steel grit
- For surface profile 60 micron: 12/30 mesh silica sand, 20 mesh garnet, 24-grit aluminium oxide, or G-25 chilled iron or steel grit
- For surface profile 75 micron: 8/20 mesh silica sand, 16 mesh garnet, 16-grit aluminium oxide, or G-16 chilled iron or steel grit

---

### Mixing

Mixing Tools: It is mandatory to use an Electric / Air Mixer or a modification of the drill tool that is provided with stirrer wings / blades, because it requires the initiation of kinetic energy so that the mixing of the chemical reaction between the base & activator becomes perfect and homogeneous

The mixing process is very important to avoid inhomogeneous paint, which will cause the drying process to be incomplete.

Part A Base: Stir 2 minutes minimum

Part B Activator: No need to stir

Mix and stir Part A & Part B: Stir for a minimum of 3 minutes, so that the initiation of the kinetic reaction can occur perfectly.

Mixed/stirred paint application must be done before 2 hours, because the paint will dry after 2 hours.

---

### Application

1. Mix the Base & Activator according to the ratio specified above and according to the needs in the field and in accordance with the pot life above
2. Mix with thinner sufficiently (Max 3-8%), do not add too much thinner, which will cause the product to become very runny, the viscosity will be too low, and cause sagging or melting and difficult to get the desired thickness
3. Stir with a mixer according to the instructions above, then it's ready to be applied with Airless Spray, Roll, or Conventional Spray
4. Trial with the number of times the spray from the nozzle or roll to get the WFT needed
5. Do a one painting application, then check the thickness of the WFT, so that the desired DFT is obtained when it is dry/cured
6. Clean application tools and equipment immediately with thinner, and hardened material can only be cleaned mechanically

---

### Safety Precaution

TAM 395 is a solvent based paint, therefore avoid:

1. Inhalation
2. Contact with eyes
3. Contact with skin

If in the process of painting, you feel tired, your eyes keep watering & you have a headache, immediately contact the nearest health center/hospital/doctor.

---

### Special Notes

1. If the surface preparation is Fullblast NACE 2/SSPC SP 10/Sa 2.5 with surface profil 50 microns, then the calculation of the required paint requirement is (desired DFT + 50 micron surface profile)
2. To calculate the actual volume value of solids in the coating:
  - Apply the coating directly on the steel surfaces, without surface preparation, and measure the WFT (Wet film thickness, micron) value. Because the profile created on surface preparation will increase the surface area and the paint will enter the profile, so the paint volume will decrease and the solid volume calculation will be invalid
  - After drying, measure the DFT (Dry Film Thickness, micron) value on the coating
    - Calculate with the formula  $\% \text{Volume solid} = \frac{DFT}{WFT} \times 100\%$

3. The application must be carried out below 40°C, so that no damage occurs to the base product polyamine
4. It is not recommended to overcoat on the Coal tar Epoxy type because the quality of the adhesion between the coating layers is weak
5. Overcoating/painting interval must be done within 24 hours – 7 days (coating time interval/allowed time for two-layer antifouling paint)
  - If it is less than 24 hours, it will cause solvent to be trapped resulting in bubbling of the coating and weak coating adhesion.
  - If the paint application is carried out for more than the maximum over coating time of 7 days, a thin sweep blast surface preparation must be carried out to create new pore profiles as a mechanical bonding in order to obtain good adhesive/adhesive power
6. It is not permitted to apply a total thickness of more than 400 microns, as this may cause sagging.
7. It is not permitted to use a manual stirrer or spatula, because it will cause an inhomogeneous reaction, so the coating cannot dry completely.
8. Minimum 24 hours after application of TAM 395 Coal tar Epoxy before lifting pipes or operating dump truck

---

#### **Legal Notes**

---

1. Information and recommendations related to products and the use of TAM products, are provided based on the knowledge and experience of TAM
2. In practice, there may be differences in the final result or product quality due to:
  - a. Improper quality of applicator work
  - b. The application is carried out in an inappropriate environment (temperature, humidity, etc.)
  - c. Inappropriate work equipment
  - d. Inadequate quality control
  - e. Does not follow the rules presented in this datasheet
3. If a dispute occurs, it will be jointly investigated to find out the root of the problem so that it can be corrected by the applicator/owner/other third party
4. The TAM Victory Cemerlang factory/or authorized distributor, is not responsible for the failure of this paint product, if from the results of a joint investigation, the applicator does not follow the instructions in this data sheet
5. If there is unclear information, please contact the technical service below.



## TAM - 395 EPOXY COAL TAR PAINT INDONESIA

### Technical Services

PT TAM Victory Cemerlang has an engineering division, with NACE certified engineers, who would support:

1. Site survey and investigation corrosion problem
2. Discuss about problems and the comprehensive solution for corrosion problem
3. Proper coating selection
4. Training & presentation on TAM Products
5. Site supervision during application

Contact us:

Factory: PT TAM Victory Cemerlang

Website : [www.tam-coating.co.id](http://www.tam-coating.co.id)

Telephone : (021) 89983138

Authorized Distributor: PT Perintis Proteksi Sejahtera (PERPRO)

Website : [www.perintis-proteksi.com](http://www.perintis-proteksi.com)

E-mail : [perpro@perintis-proteksi.com/sales@perintis-proteksi.com](mailto:perpro@perintis-proteksi.com/sales@perintis-proteksi.com)