



DESCRIPTION

TOA 2 trong 1 is produced from 1 component thermoplastic Acrylic, combines primer and topcoat into one product.

TOA 2 trong 1 is easy to apply, quick drying, build good hardness and excellent adhesion paint film on wood and metal surfaces.

TOA 2 trong 1 doesn't use lead and mercury.

TYPICAL USE

TOA 2 trong 1 used as decorative and protective coating for wood, aluminum, stainless steel, iron, galvanized steel,...

TOA 2 trong 1 is a very convenient product since can be applied as both primer and topcoat to create a quick-drying, robust, good adhesion system, hence can help to save time and workforce.

Product is designed for both interior and exterior.

PRODUCT DATA

- **Components:** Binders, pigments, additives and solvents
- **Color:** Refer to catalogue
- **Paint film appearance:** Gloss / Matt (#222; #888; #XF350; #XF910; #XF911)
- **Solid by volume:** 41 ± 2 %
- **Theoretical coverage:** 10.0 – 13.5 m²/liter/coat
Actual surface coverage will be depended on spreading ability of paint film, dry film thickness, surface irregularities, technique and wastage during painting.
- **Volatile organic compounds (VOCs):** ≤ 580 g/L
- **Flash point:** appx.28°C
- **Drying time (at relative humidity (RH) 50% & dry film thickness (DFT) 30µm - 40µm):**

○ Surface temperature	25°C	30°C	35°C
○ Surface dry (touch dry)	30 min	15 min	10 min
○ Hard dry	3h	2h	1h
○ Painting interval, minimum	1.5h	1h	45 min

Actual drying time and painting interval time may be longer or shorter than provided data, depended on environmental temperature, dry film thickness, ventilation, humidity and number of coating applied, etc.

RECOMMENDED PAINT FILM SYSTEM:

SYSTEM	PRODUCT	COAT(S)	DRY FILM THICKNESS
<i>For metal surfaces:</i>			
Primer & Topcoat	TOA 2 trong 1	2 - 3	35µm
<i>For wood surface:</i>			
Primer & Topcoat	TOA 2 trong 1	2 - 3	35µm

Technical data sheet

It is recommended to use 1 coat of #222 as base-coat together with 1-2 coat(s) of #232 / #273 / #335 / #336 / #445 / #614 to achieve desired color.

APPLICATION INSTRUCTION

▪ SURFACE PREPARATION

- Make sure the surface is dry and clean, free from grease, oil, waxy contamination, rust or mill scale.

For industrial purpose:

- Oil and grease must be cleaned in accordance with SSPC-SP1, Solvent Cleaning.
- Surface should be blast cleaned, at least achieved Sa 2.0 - Sa 2.5 (ISO 8501-1:2007).
- With area cannot be blast cleaned, use power tools to clean the surface at least achieved St2-St3 (ISO 8501-1:2007).

▪ APPLICATION

Equipment / methods:

Brush, roller, conventinal spray, airless spray

For airless spray:

- Nozzle tip size : 0.013" - 0.021"
- Angle to the surface : 65° - 80°
- Presure at nozzle : 140 - 190 Kg/cm² (2.000 - 2.600 Psi)

Paint film thickness:

	Min	Standard	Max
- Dry film thickness (DFT):	30µm	35µm	40µm
- Wet film thickness (WFT):	73µm	85µm	97µm

Film thickness will vary and is calculated as average.

Dilution ratio:

60% - 100% by weight with TOA lacquer thinner #74N for conventinal spray

0% - 30% by weight with TOA lacquer thinner #74N for brush, roller, airless spray

Dilution percentage is depending on ambient temperature, relative humidity, paint film thickness, equipment and application method.

CERTIFICATION

QCVN 08:2020/BCT - National technical regulation on the limits of lead content in paints certified.



HANDLING AND STORAGE

The product must be stored in accordance with national regulations.

Technical data sheet

Store in a dry, cool, good ventilation area; far from heat, open flame, flammable materials.

Tightly closed when not in use.

Keep out of reach of children.

Stir well before use, paint should be used up when lid opened.

Storage temperature is recommended at 25°C – 30°C.

Do not apply when temperature is lower than 15°C or higher than 40°C.

Do not apply when relative humidity exceeds 75%.

Surface temperature should be at least 3°C higher than the dew point of the air.

HEALTH AND SAFETY

Please do not handle until all safety precautions have been read and understood.

Keep away from heat, sparks, open flame, hot surface. No smoking.

Wear protective gloves, respirator, eye protection, protective clothing.

Avoid contact with skin, eyes or ingestion. Go right to the nearest health center for help in case of ingesting paint or paint contacts with eyes.

Avoid release to the environment. Treat discarded paint according to environmental law.

See more guidelines in the Safety Data Sheet.

PACKAGING

17.5 liter; 3 kg; 0.8 kg and 0.375 kg

SHELF LIFE

36 months from manufacturing day when stored at 25°C – 30°C

DISCLAIMER

The information in this data sheet is given to the best of TOA's knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, TOA cannot guarantee anything only the quality of the product itself. TOA reserves the right to change given data without notice.

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