



# TDS Sheets Custom Colors

Tamco's Custom Color line from Tamco Paint is unique in its ability. We've taken hard to create colors and simplified them. Do you want custom exotic rich colors that mix 1:1 and have 2-3 coat max coverage no matter the color? Do you want custom colors that would normally have to be created in candies or tri stages in an easy to use basecoats? If this is something you've been looking for, the Tamco Custom Color line has you covered. We've achieved rich intense candy like colors in basecoats that aren't expensive like tri stages and are user friendly and easy to spray. We've taken custom and made it simple and cost effective in typical Tamco fashion. This line will have new colors produced periodically so keep looking out for updates! Do you want a color not listed and want it created special? Just ask, we specialize in this unique ability to create from scratch hard to find custom colors

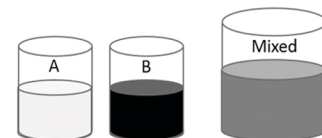


## Component

## Volume

Tamco Basecoat	Basecoat	1
HR-1360/1370/1380/1390	Reducer	1

USE ONLY TAMCO REDUCERS. Our reducers are completely moisture free. Moisture in reducer will kill the shine of our clears. 35% solid content RTS



HR1360-Fast 11-100 7085 /40 0480	HR1370- Medium 11-105 0085 /40 0780	HR1380 Slow 11-105 75 0085 /04 0080	HR1390- Extra Slow 11-10585 /0580
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HR-1390 will be 87-100°F you may need to add HR900 retarder in hot humid conditions

## Gun Setups

See manufacturers suggestions

Common User Suggestions

Iwata Supernova: 1.3 or 1.4, fluid open, trigger pull full, 1 turn in on fan, 26 psi

Iwata WS400 evo: 1.3hd fluid open, trigger pull full, 1 turn in on fan, 30 psi

Iwata LPH 400: 1.3 or 1.4 fluid open, trigger pull full, 1 turn in on fan, 20 psi (this is an lvp gun recommended by the manufacturer to be no higher than 19 psi but the extra (pressure helps atomize the clear for a smoother finish

Sata RP 4000/5000: 1.3 or 1.4 fluid open, trigger pull full, fan open, 28-30 psi

Sata 4000/5000 hvlp: 1.3 or 1.4 fluid open, trigger pull full, fan open, 29-32 psi

Devilbiss Pro Lite: 1.2, 1.3 or 1.4 TE10 fluid open, trigger pull full 28 psi

Devilbiss Pro Lite: 1.2, 1.3 or 1.4 TE20 24-26 psi





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### Application & Dry Times

See manufacturers suggestions

Common User Suggestions

Apply 2-3 coats or until proper color is achieved. Color is achieved in almost all Tamco colors in 3 coats

**Air Dry:** 70°F / 21°C

**Dust Free:** 5-10 minutes at 70°F / 21°C 10-15 minutes at 70°F / 21°C

**Tape Free:** 20-40 minutes at 70°F / 21°C

**Dry to Clearcoat:** 15 minutes at 70°F / 21°C PREFERRLY top-coated within a hour for the best chemical adhesion. 6-12 hours maximum to clearcoat. If Tamco basecoat color is allowed to dry more than 24 hours, it must be scuffed and new basecoat color applied (if it's pearl or metallic) Solids can be sanded and cleared without new base. Tamco Tip HP2010 Tamco adhesion promoter brings back the chemical window if it's lost, and no sanding is required at any point. 2 tack coats, 5 minute flash, and you can continue with more base, or clearcoat

**Striping or Two Toning:** Tape time with Tamco Base is 20-40 minutes at 70°F / 21°C and 50% relative humidity. All striping, two toning and clearcoating must be completed within 6-12 hours. If allowed to dry for more than 6-12 hours, follow steps listed above

### Air Pressure

**Gun Setup:** 1.2-1.4 mm or equivalent Note: For best overall results, refer to spraygun manufacturer's recommendations for inlet air pressures. All guns PSI varies

### Surface Preparation

Clean and prep surface with soap and water. Diluted Dawn works well too

Then clean with either Tamco HR397 Wax & Grease or Tamco HR398 Final Wipe depending on the surface

Sand with 400-600 (max) grit sandpaper or equivalent, scotch brite

Re-Clean again

Lightly scuff with 400-600 grit sandpaper or equivalent, scotch brite

Re-clean with Tamco HR398 final wipe cleaner

### What can Tamco Basecoat be sprayed over

Cleaned and sanded OEM finishes. Preferably no less than 320, no more than 600

Tamco properly prepared Primer - 53xx series. Tamco Sealer - 53xx series reduced as 4:1:2

And Tamco epoxy - HP600 series, that has flashed 12 hours prior to being topcoated

Tamco HP2010 Adhesion Promoter after at least a 5 minute flash time, and no more than a hour. If over a hour, apply another coat of Tamco AP



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### **Clean Up**

Standard lacquer thinner works, Tamco reducers work well at a higher cost  
Use Tamco T-cups and save money and time on clean up. Time is money! Our T-cups are less than the competition for true quality

### **Clearcoat**

Tamco clear coats are the only clears we recommend over Tamco basecoat, however most quality clears will work, use at your own discretion. Teaching issues is always easier when using one brand through and through

### **Pot Life**

There is zero pot life for basecoat. Even ready to spray, it has an indefinite pot life. ONLY time basecoat is affected by a pot life is if you added hardener to the basecoat

If you want to add hardener (HH76xx series hardener) you can. 16:1 and then mix it 1:1 with Tamco reducer of choice. This mixture will have a pot life of an hour or less