



AUTOMOTIVE

TAMCO PAINT

FOREVER SEAL

HP3500 / HP3501 / HP3502 / H3503

Forever Seal is a 1K (phenolic resin based) non sanding sealer that is direct to metal. It has exceptionally good filling properties and provides good color holdout and fast topcoat times. It can be applied directly over properly prepared steel, galvanized, aluminum, fiberglass, SMC, basecoat, old lacquer, old, cured enamel, and old polyurethane. The advantage of this sealer is that there is an unlimited pot-life with no recoat window to worry about. It's forever recoat-able without sanding.

This is a huge advantage to most shops as it is geared for Automotive, Industrial, Fleet and a Marine Sealer. With being able to paint a panel , car, boat or semi truck and push it aside in your shop for an hour, a day , a week or even a month. All you need to do is clean the sealer and apply your activated basecoat.

Even though **Forever seal** is non sanding technically you can, but defeats the purpose of the product. You can sand and it wont sand like a brick.

Forever Seal is not a Lacquer, enamel or even urethane. It is in a class of its own. The Phenolic resin (which stays open), will allow unlimited recoat window. (If it was a 2k it would have a limited window and "fully cure" Unlike the Phenolic based sealer we have developed). The 1k is just another plus to this product.

Features & Benefits

- Unlimited potlife
- No recoat window
- Exceptionally smooth (basecoat like finish)
- Ready to topcoat in 30 mins
- Can Spray, Brush or Roll on
- Direct to metal
- Filling capabilities
- Non Sanding
- Ideal for all coating divisions



Compatible Surfaces

- Aluminum
- Galvanized Steel
- Fiberglass/ SMC
- Bare metal
- Plastic
- E-Coat
- OEM Finishes

Required products

- HR Reducers
 - HR1360
 - HR1370
 - HR1380
 - HR1390

Optional

- Tamco® Toner/ Tamco® Basecoat
- HR900 Retarder

(See our " What Temperature should I choose PDF" for a guideline on which suits your current job)

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Surface Preparation: **Over Primer:** Properly Sand and clean with HR397 or HR397W and wipe dry with clean lint free cloth/rag. Please refer to your Primer TDS for information.
Over Metals: And wipe dry with clean lint free cloth/rag.
Plastics: Properly sand and clean with HR397 or HR397W using a scotch-brite and wipe dry with clean lint free cloth/rag.

Mix Ratio:



For Spray Gun use:

- 4:1 (4 Parts Forever Seal to 1 Part HR Reducer)



HP3500 Clear (tintable) Sealer: 4:1:2 (4 parts Clear Forever Seal to 1 part Tamco Toner to 2 parts HR Reducer)

Note: Use only Tamco® Reducers. Our reducers are moisture free.

Additives:



HR Reducers, Tamco® basecoat colors (only for HP3500 Tintable/Clear). HR900 retarder in temperatures over 90°F.

Air Pressure:



Air Pressures Conventional/ HVLP: Always refer to your gun manual for their advice in using our products.

Air pressure Gun Setups: 1.4 tip when spraying as a fine automotive sealer. 1.8 - 2.0 when spraying as a fleet or marine medium build sealer (with no reduction).



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Application:



- Clean with Tamco® HR397 (or HR397W) Wax and Grease remover. Refer to HR397 & HR397W TDS for further information.
- Sand the paint either to the bare metal, the original primer, or at least sufficiently for the new paint to adhere. Dry sand using 180-320 grit sandpaper to remove rust or surface damage before moving on.
- Re-clean with HR398 Final wipe. This is a must to remove microscopic dust particles that will end up as "dirt" in your paint job. Refer to HR398 TDS for further information.
- Final sand before sealing with 180 finishing to 320 grit sandpaper.
- Mix Forever Seal as described in the mix ratio section.
- Apply 1-2 wet coats of Forever Seal waiting 15-20 minute flash time between coats. Allow to flash for a minimum of 30-45 or 60 mins at 75 degrees before top coating.
- Spray-Gun: Apply 1-2 coats with a 15-20 minute flash time between coat @ 75°F. Allow 30-45 minutes before "nib-sanding" (if needed). Use between 25-35 psi at the gun or 5-10 psi at the cap when using HVLP. If using airless, apply 1 coat only.
- Unreduced - Forever Seal can be applied using a 1.8- 2.0 tip. Use between 35-45 psi at the gun or 5-10 psi at the cap. Forever Seal can also be applied with a short nap urethane grade roller. 1 coat.

Note: When using Tamco® basecoat, catalyze the basecoat 16:1 with HH-57 basecoat hardener. See various Tamco® TDS sheets on each type of paint topcoat.

Drying Times:



1 hour at 75° F to dry or wet sand if needed, but not required.
Recoat: Anytime after 30-45 minutes at 75° F

Tamco® Tips:



- Best Sealer to use over enamels that may wrinkle when using urethane primers and sealers.
- Can be sanded after 1 hour at Best Sealer to use over enamels that may wrinkle when using urethane primers and sealers.
- Can be sanded or denibbed after 1 hour at 75°F.
- Store unused reduced or unreduced Forever Seal in metal cans with lid tightly sealed. No shelf-life issues, but stir very well before reusing.
- Must use Hardener in Tamco® basecoats when using Foreverseal. hours to denib. Or to make smoother finish for less orange peel in final topcoats.
- Do Not Use Fisheye in this product!
- Store unused reduced Foreverseal in metal cans with lid tightly sealed. No shelf-life expiration. Stir & agitate thoroughly before reusing.
- For best results substrates should be 68 Degrees ° F or warmer. Heat up your space
- Mixing 16:1 is roughly 1-2 Capfuls of HH57 per sprable Quart Tamco Basecoat
- Must use HH57 Hardener in Tamco® base coats when using Forever Seal.



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Polishing:



N/A

Equipment Cleaning:

Lacquer Thinner

Cold Shop Conditions:

Do not use below 50°F or above 100°F.

Heat up your space if needed Adequate airflow and ventilation



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TECHNICAL DATA & PHYSICAL PROPERTIES

Colors: Grey, black, white, clear
Sprayable Viscosity: (RTS) 21-26 sec. EZ Zahn #2
Pot Life: N/A
Theoretical Dry Film: 480 ft2 @ 1 Mil Weight Solids (RTS) 53%
Color & Gloss hold out: Excellent Volume Solids (RTS) 41%
Humidity Resistance: Excellent
Weight Per Gallon: 9.50 lbs.
Solvent Resistance: Excellent
Repair ability: Excellent
Flash point: 52 ° F
Florida Exposure: N/A
Package voc: 4.60 # / gal
Chip resistance: Excellent
RTS VOC: 5.0 # / gal

See Safety Data Sheet/Material Safety Data Sheet and Labels for additional safety information and handling instructions.

Important: The contents of this package must be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the public. Products mentioned may be hazardous and should only be used according to direction, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to Tamco Paint Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does Tamco Paint warrant freedom from patent infringement in the use of any formula or process set forth herein.

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