

Gramos Training



Agenda

Who are we

Dust Control

Wipes

Protective Coatings

Water Treatment

Paint Strippers

Skincare

Metal Pre-Treatment



TAK

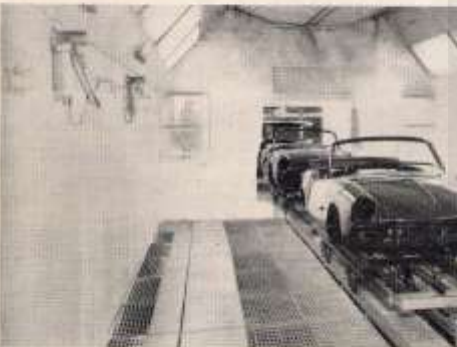
TAK HELPS IN MAINTAINING HIGH

Since using Takdust Peelable Booth Coating, the Standard Triumph motor company is saving approximately £100 every time the paint spray booths at the Tile Hill factory are cleaned.

Various other of our products including Takdust Surface Coating—a water based coating for booth surrounds, and a peelable protective used for guarding miscellaneous metal surfaces against damage and corrosion, are used by Standard Triumph, but at the Tile Hill factory the main emphasis is laid on Takdust Peelable Booth Coating, HT/105, Oven Coating Film and Takrags.

There are five booths altogether at Tile Hill, three of which are protected against paint overspray by heavy white paper, which had to be stripped off and replaced every two, or even three weeks on all booths, with the exception of the primer booth which, owing to a high level of production, still has to be cleaned once a week.

There is no actual saving on cleaning the primer booth, but it was decided to use our peelable coating because its clean white appearance greatly enhances the appearance of the booth, increases visibility and



This shows Triumph Spitfire cars passing through the colour booth. Visibility has been greatly increased by using our peelable booth coating.



the man in charge
Mr. Sandy Judge, maintenance engineer of Standard Triumph's Tile Hill factory.



Litre prices will be implemented
**For smooth spray
—from the gun**



- Eliminate nibs, bl...
- Eliminate rubbing
- Reduce rubbing c...

TAK SUPER TAKRAG 1-27 — P
A FEW PENCE SAVE TIME



TakMATS

**trap dust and prevent contamination
from all foot and trolley traffic**



STEP ON — STEP OFF

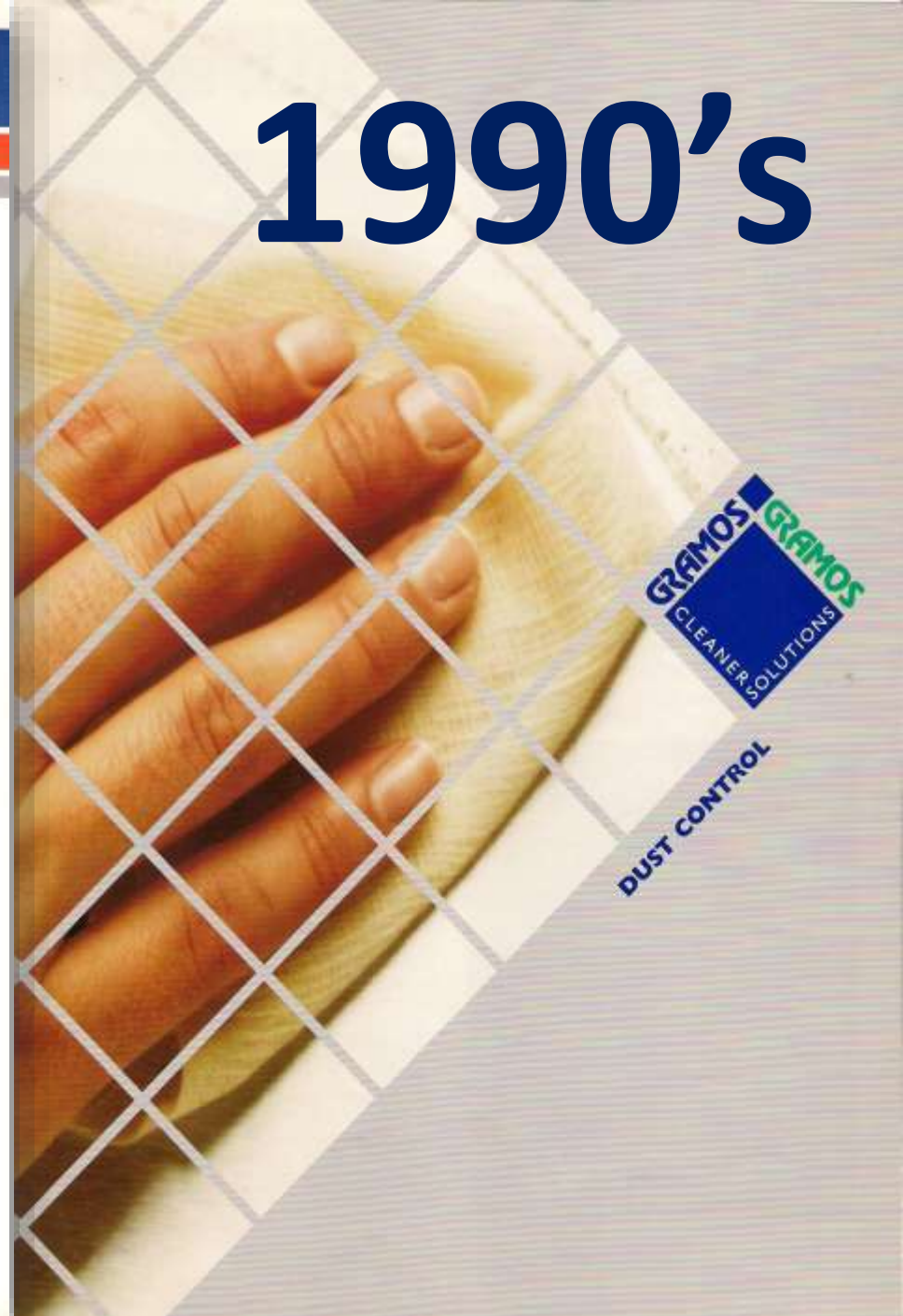
GRAMOS



1980's

Automotive
Refinishing Products

1990's



1990's



ORAPI
GROUP



2007

ORAPI[®]
GROUP



ORAPI[®]
GROUP



Gramos Brands



Dust Control

Protective Coatings

Water Treatment

Kleenall



Degreasing

De-Oxidisers

Phosphating

Corrosion Inhibitors

Paint Removal



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Gramos



Industrial
Cleaning

Hygiene
Chemicals

Food Industry

Janitorial
Chemicals



TRANSNET

Exterior Cleaning

Interior Cleaning
Valeting

Lubricants

Adhesives



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GROUP



Gramos Dust Control



TAK[®] rags

Barrier Curtain

TAK[®] mats

Wipes



Gramos TAK[®] rags? What are they?

Designed over 50 years ago

Resin impregnated “tacky” wipe designed to collect and contain dust from surfaces prior to a secondary finishing process



That process could be -



Vehicle production and refinishing (pre-paint).

Vehicle component production (bumpers, headlamps, fascia's, door handles etc).

Powder paint applications.

Industrial paint ovens (cleaning).



That process could also be

Printing industry.

Furniture manufacture and finishing.

Leather tanning and finishing.

Decontaminations such as:

Asbestos removal

Nuclear Power Industry

Quarantined areas

Clean rooms etc



TAK[®]rags within the paintshop

Dust and Dirt = Painters Worst Enemy

Virtually impossible to keep areas dust and dirt free.

Very Important to attempt to keep surface's dust and dirt free.

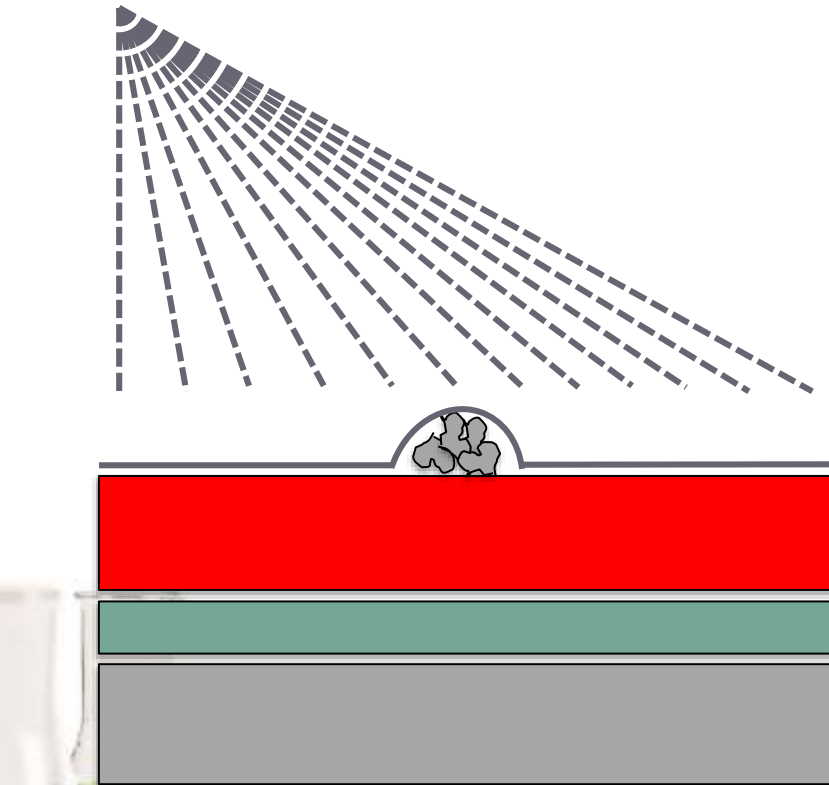
Gramos TAKrags remove and capture surface Contamination.

Reduction of rejects due to **inclusions** in paint.

Reduction of costly rework.



Inclusions – What are they?



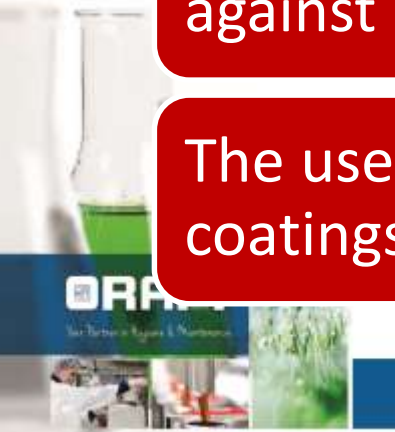
Inclusions

Inclusions are very important to all paintshops

Most will track their effect by a % rate

The lower the rate they can achieve provides a cost saving against reworked product

The use of Gramos TAKrags, TAKmats and protective coatings will drastically reduce their inclusion rate



TAK[®]rag variations

Fabric

Resin Type

TAK Level

Cloth Size



Benefits of Gramos TAK[®]rag

Resin

- Non-Hazardous to operators
- Non-drying
- Non-staining
- Provides uniformity of tack
- Extremely low resin transfer
- Ensure Maximum containment pick-up & holding power

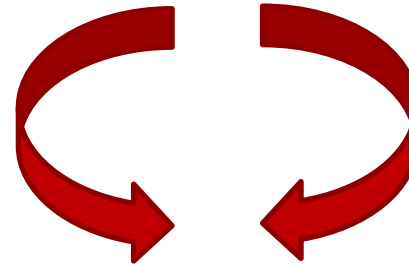
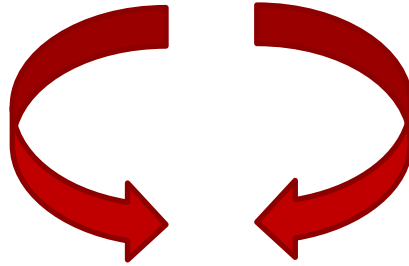
Fabric

- More materials than any other supplier

Production

- Clinical process
- QC traceability
- Low MOQ
- Quick lead time

How to use TAK[®] rags



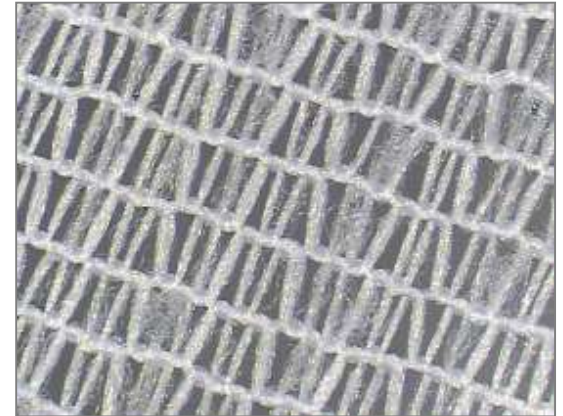
TAK[®]rag Material Types



Woven Cotton



Non-Woven



Continuous Filament
Knitted Polyester



Woven Cotton TAK[®] rags

Traditional

Economical

Open / Close Weave

Natural / Bleached

Soft feel cotton

Highly absorbent cotton fabric



Woven Cotton



Woven Cotton TAK[®] rags

The Original TAK[®] rag

Medium TAK impregnation weight

Removal and containment of high volumes of large particle size contamination i.e. after sanding in the automotive and woodworking industries, large surface area cleaning (aircraft, wind turbine blades etc). Particularly suitable for decontamination cleaning.



D3009 – Bulk Pack / 50

D3019 – Bleached / Wrapped

D3020 – Bleached / Bulk Pack / 50

D3023 – Wrapped / 10 pck

D3023 – Wrapped / 50 pck



Woven Cotton TAK[®] rags

maxaTAK[®]

Medium TAK impregnation weight

A large TAKrag for superior dust holding. Made from textured cotton that provides a soft, high bulk nature. Ideal for large surfaces or high levels of dust



D3002 – Bulk Pack / 50

D3033 – Wrapped 25 pck



Woven Cotton TAK[®] rags

The Original TAK[®] rag

Light TAK impregnation weight

Removal of low volume small particle size contamination commonly found in final finishing operations i.e. Leather finishing, ceramics industry etc.

Use where water based paint systems are employed.



Non Woven TAK[®]rags

Modern style

Spunlace viscose/polyester

Snag resistant for use where rough or sharp edges are encountered.

Effective at lower TAK levels.

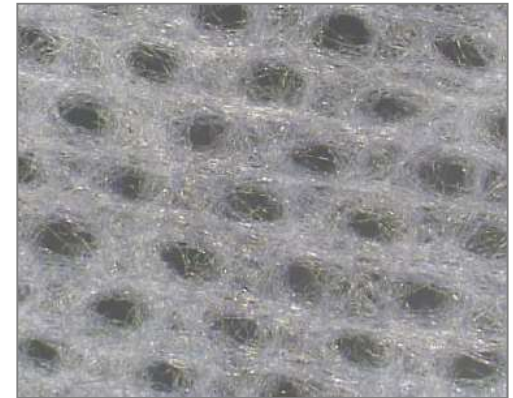
Ideal for use where water based paint systems are employed.

Soft Feel Qualities

Almost zero static electricity build up.

Used extensively in Electronics, Pharmaceutical, Medical Industries & OEM's

Increasingly popular within refinish



Non Woven

Non Woven TAK[®]rags

UltraTAK[®]

Light–Medium TAK Impregnation Weight

An ultra soft, white non-woven fabric which gives a high snag resistant quality. Ideal for uneven surfaces and developed for water based paint systems



D3055 – Dispenser Pack /
Wrapped 50 pck

D3055 – Bulk Pack / 50



Non Woven TAK[®] rags

aquaTAK[®]

Light or Medium TAK Impregnation Weight

An blue, heavy duty non-woven fabric. fabric which gives a high snag resistant quality. Ideal for uneven surfaces and developed for water based paint systems.



D3042 – Medium Bulk Pack / 50

D3042 – Medium / Retail 10 pck

D3032 – Light Bulk Pack / 50



Knitted Polyester TAK[®] rags

Suited for the removal of the finest particle size contamination

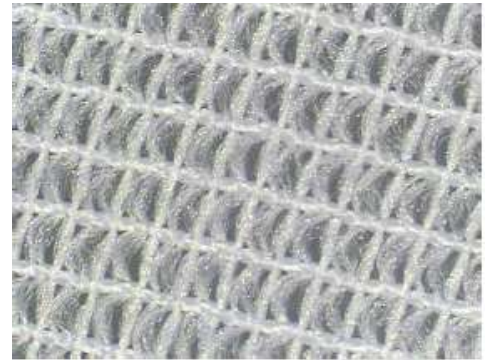
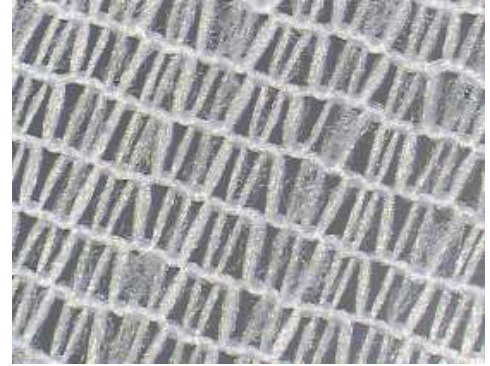
Premium use prior to application of base coat paints and clear coat lacquers

Strong in both planes making them highly tear & snag resistant.

Suitable for applications where sharp edges/corners are encountered.

Product of choice for premium OEM's.

Other applications include the aircraft components industry, high gloss furniture, glass etching and coating etc



Continuous Filament
Knitted Polyester



Knitted Polyester TAK[®] rags

autoTAK[®]

Light TAK Impregnation Weight

Quality medium strength fabric

White, continuous filament, Honeycomb
knitted polyester

Low lint

Only two cut edges



D3035R – Bulk Pack / 50



Knitted Polyester TAK[®] rags

kleenTAK[®]

Medium TAK Impregnation Weight

High quality, high strength fabric

White, continuous filament, box knit polyester

Extremely low lint

No “fibre shed”

Only two cut edges

Zero resin transfer



D3057 – Bulk Pack / 50



Knitted Polyester TAK[®] rags

puraTAK[®]

Medium TAK Impregnation Weight

Specially selected, premium quality, high strength fabric

White, continuous filament, box knit polyester

Extremely low lint

No “fibre shed”

Looped yarn, excellent collect and retain

Heat set “slit” edges

Zero resin transfer



D3047 – Bulk Pack / 50



TAK[®] rags - Summary

What industry? refinish, industrial, woodworking, asbestos

Level of contaminate? light/heavy

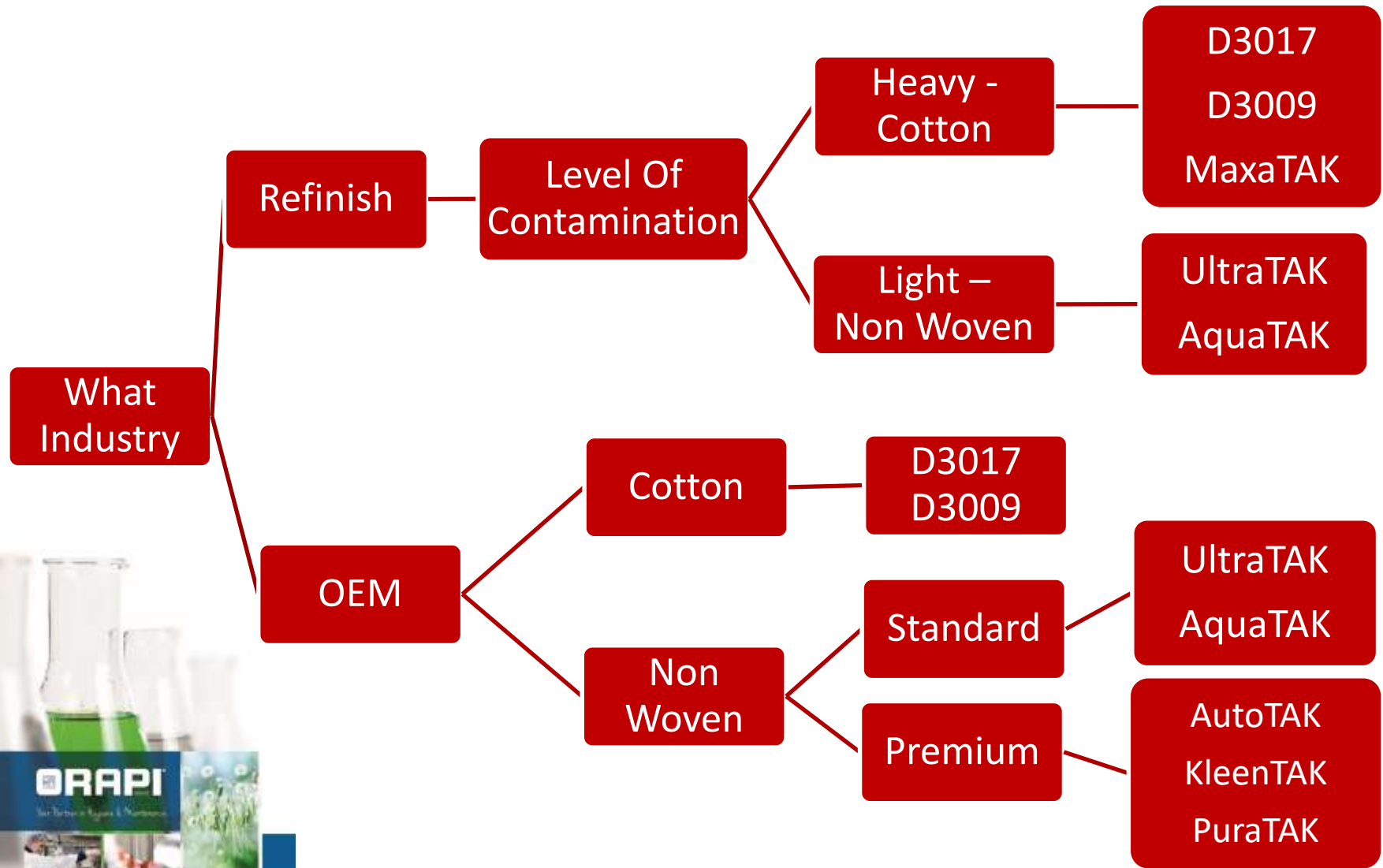
Material quality? cotton gauze, non woven, continuous filament

Size of cloth?

Pack size? individually wrapped or bulk



TAK[®]rags - Summary



Gramos Wipes

Dry Wipes

Robot Covers

Anti Static Wipes

Aqueous Degreasing Wipes

Solvent Degreasing wipes



Dry Wipes

Dry Wipes provide multiple applications. Used as a dry wiper or in conjunction with liquid cleaning agents or solvent cleaners

D3115 Ultraclean Wipe – Ultra soft, white non woven fabric, low lint

D3112 Low Lint Wipe – White, Knitted polyester, honeycomb fabric, very low lint

D3121 Sealant Wipes MF – Non Woven microfibre, very low lint

D3150/5 Kleenknit Tube Wipes – Premium, continuous filament polyester, extremely low lint



Robot Covers



Kleenknit Robot Covers

Premium quality, continuous filament polyester

Tubular design

Lint Free

Heat Sealed Edges

Super absorbent

S9051-1X1 100m Roll x 30"

S9053-1X1 77.5m Roll x 8"



Impregnated Anti-Static Wipes

Wipes impregnated with an anti static enhancer to eliminate static build up on multiple surfaces

D3101 Anti-Static Duster – Orange open weave cotton / 10 pck

D3102 Adclens Anti-Static Duster – Premium, ultra soft knitted fabric with overlocked edges – 10 pck



Impregnated Degreasing Wipes



D3084 DG Wipes – 25 pck

- Aqueous degreasing wipes
- Low lint, non-woven wipes
- Low VOC
- Extremely low residue
- Non-flammable
- Removes dirt, grease & grime



Impregnated Degreasing Wipes



D3086 Microwipe AS – Standard

D3087 Microwipe AS - Light

- Aqueous degreasing wipes
- Lint free, premium microfibres
- Fast evaporating
- Ultra Low VOC
- Extremely low residue
- Non-flammable
- Removes dirt, grease & grime



Impregnated Degreasing Wipes



D4022 Metsolv Wipes 4022 (Medium Impregnation weight)

D4034 Metsolv Wipes 4034 (High Impregnation Weight)

- Solvent degreasing wipes
- Low Lint free, premium microfibre wipes
- Fast evaporating
- Extremely low residue
- Low vapour toxicity
- High purity solvent
- Removes dirt, grease & grime



Impregnated Degreasing Wipes



WSO150 Pronatur Orange Solvent Wipes 25 pck

- Citrus based degreasing wipes
- Low lint, non-woven wipes
- Controlled evaporation for increased contact time
- Superior penetration for difficult to remove contaminants
- Removes Greases, tar, bitumen, semi cured adhesives and sealants



Wipes - Summary

Dry Wipes – Material? Application? Linting?

Static issues? – Anti Static wipes

Wet Wipes – Aqueous or solvent?

Soiling? Light soiling or tenacious deposits?



Barrier Curtain

Air filtering material for internal use

An open woven fabric impregnated with a non drying resin designed to capture and hold airborne contamination

Designed for use in transit areas and transfer tunnels.

Prevents dirt and dust contamination during multi stage painting processes.

Spreads out strong localised air currents over wider areas and at lower velocities, so that the airborne particles are allowed to settle and become trapped in the tacky resin.

Product can be cut to size to suit particular area where airborne contaminants are a problem.



TAK[®]mats

Designed to control foot-borne contamination from leaving or entering protected zones

Applications from industrial to cleanrooms

Placed at entrances to clean areas where there is heavy foot traffic, to prevent contamination from the 'dirty' side to the 'clean' side.

TAKmats remove and contain contamination from the soles of footwear so preventing transfer.



LP TAK[®]mats

- **Low Profile** mat – 2mm thick layers
- Ideal for placing in doorways – allows doors to open and close in situ.
- Multi-layered – 30 thin plastic layers.
- Inbuilt biocide to help prevent transfer of viruses.
- Self adhesive backing sticks mat to the floor to prevent 'slip and trip' hazard.



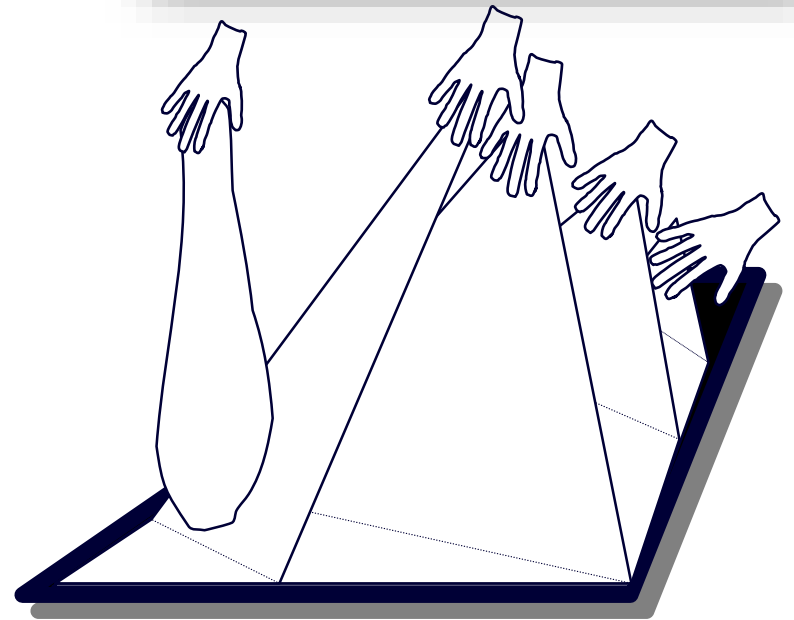
D3306 – LP TAKmat (White)

D3307 – LP TAKmat (Blue)



LP TAK[®]mat Applications

- Clean rooms
- Air showers
- Pharmaceutical and medical applications
- Electronics manufacturer
- Instrumentation
- Laboratories
- Offices
- power stations.



SDA TAK[®]mats

- Super **D**ust **A**bsorbent TAKmats
- Industrial grade product
- 36 layers of resin impregnated close weave cotton fabric with a foam underlay on a ridged base.
- 4 adhesive coated foam pads prevent 'slips and trips'
- When exposed surface is dirty, tear away to top layer of fabric to reveal a fresh, clean tacky surface.



D3303 – SDA 1 (Large – 152cm x 91cm)

D3304 – SDA 2 (Medium – 104cm x 91cm)

D3305 – SDA 2 (small – 61cm x 91cm)



SDA TAK[®]mats

Applications:

- Paint Shops
- Building and Construction
- Shipbuilding and Oil Rigs
- Workshop to Office



Selling TAK[®]mats

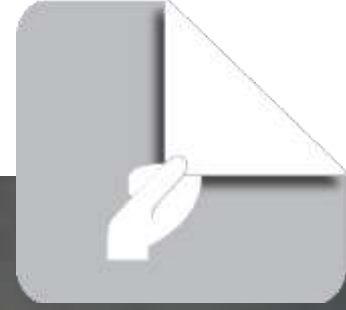
Environment? workshop, cleanroom

Door size?

LP colour



Gramos Protective Coatings



Peelable
Coatings

Tacky Surface
Coatings

Barrier Surface
Coatings

Peelable Coatings- What are they?

- Spray applied liquid plastics
- Cure to a thin, dry, flexible temporary protective coating for paint spray booth walls, floor grates, light cover etc.
- Coating will stay in place and protect surface (generally 2-3 months) from paint overspray.
- Paint overspray sticks to the plastic coating – reducing air borne contamination in the booth.
- Peelable coatings provide a safe and easy removal method of paint overspray, as paint overspray can also be a fire hazard.



Peelable Coatings – How to apply?

- Peelable coatings should be sprayed onto clean, bare metal surfaces , apply 2-3 coats to give dry film thickness of 75-100 microns (μ).
- Test compatibility with painted, coated or plastic surface before application.
- THICKER THE BETTER!
- The coating should be peeled off and replaced during booth maintenance, within 3 months of application when heavily contaminated by overspray.



THICKER THE BETTER!



Peelable Coatings – How to apply?



Spray Pot
Application



Pressure



Airless



Gravity Fed



Brush



Roller

Solvent Based Peelable Coatings



Propeel

- Solvent deposited coatings
- PVC based
- Easy to apply with conventional spray equipment
- Quick drying time (30 mins)
- Should be peeled away and reapplied up to 3 months
- Traditional method
- **Propeel range is not suitable for painted or plastic surfaces**



Solvent Based Peelable Coatings



Propeel

G4602 Propeel - Standard

G4603 Propeel HS – Heat Stable 83°

G4600 Propeel HD- Heavy Duty for floors

G4604 Propeel CL – Semi Clear for lights

G4610 Propeel OP – Component protection



Water Based Peelable Coatings



Aquapeel

- Water bourn peelable coating
- PVA based
- Environmentally Friendly
- Low Odour
- Non-Flammable
- Cheaper per sq. mtr than solvent based
- Solvent free



Water Based Peelable Coatings



Aquapeel

A4605 Aquapeel – Standard

D4608 Aquapeel TS – Clear for lights

A4618 Aquapeel Ultra – Plastic & painted surfaces



Peelable Coatings - Summary

Substrate? walls/floor, steel, plastic coated, painted, glass, low bake

Solvent or aqueous



Barrier Surface Coatings

What are they?

- Semi permanent dry film
- Protection of spray booth walls for when a water wash version is preferred
- Especially advisable where a peelable product is not recommended like booth floor plates
- Apply by spray or roller



Barrier Surface Coatings



A7866 Barrier Film WS – Remove with water

A4505 Barrier Film AS – Heavy duty, remove with an alkaline solution



Barrier Coatings - Summary

Grids/fittings/jigs

Doors

Removal



Tacky Surface Coatings

What are they?

- Water based, non drying “Tacky” coatings
- Airborne dust is attracted to the coating
- Assists in keeping the spray booth free from airborne contamination
- Prevents dust causing defects
- Liquid, gel & paste variations
- Standard, heavy duty & high temp applications



Tacky Surface Coatings

Application

Spray or brush (roller)

Removal

Easily washed off with water

Water resistant versions should be scrapped



Tacky Surface Coatings



A4512 Tacky Surface Coating – Standard liquid

D4500 Barrier Gel – Heavy duty

A4510 Barrier Paste WW – Paste, water wash off

D4501 Barrier Paste WR – Paste, water resistant

D4531 Oven Coat WR HT – High tack, high temperature 180°



Tacky Coatings - Summary

Substrate? walls, robot covers, grids, high temp oven

Clear/white

Water washable

Oven coatslave panels/foil



TAK[®]kill Spray Booth Water Treatments



Denaturants / Detackifiers

Floatation Additives

Anti-foams

Biocides / Booth Cleaners

TAK[®]kill, what are they?

Coatings applied by spray gun generate a large amount of overspray

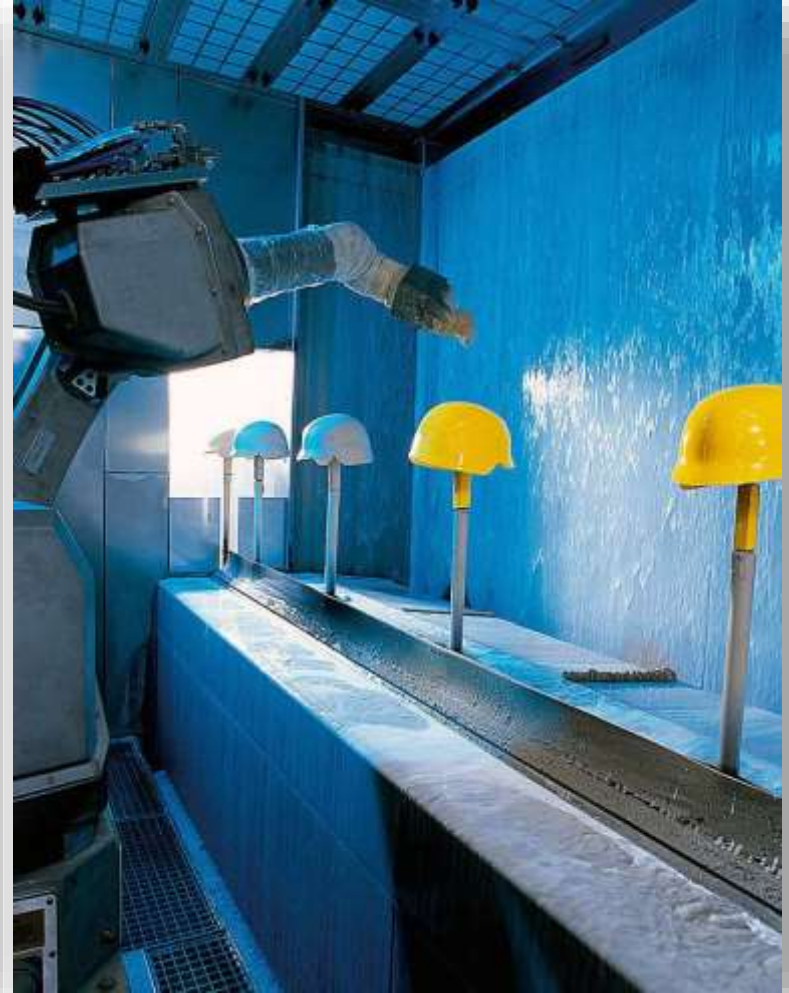
This overspray is collected in the spray booth within a “water wall”

TAK[®]kill Denaturants are added to this water to “de-tackify” the paint

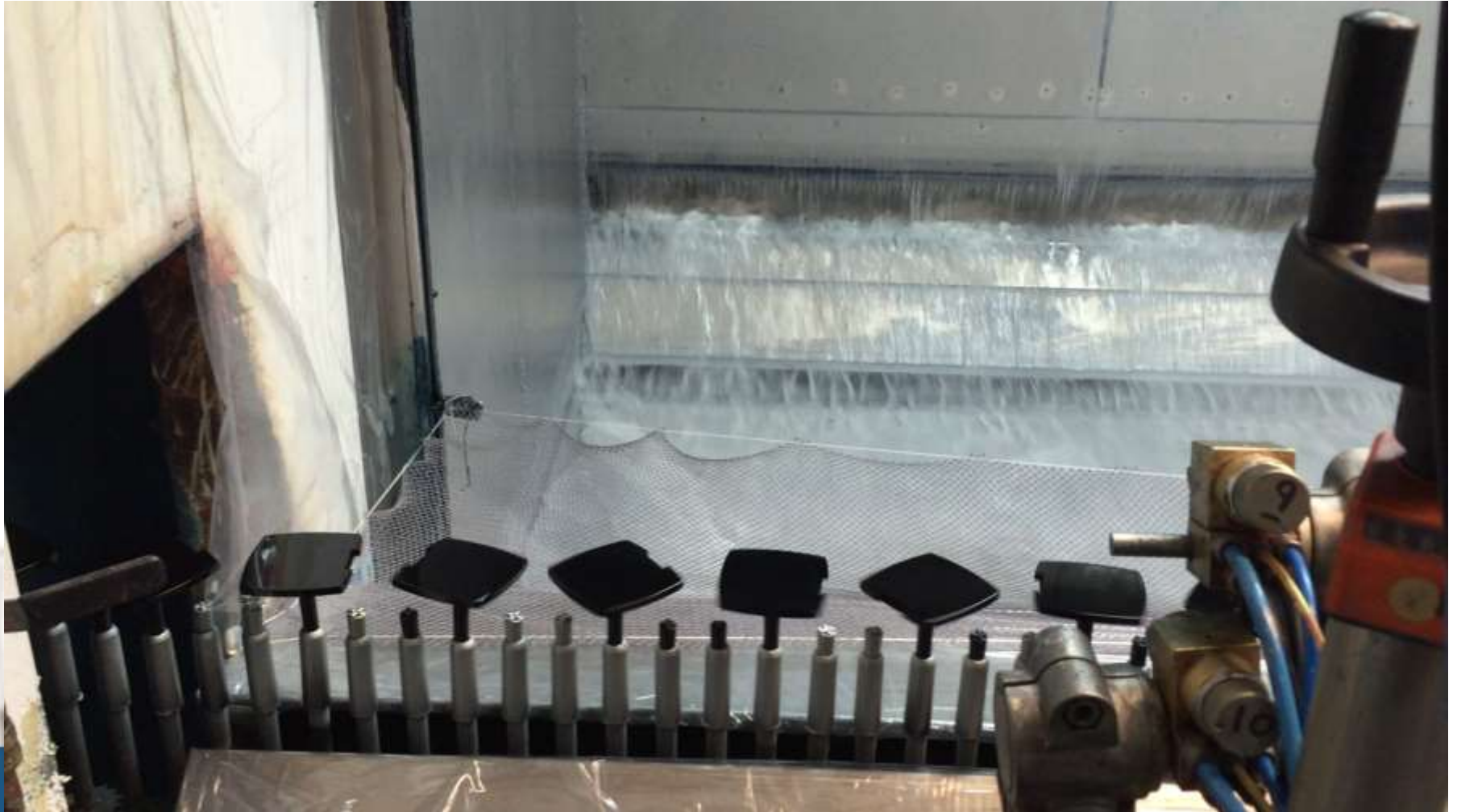
TAK[®]kill Additives are then added to sink or float the treated paint ready for removal



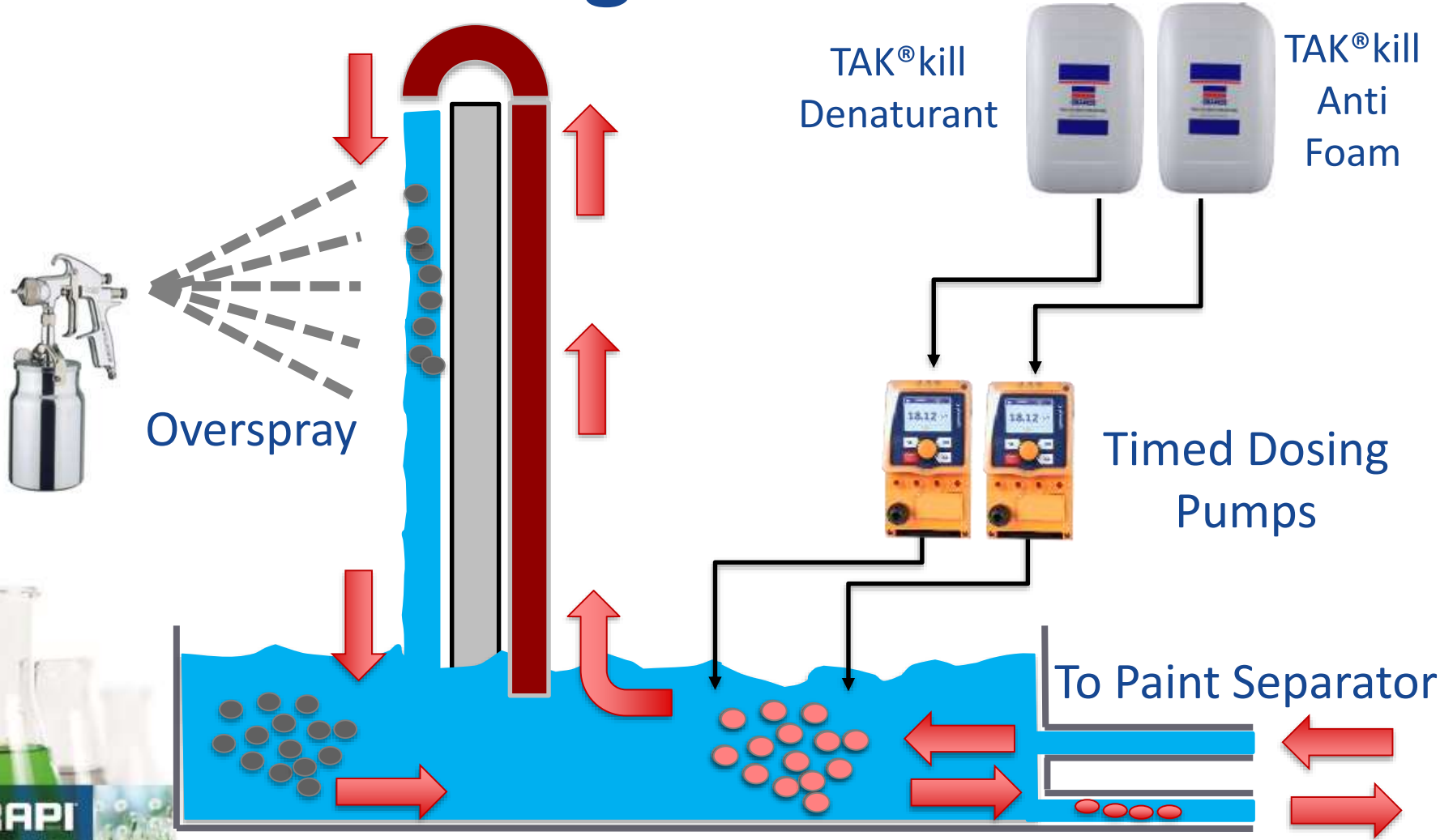
Water Wall Spray Booth



Water Wall Spray Booth



Paint Denaturing



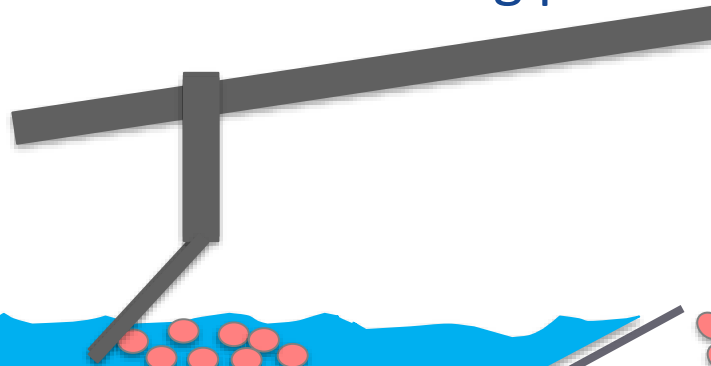
Paint Separation



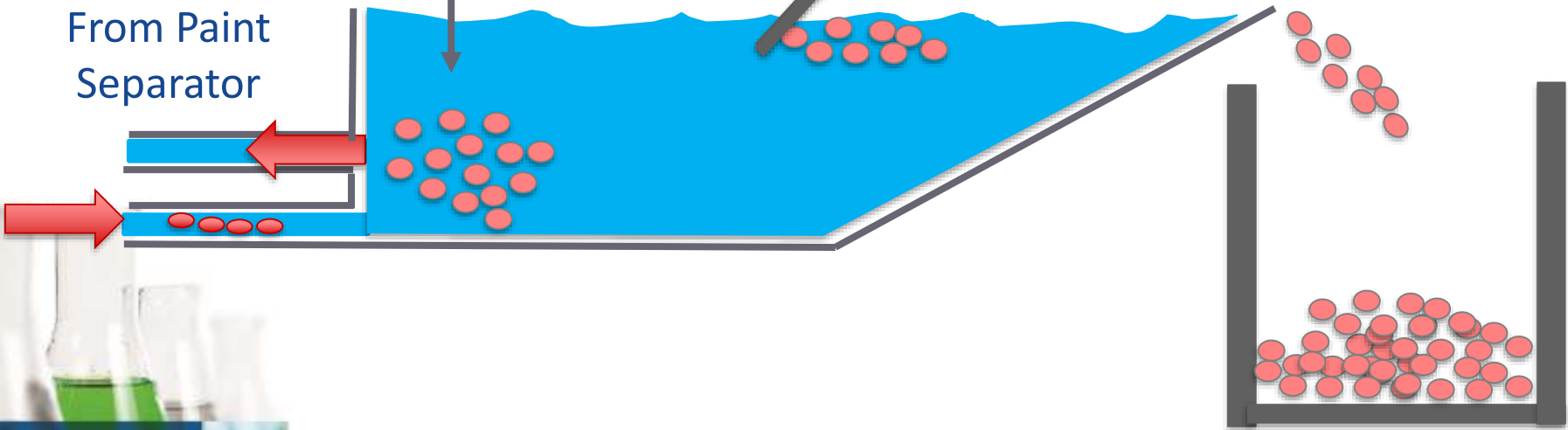
TAK®kill
Additive



Mechanical arm
collects floating paint



From Paint
Separator



Paint Separator



Paint Separator



TAKkill Water Treatments



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TAK[®]kill Water Treatments



TAKkill Paint Denaturants

C4700 TAKkill HS - High Solids Paint

D4704 TAKkill FM - Furniture and door Manufacture

B4711 TAKkill MS - Medium Solids paint

D4712 TAKkill GP - General Purpose

D4714 TAKkill WB - Water Based Paints

TAKkill Paint Floatation Additives

D4702 TAKkill PEL - Polyelectrolyte (red/alkaline) for floatation of solids.

D8805 TAKkill PEL/HS - Polyelectrolyte (blue/acidic – neutral) for floatation of solids.

TAK[®]kill Additives



A5629 TAKkill MA - Maintenance Aid

B8711 TAKkill BC1 - Biocide

D8805 TAKkill AF - Antifoam

**B5820 TAKkill pH Regulator – pH addition
for use with HS**

**F8707 TAKkill ABC - Biocidal Cleaner for
tank clean outs**



TAK[®]kill Water Treatments

Correct use of TAKkill Water Treatments will:

Increase booth efficiency by reducing down time

1. Prevents sticky blockage of pumps and nozzles
2. Removal of overspray / Solids made easier

Help prevent biocide activity

1. Helps prevent smells due to bacteria
2. Health and Safety conformance

Reduce disposal costs

1. Less frequent clean out / sludge disposal



TAK[®]kill Water Treatments

Correct use of TAKkill Water Treatments

1. Initial Dose
2. Daily Maintenance Dose

Why use a daily Dose?

- Initial strength is reduced by paint overspray continually entering the water system.
- Initial Strength is being reduced by fresh water top up to replace losses by evaporation and leaks.



TAK®kill Water Treatments



Spray booth water treatments can be confusing!

1. Identify
2. Confirm
3. Ask for help!
4. Let our technical support win the business for you!



Surface Cleaning



Hard Surface Cleaners

Ink Removers

Sealant Remover

Glass Cleaner

Hard Surface Cleaning

A7237 Multi Purpose Cleaner – Effective, non caustic pine fragranced cleaner. Multi use product for general dirt & grime

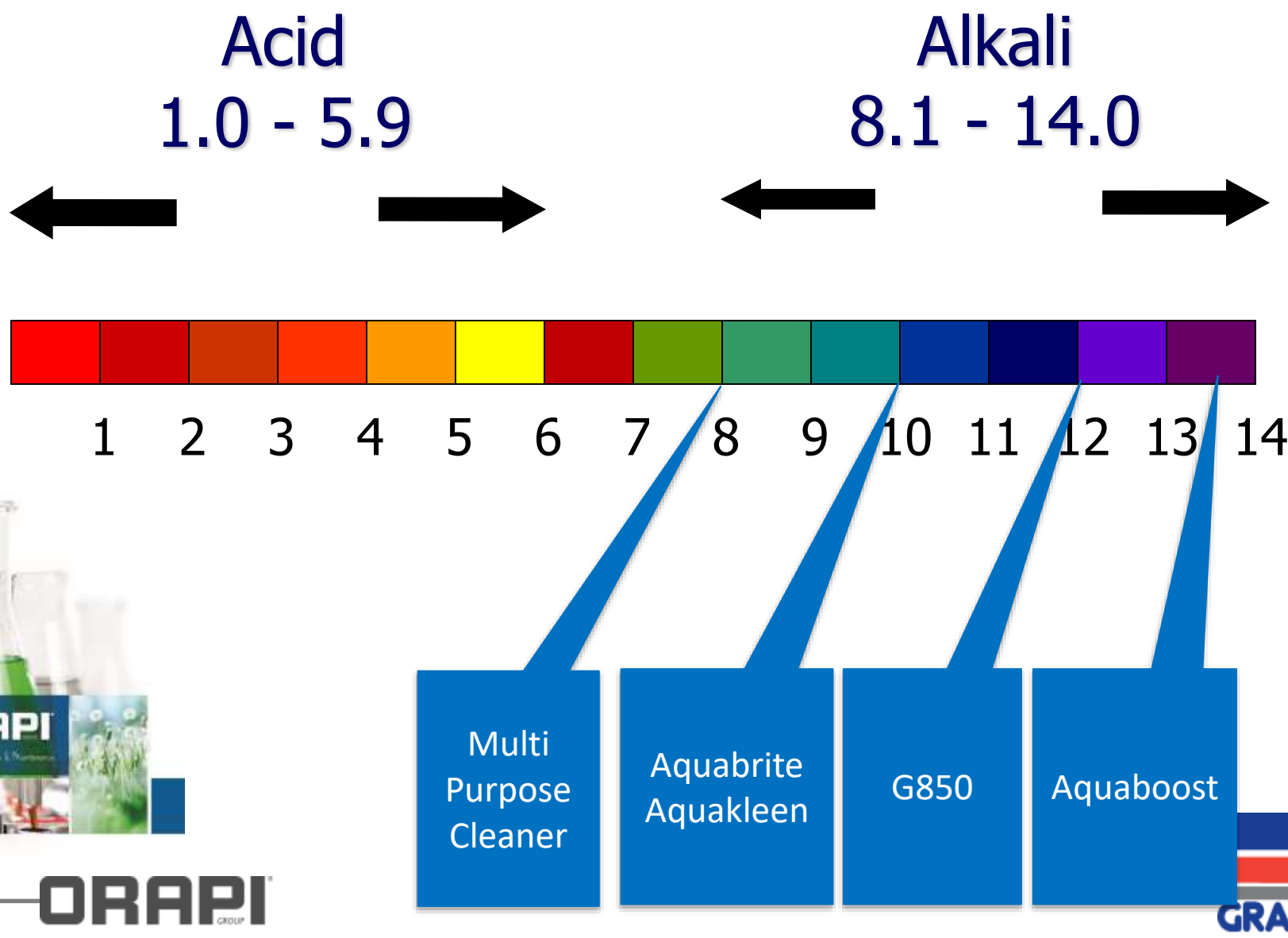
A7212 Aquabrite – Performance mild alkaline cleaner. Maintenance cleaner suitable for removing light paint overspray & silicone

A1220 G850 – Powerful concentrated alkaline cleaner. Rapid removal of grease and grime from surfaces. Ideal problem solver

B7216 Aquaboost – Very powerful, Concentrated alkaline cleaner. Quickly removes most industrial soiling at low concentrations

B7903 Aquaboost Low Foam – Low Foaming, Concentrated alkaline cleaner. Designed for areas where excess foam could cause an issue such as floor scrubbing machines

Product Positioning

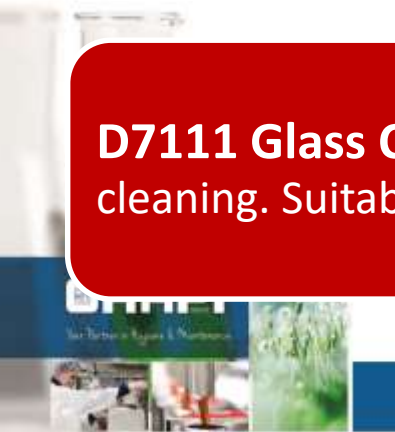


Hard Surface Cleaning

A7211 Aquakleen – Water based ink remover, suitable for use on machine parts, floors etc

E4030 Sealant Remover – Fast evaporating solvent cleaner designed to remove sealant and heavy soiling. Dries to a residue free surface

D7111 Glass Cleaner – Sophisticated blend of solvents and detergents for streak free cleaning. Suitable for glass, stainless steel, chrome, laminates etc



Selling Hard Surface Cleaners

Health & Safety considerations? Caustic or non caustic

How do they want to apply the cleaner? Spray / Wipe, mop / bucket, Floor scrubbing machine?

What is the surface? How will the cleaner effect it?

Cost? Cheap to buy or cheap to use?



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Paint Strippers

Highly effective professional use formulas

High speed, complete removal

Removes most industrial paint finishes, lacquers and varnishes

Brush or immersion

Hot or cold solutions



Paint Strippers

Restrictions on the Marketing and Use of Dichloromethane (Council Directive 76/769/EEC)

“The risks posed to human health by dichloromethane (DCM) in paint strippers have been assessed in several studies which have concluded that risk reduction measures are required throughout the community to reduce the risks posed to human health during the application of DCM at industrial, professional and consumer levels.”



Paint Strippers



F3405 Metstrip SV3405

Clinging gel, brush application, Dichloromethane based with 2% Formic acid activation.

C3452 Metstrip SV3452

Powerful, cold Immersion, Dichloromethane based with 9.7% Formic acid activation

C3453 Metstrip ST3453

Very powerful, cold Immersion, Dichloromethane based with 20% Formic acid

C3456 Metstrip ST3456

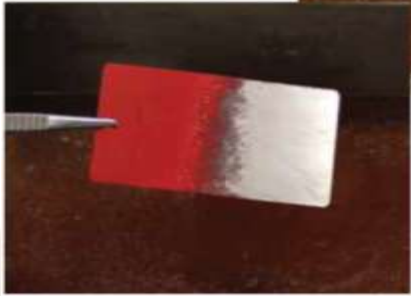
Extremely powerful, cold Immersion, Dichloromethane based with 3% Hydrofluoric acid activation



Paint Strippers



B3461 Metstrip EF3461
Hot Immersion, Benzyl
alcohol based



B3459 Metstrip AK3459
Hot Immersion, Caustic
based



ORAPI
Sanitation, Hygiene & Maintenance

ORAPI
GROUP

GRAMOS

Paint Strippers - Summary

Ensure potential customer is a professional user and aware of H&S when using paint strippers

Brush on or immersion?

Removing what type of paint?

From what type of surface?

Considerations – Dichloromethane or lower hazards?

Establish the information, ask technical for help

Kleenall® Hand Cleaners



- Market leader for the removal of paints, inks & resins
- Specialist formulation with polybeads
- Removes oil, grease & grime
- No harmful solvents
- Citrus fragrance
- Removes ALL PAINTS including 2 Pack



Kleenall® Hand Cleaners

D7030 Kleenall Paste – Original paste

D7076 Kleenall Liquid – Dispenser grade

D7017 Kleenall Beaded – Premium gel

D7029 Kleenall Takleen – Non-beaded

D7018 Kleenall Naturalle – Solvent free



Thank You Questions?

