

DEK STANDARD ENGINEERING INSTRUCTION

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PAINT: "Dek Strong Blue 107"

DSF215

PAINT TYPE

- (1) AE262 Two Pack Acrylic Finish (was AE256)
- (2) J2621 Curing Agent
- (3) Thinner P.T. 1002

PAINT PRIMERS

See DSF 210

TRIMITE REFERENCE

Strong Blue 107 Gloss Level 3

PAINT FINISH

EXTERNAL AREAS

The DEK Standard is for a Spatter Finish on the External Surfaces only of Panels, Hoods, Covers and Frames.

Note : Should a Customer - order specify a Smooth Finish, then a Gloss Level 6 paint must be used.

INTERNAL AREAS

Smooth Finish only.

PAINT SPECIFICATION DETAILS

FEATURES

This high quality two pack finish has been specifically formulated to avoid the use of isocyanates whilst retaining many of the properties of a two pack polyurethane material. The cured film has good chemical, mechanical and durability properties and excellent colour retention, making it ideal for exterior as well as interior use. The finish is available in a full range of glosses, the lower glosses being particularly suited to both smooth or spatter application.

FLASH POINT

Flash point in the range of 21°C - 32°C. Tested to BS 3900 Part A8.

STORAGE

The recommended temperature range for storage is between 10°C - 15°C. It is not considered advisable to store this material outside this temperature range or to exceed a storage period of six months prior to use.

MIXING RATIO

AE262 Two Pack Acrylic Finish must be mixed with Curing Agent J2621 in the ratio of 4 parts of finish to 1 part of curing agent, by volume.

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MIXTURE (POT) LIFE

The mixed material will remain usable for a period of up to 8 hours under normal working conditions (20°C).

COVERAGE

Calculated on a dry film thickness of 25 microns.

CONVENTIONAL SPRAYING

9-10 square metres per litre of mixed material.

The coverage figure shown are approximate and will vary with the type of equipment used and the shape of the component.

PREPARATION

PLASTICS

The substrate must be thoroughly clean and free from mould release agents and static charges. Owing to the sensitivity of many plastics to certain solvents, Anti static Cleaner J131 should be used.

Note : It may be necessary to use a suitable electronic or radioactive source static eliminator immediately prior to painting.

METAL

The substrate must be thoroughly clean and free from contamination, corrosion and grease. Conventional degreasing methods may be employed, but for maximum efficiency, degreasing with Trimite Vapour Degreasing Solvent M6052 (Genklene LV) is recommended.

FILLING

METAL

Deep hole filling may be carried out by knifing Two Pack Polyester Paste Stopper Grey J9004.

FINISHING

APPLICATION

AE262 Two Pack Acrylic Finish may be applied by the following method :-

Conventional Spraying

The mixed material (see Mixing Ratio) will normally be at a suitable viscosity for application. If necessary, Thinner PT1002 may be added up to 10% by volume to give a suitable viscosity at application temperature.

Do not apply heavy coats. If a high build is require, two or more coats should be applied, allowing a short flash-off period between coats.

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Spatter Finish

The following procedure is recommended:-

- (a) Apply the first coat normally and allow to "Flash-Off" for approximately 1 hour.
- (b) Reduce air pressure to between 5-15lbs per square inch.
- (c) Apply spatter coat to pattern desired. This application process is made easier by the use of a pressure pot which permits greater control of the resultant pattern.
- (d) A higher profile may be achieved by using the material unthinned.
- (e) Ensure the Spatter Finish matches the "Paint Sample Chip" supplied.

SUBSTRATE GUIDE	
Thermoplastics	
A.B.S.	Direct Application
A.B.S. Foam	Over Recommended Primer
Acrylic	Over Recommended Primer
Noryl PPO	Over Recommended Primer
Polycarbonate	Over Recommended Primer
Polypropylene	Over Recommended Primer
Polystyrene	Over Recommended Primer
Polystyrene Foam	Over Recommended Primer
PVC Rigid	Direct Application
Thermosets	
GRP Phenolic	Over Recommended Primer
GRP Polyester	Direct Application
Rigid PU Foam	Direct Application
Metals	Over Recommended Primer
Wood / MDF	Over Recommended Primer

DRYING PAINTWORK

PAINT CHARACTERISTICS

While this paint can be Air Dried or Stoved. It is a DEK policy to dry all paintwork, (frame, panels, covers, piece parts etc.), by the Stove Drying Method.

Details of the Air Drying method are noted solely for the purpose of touching-up paintwork in a field application.

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Stove Drying

A "Flash-Off" period of approximately 10 minutes for Semi Gloss Finish, and 30 minutes for Spatter Finish, should be allowed after application and before carrying out the Stove Drying Procedure, to allow the solvents to evaporate and avoid the risk of solvent boil.

Convection Stoving

Metal - 30 minutes at 120°C.

Plastic - To accelerate the drying time, elevated temperatures may be used.

This procedure must be carried out with care to avoid component deformation. The type of plastic, conditions of moulding and post-mould time will influence the maximum temperature.

Air Drying

At an ambient temperature of 20°C, the drying time is approximately as follows :

Surface Dry : 15-20 minutes

Hard Dry : 2-4 hours

Full Properties : 7 days

CAUTION : Do not expose wet panels to direct sunlight, (for air drying / flash off), in order to avoid an additional risk of "solvent boil".

PACKAGING

The painted / stoved items must be allowed to cool down in the "Air" to ambient temperature. **NOTE:** This is an important feature as it will eliminate any risk of lowering evaporation, thereby causing solvent retention, with an end result of the paintwork not achieving its full properties. This type of situation would give the effect of the spatter particles being soft and if components were placed against each other, they might adhere together.

The painted / stoved items can then be wrapped for protection against dirt / marks / scratches with (eg) bubble wrap.

SAFETY INFORMATION

Before use, refer to :-

1. TRIMITE Good House Keeping Guide
2. TRIMITE Safety Sheet S4 - Section 2
3. TRIMITE Safety Sheet S2 - Section 4
4. TRIMITE Individual Safety Info. Sheets

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