

DEK STANDARD ENGINEERING INSTRUCTION

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PAINT: "DEK White"

DSF231

MANUFACTURER

Trimite

TYPE

"White Alkid Amino W301" Gloss

S60 Stoving Finish

FEATURES

A high quality, general purpose, stoving finish which is reliable and widely used throughout the original equipment and sub-contracting industries.

- Tough, mar-resistant finish.
- Can be applied by a wide range of spraying techniques.
- Melamine reinforced for improved durability.
- Energy savings achievable through lower stoving schedules.
- Effective capacity normally achieved in one coat.

FLASH POINT

Flash point in the range of 21 deg C - 32 deg C. Tested to BS 3900 Part A.8.

COVERAGE

FILM THICKNESS

A wet film thickness of 50 microns (2.0 thou) will result in a dry film thickness of approx. 25 microns (1.0 thou). Calculated on a dry film thickness of 25 microns (1.0 thou).

CONVENTIONAL SPRAYING

6-8 square metres per litre. (65-85 square feet per litre).

ELECTROSTATIC SPRAYING

8-10 square metres per litre

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PREPARATION

Any of the following pre-treatment methods are recommended:

The substrate must be thoroughly clean and free from contaminants, corrosion and grease.

De-rusting

- Manual - Use Deoxidine 125 (Trimite Ref MP0006)
- Dip Use Deoxidine 49 (Trimite Ref MP0301)
- Kephos 353 Paint Preparation

Cleaning

- Manual "T" Degreaser J102
- "T" Cleaner No 1 (Trimite Ref 0504)

Vapour Dip Triklone N (Trimite Ref MP0301)

Notes

1. For aluminium and light alloys, specific cleaners and de-oxidisers may be needed. (See Trimite Condensed Guide)
2. Should a Paint Finisher wish to use an alternative conventional degreasing method, they will need to contact DEK to explain the method and have it approved as being acceptable, prior to quoting for the job

PRE-TREATMENT

MILD STEEL

For optimum results a zinc phosphate pre-treatment is preferred. Iron phosphate pre-treatment may be used for general purpose applications.

In the absence of an aqueous pretreatment, the recommended primers are SAP3 Two pack Self etching Primer or HP20 One pack Pigmented Primer.

ALUMINIUM & LIGHT ALLOYS

The use of the correct primer is essential before finishing and where optimum adhesion is required SAP3 Two Pack. Self Etching Primer should be used.

Where a one pack primer is required HP20 One Pack Pigmented Etching Primer is available but is not considered suitable for extruded aluminium.

PRIMING

MILD STEEL

The recommended primers are SAP3 Two Pack Self Etching Primer or HP20 One Pack Pigmented Etching Primer. For additional primer or primer filler coat is required use SP60 Stoving Primer or SPF60 Stoving Primer Filler.

FILLING

When an additional Primer or Primer Filler coat is required use either SP60 Stoving Primer or SPF60 Stoving Primer Filler. Deep Hole filling may be carried out by knifing A90 Two Pack Polyester Paste Stopper Grey J9004 or GK1 Universal Knifing Stopper.

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FINISHING

APPLICATION

S60 Stoving Finish may be applied by the following methods:

- Conventional Spraying
- Electrostatic Spraying
- Airless Spraying
- Hot Spraying

Conventional Spraying

Thinner ST60 may be added up to 20%, by volume, to obtain a viscosity of 25-45 seconds at application temperature using a BS B4 viscosity cup.

A period of approximately 10 minutes "Flash-Off" should follow the application to allow the solvents to evaporate.

STOVING

The stoving schedule will vary with the size, weight of article and type of equipment used.

The following schedule may be used as a general guide:-

CONVECTION STOVING

30 minutes at 120 deg C.

RADIANT HEAT (INFRA-RED)

The systems outlined in this sheet are suitable for radiant heat curing but due to the many variables, eg. weight, configuration, reflectivity, distance from heat source, a suitable schedule must be determined.

HEALTH & SAFETY: SEE DSH111

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KEPHOS 253 PAINT PREPARATION

A non aqueous pretreatment which simultaneously phosphates and seals steel surfaces.

PROCESS SUMMARY:

STAGE	DESCRIPTION	EQUIPMENT
Pre-Cleaning	1) Heavy rust removal	Grit blasting equipment etc
	2) Grease removal by trichloroethylene, Genklene or Solvent wiping.	Degreasing plant for trichloroethylene or Genklene
	3) Removal of light rust patches if required with Deoxodinel 25 followed by wiping with a damp rag & drying	See Product Data Sheet + Associated Health and Safety Data Sheet.
Phosphating and Sealing	Spray: 1 thin coat Dip: Immersion followed by with-drawal immediately the Kephos has wetted the surface	Paint spray booth* acid resistant containers & pressure pots, Solvent-resistant fluid lines. Stainless Steel tank or for a small tank, some grades of glass fibre, polypropylene, vitreous enamel or chemical lead Heating not required.
Drying	Spray 3-5 mins at room temperature.	Ventilated flash off area.*
	Dip 10-30 mins at room temp. or for example 3 mins at 93 deg C (200 deg F)	Ventilated flash off area or force drying oven
Painting	Paint when required	

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RUST TREATMENT

Deoxidine 125 is an acid cleaner which is applied cold by brush. It is used to derust steel prior to painting and can also be used to etch aluminium.

DEOXIDINE TREATMENT

Mix 1 part of Deoxidine with 2 parts of water in a rubber or polythene bucket and apply the solution generously to the metal surface by brush. The solution should be flowed on rather than brushed out like paint.

Immediately after application brush the surface well to bring the chemicals into direct contact with the metal and speed up the derusting action. Pay particular attention to areas which are heavily rusted or contaminated and make further applications of Deoxidine to these areas if necessary.

Do not allow the Deoxidine to dry on the surface; if it does, dry, soften the resulting sticky film with a fresh application of Deoxidine before rinsing off.

NOTE:

Deoxidine 125 can be used by dip application but it is preferable to use Deoxidine 670 for cold dip and Deoxidine 49 for a hot dip process.

RINSING

Thoroughly rinse the surface with clean cold water, preferably from a hose, and then in hot water, if available, to help dry the work.

FINISHING

Dry and paint as soon as possible. This can be done in an oven by wiping with clean dry cloths or a sponge and leather. Compressed air can be used to remove water from seams and crevices. Check that work is perfectly dry and free from stickiness before painting.

Paint must be applied as soon as possible after drying. Ideally, the Deoxidine cleaning should take place immediately before painting and in any case the work should not be left overnight before finishing.

HANDLING PRECAUTIONS

Deoxidine 125 contains phosphoric acid. When handling the product or operating the process PVC gloves and goggles or a face shield should be worn.

In case of accidental contact with skin or clothing wash immediately with large quantities of water. Get medical attention if skin contamination is extensive or a rash develops.

If the Deoxidine gets into the eyes flush out with large quantities of cool water and OBTAIN MEDICAL ATTENTION.

Deoxidine must be used only in conditions of good ventilation. It must not be allowed to come into contact with galvanised or other zinc surfaces as these will be attacked.

The solvents present are water miscible.

The Flash Point of the product as supplied is 35 deg C and it does not support combustion. It is therefore classed as a non-flammable product.

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