

DEK STANDARD ENGINEERING INSTRUCTION

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PAINT: "Thermoplastic Material Application"

DSF224

PAINT TYPE

Trimite Plastilac AE240 Air Drying Finish

REFERENCE

TRIMITE COLOUR REFERENCE:

White DSF224

FEATURES

A one coat fast drying finish formulated for use in the automotive industry for painting ABS, Noryl, Polycarbonate and similar thermoplastics in solid form as well as suitably primed structural foam versions. Adhesion, abrasion resistance, colour retention and exterior durability are all excellent. Various gloss levels are available to meet individual specifications.

FLASH POINT

Flash Point below 21 deg C. Tested to BS 3900 Part A.8.

Subject to the Petroleum (Consolidation) Act, 1928.

STORAGE

The recommended temperature range for storage is between 10 deg C - 15 deg 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.

COVERAGE

Calculated on a dry film thickness of 25 microns, (1.0 thou).

CONVENTIONAL SPRAYING

9-10 Square metres per litre. (95-110 Square feet per litre).Preparation

The substrate must be thoroughly clean, 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.

PRIMING

A primer is not normally required for solid forms, but to counteract the porosity and surface defects inherent in structural foams, Plastilac APF200 Air Drying Primer Filler should be used.

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FINISHING

APPLICATION

Plastilac AE240 Air Drying Finish may be applied by the following method:

Conventional Spraying

Thinner PT1000 may be added up to equal parts by volume to obtain a viscosity of 16-18 seconds at application temperature using a BS B4 viscosity cup.

Where metallic finishes are used, constant agitation is essential after thinning in order to ensure an even colour is consistently achieved.

AIR DRYING

An ambient temperature of 20 deg C, the drying time is approximately as follows:

Surface Dry	5 - 10 minutes
Hard Dry	30 - 60 minutes
Full Properties	7 Days

FORCE DRYING

Increased temperatures may be used to reduce the drying time.

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.

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