

DEK STANDARD ENGINEERING INSTRUCTION

Title

Page 1 of 9

PAINT: "Dark Grey Suede Anti-static Finish"

DSF299

AN ANTI STATIC SPEC FINISH FOR G.R.P.

PROCESS

- 1 ANTI-STATIC CLEANING J131
- 2 PRIMING, AP210
- 3 EMC SHIELDING, J2904
- 4 PAINT PRIMING, AP79
- 5 SENOTEX TOPCOAT

Issue	02	03	04	05	06	07	08	09
DCR	7135							

DEK STANDARD ENGINEERING INSTRUCTION

Title

Page 2 of 9

PAINT: "Dark Grey Suede Anti-static Finish"

DSF299

1 - ANTI-STATIC CLEANING - J131

Before attempting to apply a finishing system to a plastic substrate, the surface must be thoroughly clean and free from contaminants. Antistatic Cleaner J131 effectively cleans the surface and removes release agents without attacking sensitive plastics. It can also reduce surface static, a magnet for dust which could mar the appearance of the finish.

AVAILABILITY

Full details of the container sizes and prices may be obtained from TRIMITE sales offices.

FLASH POINT

Flash point below 21°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 twelve months prior to use.

APPLICATION

Using a brush or clean cloth. Antistatic Cleaner J131 should be applied liberally to the substrate. it is important to change the cloth regularly to avoid returning contaminants to the surfaces.

Clean gloves should be worn when handling surfaces which have been treated.

SAFETY

This product is not formulated as a skin cleaning material nor should it be used for cleaning clothing or any protective equipment. Do not use on electrical equipment or cables.

Before use, refer to :

1. - TRIMITE Good Housekeeping Guide.
2. - TRIMITE Individual Safety Info. Sheet.

Issue	02	03	04	05	06	07	08	09
DCR	7135							

DEK STANDARD ENGINEERING INSTRUCTION

Title

Page 3 of 9

PAINT: "Dark Grey Suede Anti-static Finish"

DSF299

2 - PRIMING AP210

TWO PACK PRIMER : AP210

Hardener : J2511

Mixing Ratio 20:1

FEATURES

A general purpose, fast drying primer for GRP, Noryl and Polyurethane rigid foam. It is formulated with solvents that will not attack these plastics but this primer should not be used on polystyrene and similarly sensitive plastics. The primer effectively masks surface imperfections and when hard dry exhibits very good flattening characteristics

AVAILABILITY

Full details of the container sizes and prices may be obtained from TRIMITE sales offices.

The following colours are available as standard:

Light Grey 40/AP210

White 90/AP210

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

Plastilac AP210 Two Pack Polyurethane Primer must be mixed with Curing Agent J2511 in the ratio of 20 parts of Primer to 1 part of Curing Agent, by volume.

NOTE : When not in use, the can of Curing Agent must be kept sealed.

Pot Life

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

COVERAGE

Calculated on a dry film thickness of 25 microns.

Conventional Spraying : 8 - 9 Sq. metres per litre, (85 - 95 ft² per Litre)

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

PREPARATION

The smooth surface of the GRP material must be sanded to give a surface roughness of 80 grit/square inch using Dry Production abrasive paper. This is to provide a key for the paint.

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, Antistatic Cleaner J131 should be used.

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

Issue	02	03	04	05	06	07	08	09
DCR	7135							

DEK STANDARD ENGINEERING INSTRUCTION

Title

Page 4 of 9

PAINT: "Dark Grey Suede Anti-static Finish"

DSF299

FINISHING

Primer Application

Plastilac AP210 Two Pack Polyurethane Primer may be applied by the following method.

Conventional Spraying

The blend of the mixed material (see Mixing Ratio) is normally ready for use. If necessary, Thinner PT1002 may be added up to 5% by volume.

Note:- Some mouldings may require two applications of primer to cover surface imperfections. In such cases, the first coat, when Hard Dry should be flatted with 320 or 440 grade of abrasive paper before applying the subsequent coat.

Air Drying

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

Surface Dry	10 - 15 minutes
Hard Dry	4 - 6 hours
Full Properties	7 days

Note: The recommended finish may be applied when the primer is Hard Dry

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 determine the maximum temperature that can be employed.

EQUIPMENT CLEANING

High Flash Gun Cleaning Solvent J113 is suitable for cleaning of all equipment after use.

SAFETY

Before use, refer to :

1. TRIMITE Good Housekeeping Guide.
2. TRIMITE Safety Sheet S2 - Section 1.
3. TRIMITE Safety Sheet S4 - Section 2.
4. TRIMITE P.A. G/30/76.
5. TRIMITE Individual Safety Info. Sheets.

Issue	02	03	04	05	06	07	08	09
DCR	7135							

DEK STANDARD ENGINEERING INSTRUCTION

Title

Page 5 of 9

PAINT: "Dark Grey Suede Anti-static Finish"

DSF299

3 - EMC SHIELDING - J2904

ELECTROMAGNETIC SHIELD J2904

THINNER PT1002 (up to 50% by volume)

FEATURES

Electromagnetic Shield Coating J2904 has been manufactured to meet the strictest control of electrical interference. It is formulated utilising specially prepared metallic nickel to provide electromagnetic compatibility (EMC) on plastic housings for a wide range of electronic equipment. This highly conductive coating when applied correctly provides an effective shielding against radiated electromagnetic interference (EMI) and protection against electrostatic discharge.(ESD)

This product provides a cost effective and efficient way of complying with

The United States Federal Communications Commission (F.C.C) Docket 20780

German Regulations V.D.E 0871 - 0879. (Assoc. of German Electrotechnical Engineers.)

Electromagnetic Shield Coating J2904 air-dries rapidly to a pleasing metallic grey finish. It is suitable for application, without priming, to most plastic substrates used in the manufacture of electronic housings. It is formulated to minimise settlement both in the can and in the supply lines of the spray equipment.

AVAILABILITY

Full details of the container sizes and prices may be obtained from TRIMITE sales offices.

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.

COVERAGE

Calculated on a dry film thickness of 50 microns.

Conventional Spraying

4 - 5 Sq. metres per litre. (45 - 55 ft² per litre)

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

PREPARATION

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, Antistatic Cleaner J131 should be used.

PRIMING

Electromagnetic Shield Coating J2904 is suitable for direct application to thermoplastics. Priming is necessary on the thermoset range of plastics (ie Glass Reinforced Polyesters, Glass Reinforced Phenolics, SMC, DMC & Polyurethane Foam Moulding) and AP210 Two Pack Polyurethane Primer or AP262 Two Pack Acrylic Primer should be used.

Issue	02	03	04	05	06	07	08	09
DCR	7135							

DEK STANDARD ENGINEERING INSTRUCTION

Title

Page 6 of 9

PAINT: "Dark Grey Suede Anti-static Finish"

DSF299

FINISHING

Application

Electromagnetic Shield Coating J2904 may be applied by the following method.

Conventional Spraying

Thinner PT1002 may be added up to 50% by volume to obtain a viscosity of 45 - 50 seconds at application temperature using a BS B4 viscosity cup.

Film Thickness

To achieve the full shielding properties, the coating J2904 should be applied in several passes to achieve a wet film thickness of 100 microns which will result in a dry film thickness of approximately 50 microns.

Overcoating

It is not usual to overcoat Electromagnetic Shield Coating J2904, but this is dependent upon the finishing coat requirement. TRIMITE Product Advisory Department should be consulted for a suitable recommendation.

Air Drying

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

Surface dry : 10 - 15 minutes

Hard dry : 1/2 - 1 hour

Full properties : 24 hours

NOTE : Properly painted parts should attain a conductivity of less than 1 ohm/square inch in one hour.
Maximum conductivity is normally achieved in 12 hours.

Equipment Cleaning

High Flash Gun Cleaning Solvent J113 is suitable for cleaning all equipment after use.

Issue	02	03	04	05	06	07	08	09
DCR	7135							

PAINT: "Dark Grey Suede Anti-static Finish"

DSF299

4 - AP79 ONE PACK POLYESTER PRIMER / SEALER

This product has been specifically formulated as an integral part of the high quality Trimite Machine Tool finishing system for both sheet and cast metal. As a very fast drying primer with good adhesion to ferrous metals, it can reduce processing time. As part of a total system it is resistant to most oils and cutting fluids and protects the substrate from corrosion. The product is widely used as a sealer for the trimite polyesters, fillers and knifing stoppers, and is should always be used prior to the application of A79 air drying acrylic finish.

AVAILABILITY

Full details of the container sizes and prices may be obtained from the sales offices.

The following colours are available:

Light Grey 40/AP79 White 90AP79

FLASH POINT

Flash point below 21°C tested to BS 3900 part A 8.

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.

COVERAGE

Calculated on a dry film thickness of 18 microns (0.7 thou).

Conventional spraying : 5 - 6 square metres per litre (55 - 65 square feet per litre).

The coverage figures shown are approximate and may vary with the type of spraying equipment used and the shape of the component.

PREPARATION

Metal

The substrate must be thoroughly clean and free from contaminants, corrosion and grease. Conventional degreasing methods may be employed but, for maximum efficiency vapour degreasing with Trimite Vapour Degreasing Solvent M6052 (Genklene LV) is recommended. Note : A trial application should be carried out initially to ensure suitability : this is particularly important where AP79 One Pack Polyester / Sealer is to be applied onto existing painted surfaces.

Priming

Application

AP79 One Pack Polyester/Sealer may be applied by the following method :

Conventional Spraying

Thinner M6019 may be added up to 50% by volume, to obtain a viscosity of 20 - 25 seconds at application temperature using a BS B4 Viscosity cup.

Note : Thinner AT79 may be used where the speed of surface drying is not too important.

Film Thickness

A wet film thickness of 80 microns (3.2 thou) will result in a dry film thickness of approximately 18 microns (0.7 thou).

Issue	02	03	04	05	06	07	08	09
DCR	7135							

DEK STANDARD ENGINEERING INSTRUCTION

Title

Page 8 of 9

PAINT: "Dark Grey Suede Anti-static Finish"

DSF299

Stopping

Deep hole stopping may be carried out by "knifing" A90 two pack polyester paste stopper grey J9004, and where necessary followed by an application of A90 Two Pack Polyester Paste Filler Grey J9005. Using a knife, trowel or similar instrument to give a smooth surface.

Filling

Where additional filler coats are required. A90 Two Pack Polyester Spraying Filler should be applied.

NOTE : Flatting of the polyester filler must be carried out prior to SEALING.

Sealing

When Two Pack Polyester Fillers or Knifing Stoppers are used, a coat of AP79 One Pack Polyester Primer / Sealer must be applied prior to the application of A79 Air Drying Acrylic Finish.

Air Drying

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

Surface Dry	under 5 minutes
Hard Dry	under 30 minutes
Full Properties	7 days

Note: Subsequent filler or finishing coats should only be applied when the primer / sealer is Hard Dry.

Equipment Cleaning

Gun Cleaning Solvent J103 is suitable for cleaning all equipment after use.

Safety

Before use refer to Trimite's

1. Good housekeeping guide
2. Safety sheet S4 - Section 2
3. Individual Safety Information Sheets.

Issue	02	03	04	05	06	07	08	09
DCR	7135							

DEK STANDARD ENGINEERING INSTRUCTION

Title

Page 9 of 9

PAINT: "Dark Grey Suede Anti-static Finish"

DSF299

5 - SENOTEX TOPCOAT

SENOTEX Suede Two Pack Top Coat Dark Grey Ref. : 05-0345-440.570.)

SENOTEX Hardener (Ref : 19-0306-501.105) Mixing Ratio 10:1 Paint : Hardener

SENOTEX Thinner (Ref : 00-9777-501.033) (Use as required)

AVAILABILITY

Weilburger

TECHNICAL INFORMATION

Colour	Grey
Gloss	Matt
Supply viscosity	40 +/-3 sec DIN 4/20°C
Weight solids	Approx. 44%
Volume solids	Approx. 39%
SG wet	Approx. 0.98
SG dry	Approx. 1.10
Film thickness wet	170 +/- 10 microns
Film thickness dry	75 +/- 5 microns
Theoretical coverage	Approx. 5 sq. metres per litre at 75 microns pre-mixed.
Shelf life	6 months from date of despatch in the original unopened containers.
Flash Point	Below 21°C

APPLICATION INSTRUCTIONS

Substrate	ABS, PC.
Pre-treatment	Degrease.
Application method	Conventional hand or Automatic Spray. Two pack metering apparatus is recommended.
Recommended coating	One Coat System.
Hardener	19-0306-501.105
Mixing ratio	100 10 18 by weight. Paint Hardner Thinner
Thinner	00-9777-501-033
Application viscosity	20 / DIN 4 / 20°C
Pot life	4 hours.
Flash off	3 - 5 minutes at room temperature.
Curing schedule	30 minutes @ 60°C object temperature. 20 minutes @ 80°C object temperature. For GRP we require the parts to be cured at an oven temperature of 40°C for a period of 50-60 minutes.

Issue	02	03	04	05	06	07	08	09
DCR	7135							