

DEK STANDARD ENGINEERING INSTRUCTION

Title

Page 1 of 5

PAINT: "Dark Grey Suede"

DSF297

PAINT TYPE :

1. SENOTEX SUEDE Two Pack Top Coat Dark Grey
(Development Code Ref. : 05-0345-440.570.)
2. SENOTEX HARDENER
(Ref : 19-0306-501.105)
Mixing Ratio 10:1 Paint : Hardener
3. SENOTEX THINNER
(Ref : 00-9777-501.033)
(Use as required)

PRIMER TYPE

Paint Primers

1. Two Pack Primer : AP210
Hardener : J2511
Mixing Ratio 20:1
2. Primer AP79-

MANUFACTURER

Trimite

REFERENCE

Trimite Reference : R89680 / AE267

PAINT PRIMERS

As defined below.

PAINT SPECIFICATION DETAILS

TWO PACK POLYURETHANE SUEDE FINISH DARK GREY AE267

This Product looks and feels like suede leather and the cured film gives a very tough and mar resistant finish. Using only conventional spray equipment, the finish may be applied to wood and wood-based products, including Medium Density Fibreboard (MDF), metal and many plastic substrates, providing a pleasing non reflective suede appearance which compares very favourably with the natural product.

AVAILABILITY

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

FLASH POINT

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

Issue	01	02	03	04	05	06	07	08
DCR	7135							

DEK STANDARD ENGINEERING INSTRUCTION

Title

Page 2 of 5

PAINT: "Dark Grey Suede"

DSF297

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. (See below for details of the pot life of the material when the two components are mixed together).

NOTE :- When not in use, the can of hardener must be kept sealed.

MIXING RATIO

Two pack polyurethane suede finish Dark Grey AE267 must be mixed with hardener J2511 in the ratio of 4 parts Finish to 1 part Hardener, by volume.

MIXTURE (POT) LIFE:- The mixed material will remain usable for a period of up to 2 hours under normal working conditions (20°C).

COVERAGE

Calculated on a dry film thickness of 37.5 microns.

Conventional Spraying : 9 -10 square metres per litre of mixed material (95 - 110 ft²/litre)

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

PREPARATION

WOOD AND MDF

The substrate must be thoroughly clean, dry and free from foreign matter. Sanding the surface or "denibbing" is recommended where applicable.

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.

PLASTIC

The substrate must be thoroughly clean and free from mould release agents and static charges. The use of Antistatic cleaner J131 is recommended.

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

SEALING

MEDIUM DENSITY FIBREBOARD (MDF)

To avoid any problems of differential drying when coating MDF, the board face should be sealed with MDF barrier coat J135. The edges should be filled with MDF Edge filler J134.

Issue	01	02	03	04	05	06	07	08
DCR	7135							

PAINT: "Dark Grey Suede"

DSF297

PRIMING

Wood and Sealed MDF

The recommended primer is AP79 One pack polyester primer / sealer.

Plastic

The choice of primer will depend on the type of plastic used. AP79 one pack polyester primer / sealer is normally suitable for most applications but in case of doubt Trimite's product advisory department should be consulted.

Mild Steel

The recommended primer is HP20 one pack pigmented etching primer.

FINISHING

APPLICATIONS

Plastilac AE267 Two Pack Polyurethane Suede Finish 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, a small quantity of thinner PT1002 may be added to give a suitable viscosity at the application temperature.

FILM THICKNESS

A wet film thickness of 75 microns will result in a dry film thickness of approximately 37.5 microns.

AIR DRYING

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

Surface Dry :	7 - 8 hours
Hard Dry :	24 hours
Full Properties :	7 days

NOTE: Lower temperatures will significantly increase the drying time.

FORCE DRYING

Plastic and Mild Steel. Following a "flash - off" period of a minimum 10 minutes, temperatures up to 60°C for 30 minutes or 80°C for 20 minutes may be used.

CLEANING

High flash gun cleaning solvent J113 is suitable for cleaning all equipment after use.

Issue	01	02	03	04	05	06	07	08
DCR	7135							

DEK STANDARD ENGINEERING INSTRUCTION

Title

Page 4 of 5

PAINT: "Dark Grey Suede"

DSF297

PRIMER FOR DSF297

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.

Issue	01	02	03	04	05	06	07	08
DCR	7135							

DEK STANDARD ENGINEERING INSTRUCTION

Title

Page 5 of 5

PAINT: "Dark Grey Suede"

DSF297

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).

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: Flattening 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.

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	01	02	03	04	05	06	07	08
DCR	7135							