

DEK STANDARD ENGINEERING INSTRUCTION

Title

Page 1 of 4

PAINT: "Dk Grey Suede Non Anti-static Finish"

DSF2910

PAINT: "DARK GREY SUEDE NON ANTI-STATIC FINISH"

PROCESS

- 1 GRP ONLY ANTI - STATIC CLEANING J131
- 2 METALS ONLY - PAINT PRIMING, AP210
- 3 SENOTEX TOPCOAT

Issue	01	02	03	04	05	06	07	08
DCR	7135							

DEK STANDARD ENGINEERING INSTRUCTION

Title

Page 2 of 4

PAINT: "Dk Grey Suede Non Anti-static Finish"

DSF2910

1 - GRP - ANTI - STATIC CLEANING J131

FEATURES :

Before attempting to apply a finishing system to a plastic substrate, the surface must be thoroughly clean and free from contaminants. Anti - static 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.

(Cleaning with J131 completes surface preparation of GRP, priming is applied to metal surfaces only)

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.

PREPARATION

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

Note "It is the GRP Sub-Contractors Responsibility to prepare the product for painting. The GRP will have been previously thoroughly cleaned using Trimite 'T' degreaser J102, to remove all the wax particles from the mould release agent and the GRP "keyed" (using 80 grit) to at least 95% of the surface area and checked for any pin holes/porosity throughout the GRP's material's significant face and through any filler material that may have been applied. It is essential that the cleaning action of the solvent takes place **before** any "keying", otherwise wax particles from the release agent will move into the gritted surface during keying and subsequent action to degrease after gritting will not remove all the waxed particles from the gritted/keyed face".... extract from DSM342 GRP

APPLICATION

Using a brush or clean cloth. Antistatic Cleaner J131 should be applied liberally to the GRP 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	01	02	03	04	05	06	07	08
DCR	7135							

DEK STANDARD ENGINEERING INSTRUCTION

Title

Page 3 of 4

PAINT: "Dk Grey Suede Non Anti-static Finish"

DSF2910

2 METALS ONLY - PRIMING, AP210

STEEL / ALUMINIUM

1. 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.
2. Apply SENOPUR Primer One Coat Two Pack Black Ref : 03-0377-500.727

Technical Information

Colour :	Black
Gloss :	Matt
Supply viscosity :	50-60 sec DIN 53211/4mm//20°C
Weight solids :	Approx. 44 +/- 2%
Volume solids :	Approx. 33 +/- 2%
SG wet :	Approx. 1.04 g/cm ³
SG dry :	Approx. 1.41 g/cm ³
Film thickness wet :	40-50 microns
Film thickness dry :	20-25 microns
Theoretical coverage :	Approx. 16 sq. metres per litre at 20 microns
Shelf life :	6 months in original sealed containers at room temp.(20-25°C)

Flash Point :

Application Instructions

Substrate :	Steel, Aluminium, Aluminised Steel, Galvanised Steel.
Pre-treatment :	Degrease.
Application method :	Conventional hand or Automatic Spray. .
Recommended coating :	Two Pack polyurethane coatings series system 0345,0340,4205 & 4283.
Hardener :	19-0306-501.105
Mixing ratio :	100 : 5 by weight. (Paint : Hardener) 20 : 1 by volume
Thinner :	00-9951-501-033
Application viscosity :	20 +/- 2 seconds Din 4/20°C
Pot life :	Approx. 4 hours.
Flash off :	3 - 5 minutes at room temperature.
Curing schedule :	30 minutes @ 60°C object temperature. 20 minutes @ 80°C object temperature. 10 minutes @ 120°C object temperature.

3 EMC SHIELDING - SENOTEX TOPCOAT

SENOTEX SUEDE

Issue	01	02	03	04	05	06	07	08
DCR	7135							

DEK STANDARD ENGINEERING INSTRUCTION

Title

Page 4 of 4

PAINT: "Dk Grey Suede Non Anti-static Finish"

DSF2910

SENOTEX HARDENER

SENOTEX THINNER

Availability

Available from : 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:Hardener: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	01	02	03	04	05	06	07	08
DCR	7135							