

DEK STANDARD ENGINEERING INSTRUCTION

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PAINT: "Dek Strong Blue 107"

DSF211

TRIMITE "STRONG BLUE 107"

S86 Low Temperature Acrylic Stoving Finish Coarse Texture.

FEATURES

This stoving finish has an evenly defined coarse texture with a pleasing low sheen. It provides a durable and attractive finish for business machines, computer housings and electronic equipment.

- Epoxy fortified acrylic resin for maximum durability.
- Highly resistant to scuff and wear.
- Low sheen minimises unwanted light reflection.
- Conceals surface imperfections, reducing the number of preparatory costs.
- Uniform texture obtainable even with different sprayers or application equipment.

FLASH POINT

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

COVERAGE

FILM THICKNESS

It is essential to achieve an even wet film thickness of 120 microns, (4.8 thou), which will result in a dry film thickness of approximately 50 microns, (2.0 thou).

CONVENTIONAL SPRAYING

3-4 square metres per litre, (30-45 square feet per litre), approximately only.

ELECTROSTATIC SPRAYING

5-6 square metres per litre. (55-65 square feet per litre) approximately only. A period of approximately 10 minutes "Flash Off" should be allowed after application to allow the solvents to evaporate.

PREPARATION

The substrate must be thoroughly clean and free from contaminants, corrosion and grease. Conventional degreasing methods may be employed but for maximum efficiency vapour greasing with Vapour Degreasing Solvent M6052, (Genklene LV) is recommended.

PRIMING

Mild Steel

The recommended primers are SAP3 Two Pack Self Etching Primer or HP20 One Pack Pigmented Etching 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.

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

FILLING

When an additional Primer or Primer Filler coat is required, use either SP60 Stoving Primer or SPF60 Stoving Primer Filler.

FINISHING

APPLICATION

S86 Low Temperature Acrylic Stoving Finish Coarse Texture may be applied by the following methods:

- Conventional Spraying
- Electrostatic Spraying
- Airless Spraying

NOTE

S86 Low Temperature Acrylic Stoving Finish Coarse Textures is not considered suitable for hot spray application.

CONVENTIONAL SPRAYING

Thinner ST60 may be added up to 5% Volume, to obtain a viscosity of 90-100 seconds at application temperature using a BS B4 viscosity.

STOVING

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

The following schedule may be used as a general guide:

CONVECTION STOVING

30 minutes at 140 deg C. (Where a maximum hardness and durability are required, stoving must be carried out at 150 deg C, but it is important that this temperature is not exceeded).

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

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