

DEK STANDARD ENGINEERING INSTRUCTION

Title

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PAINT: "DEK PRIMER"

DSF 2.1.0

Paint Description:

One Pack Pigmented Etching Primer

Manufacturer:

TRIMITE

Manufacturer product reference:

HP20 – (Mid Grey - 41/HP20)

For the latest information and application details please check with Trimite.

Issue	03	04	05	06	07	08	09	10
DCR	7135	44428	02/06/21					

DESCRIPTION:

An epoxy modified etching primer combining the functions of etching and colour priming in one simple application.

- Excellent adhesion to many metals.
- Good opacity.
- Suitable for many types of electrostatic equipment.
- May be air dried prior to stoving the finish.
- Improves the corrosion and water resistance of the finishing system.

AVAILABILITY:

Call our Sales Hot Line 0121 554 7000 for full details of the container sizes and prices.

The following colours are available as our standard offer:

Black	8/HP20	Light Grey	40/HP20
Red Oxide	85/HP20	Mid Grey	41/HP20
	White	90/HP20	

FLASH POINT:

Flash point in the range of 21°C-32°C. Tested to BS 3900 Part A8.

STORAGE:

Store between 5°C – 35°C for a period not exceeding twelve months before use.

Note: When not in use cans must be kept sealed.

COVERAGE:

Calculated on a **dry film** thickness of 12.5 microns.

Conventional Spraying: 7 - 8 square metres per litre.

Electrostatic Spraying: 9 - 10 square metres per litre.

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

PREPARATION:

Metals: Substrates must be thoroughly cleaned, dry and free from contaminants, corrosion and grease prior to coating. Trimite has a comprehensive range of pre-treatment chemicals for most ferrous and non-ferrous substrates, please contact our Pretreatment Dept for advice on the most suitable processes for your application and product prices.

PRIMING:

Application: HP20 One Pack Pigmented Etching Primer may be applied by the following methods:

Conventional Spraying
Electrostatic Spraying

Note: HP20 One Pack Pigmented Etching Primer is not considered suitable for extruded aluminium.

Conventional Spraying: Thinner CT80 may be added up to 30% by volume, to obtain a viscosity of 20 - 30 seconds at application temperature using a BS B4 viscosity cup.

Electrostatic Spraying: HP20 One Pack Pigmented Etching Primer when used with Thinner ST160 is normally suitable for application with various types of electrostatic spraying equipment. It is recommended that our Technical Service Team be consulted for more detailed information.

Film Thickness: A wet film thickness of 37.5 microns will result in a dry film thickness of approximately 12.5 microns.

Continued/...

AIR DRYING:

When HP20 One Pack Pigmented Etching Primer is to be used in an air drying system the addition of an acid component is recommended.

Mixing Ratio: 2 parts by volume of HP20 One Pack Pigmented Etching Primer to 1 part by volume of Two Pack Self Etching Primer Acid Component SAR2.

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

Surface Dry:	20-30 minutes
Hard Dry:	2-4 hours
Full Properties:	7 days

HP20 One Pack Pigmented Etching Primer must be **Hard Dry** prior to overcoating.

Note: The addition of Two Pack Self Etching Primer Acid Component SAR2 may make the primer unsuitable for electrostatic spraying.

STOVING:

A 'flash-off' period of approximately 10 minutes should be allowed after application, for the solvents to evaporate, before 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: 15 minutes at 120°C.

Radiant Heat (Infra-red): The systems outlined in this sheet are suitable for radiant heat curing but due to the many variables, e.g. weight, configuration, reflectivity, distance from heat source, a suitable schedule must be determined.

Note: It is not essential to stove the priming coat prior to applying the finishing coat providing that the primer has been allowed to dry for at least 30 minutes at 20°C and the complete system is then cured at the recommended stoving schedule. However, for optimum adhesion, stoving the primer prior to applying the finishing coat is strongly recommended.

CLEANING:

Thinner CT80 is suitable for cleaning all equipment after use.

SAFETY:

Before use, refer to our Individual Safety Information Sheets.

WARRANTY:

Information provided in this leaflet is given in good faith but without warranty on the understanding that users satisfy themselves about the product's suitability for their own purpose. Our Technical Service team is available to assist in cases of doubt. Any sale by this Company is strictly subject to our Conditions of Sale.

TRIMITE

GLOBAL COATINGS

SAFETY DATA SHEET

HP20 ONE PACK PIGMENTED ETCHING PRIMER

SECTION 1: Identification of the substance/mixture and of the company/undertaking

1.1. Product identifier

Product name HP20 ONE PACK PIGMENTED ETCHING PRIMER

Product number HP20

Special User Instructions

1.2. Relevant identified uses of the substance or mixture and uses advised against

Identified uses Finish coat.

1.3. Details of the supplier of the safety data sheet

Supplier Trimite Global Coatings
Firwood Paints Ltd. Oakenbottom Road, Bolton, UK, BL2 6DP
+44 (0)1204 - 525231
sales@firwood.co.uk

1.4. Emergency telephone number

Emergency telephone +44 (0) 1895 - 251234 Mon - Thurs: 9.00 - 17.30, Friday: 9.00 - 16.00

SECTION 2: Hazards identification

2.1. Classification of the substance or mixture

Classification (EC 1272/2008)

Physical hazards Flam. Liq. 3 - H226

Health hazards Skin Irrit. 2 - H315 Eye Dam. 1 - H318 STOT SE 3 - H335 STOT RE 2 - H373 Asp. Tox. 1 - H304

Environmental hazards Aquatic Chronic 3 - H412

2.2. Label elements

Hazard pictograms



Signal word Danger

Hazard statements

- H226 Flammable liquid and vapour.
- H315 Causes skin irritation.
- H318 Causes serious eye damage.
- H335 May cause respiratory irritation.
- H373 May cause damage to organs through prolonged or repeated exposure.
- H304 May be fatal if swallowed and enters airways.
- H412 Harmful to aquatic life with long lasting effects.

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Precautionary statements	P261 Avoid breathing vapour/ spray. P271 Use only outdoors or in a well-ventilated area. P280 Wear protective gloves/ protective clothing/ eye protection/ face protection. P304+P340 IF INHALED: Remove person to fresh air and keep comfortable for breathing. P312 Call a POISON CENTRE/doctor if you feel unwell. P403+P233 Store in a well-ventilated place. Keep container tightly closed.
Contains	Xylene isomer mixture (with up to 20 % Ethylbenzene), Butan-1-ol, ethylbenzene
Supplementary precautionary statements	P210 Keep away from heat, hot surfaces, sparks, open flames and other ignition sources. No smoking. P240 Ground and bond container and receiving equipment. P241 Use explosion-proof electrical equipment. P242 Use non-sparking tools. P243 Take action to prevent static discharges. P264 Wash contaminated skin thoroughly after handling. P273 Avoid release to the environment. P301+P310 IF SWALLOWED: Immediately call a POISON CENTER/ doctor. P302+P352 IF ON SKIN: Wash with plenty of water. P303+P361+P353 IF ON SKIN (or hair): Take off immediately all contaminated clothing. Rinse skin with water or shower. P305+P351+P338 IF IN EYES: Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing. P321 Specific treatment (see medical advice on this label). P331 Do NOT induce vomiting. P332+P313 If skin irritation occurs: Get medical advice/ attention. P362+P364 Take off contaminated clothing and wash it before reuse. P370+P378 In case of fire: Use foam, carbon dioxide, dry powder or water fog to extinguish. P403+P235 Store in a well-ventilated place. Keep cool. P405 Store locked up. P501 Dispose of contents/ container in accordance with national regulations.

2.3. Other hazards

SECTION 3: Composition/information on ingredients

3.2. Mixtures

Xylene isomer mixture (with up to 20 % Ethylbenzene)			10-30%
CAS number: 1330-20-7	EC number: 215-535-7	REACH registration number: 01-2119457558-25-XXXX	
Classification			
Flam. Liq. 3 - H226			
Acute Tox. 4 - H312			
Acute Tox. 4 - H332			
Skin Irrit. 2 - H315			
Eye Irrit. 2 - H319			
STOT SE 3 - H335			
STOT RE 2 - H373			
Asp. Tox. 1 - H304			
Aquatic Chronic 3 - H412			

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Butan-1-ol			10-30%
CAS number: 71-36-3 EC number: 200-751-6			
Classification Flam. Liq. 3 - H226 Acute Tox. 4 - H302 Skin Irrit. 2 - H315 Eye Dam. 1 - H318 STOT SE 3 - H335, H336			
1-Methoxy-2-propanol			5-10%
CAS number: 107-98-2 EC number: 203-539-1			
Classification Flam. Liq. 3 - H226 STOT SE 3 - H336			
ethylbenzene			1-5%
CAS number: 100-41-4 EC number: 202-849-4			
Classification Flam. Liq. 2 - H225 Acute Tox. 4 - H332 STOT RE 2 - H373 Asp. Tox. 1 - H304			
Zinc Phosphate			1-5%
CAS number: 7779-90-0 EC number: 231-944-3			
M factor (Acute) = 1 M factor (Chronic) = 1			
			REACH registration number: 01-2119485044-40-XXXX
Classification Aquatic Acute 1 - H400 Aquatic Chronic 1 - H410			
Phosphoric Acid			<1%
CAS number: 7664-38-2 EC number: 231-633-2			
			REACH registration number: 01-2119485924-24-XXXX
Classification Skin Corr. 1B - H314 Eye Dam. 1 - H318			

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n-Butyl Acetate			<1%
CAS number: 123-86-4	EC number: 204-658-1	REACH registration number: 01-2119485493-29-XXXX	
Classification			
Flam. Liq. 3 - H226			
STOT SE 3 - H336			

The full text for all hazard statements is displayed in Section 16.

SECTION 4: First aid measures

4.1. Description of first aid measures

General information	Move affected person to fresh air and keep warm and at rest in a position comfortable for breathing. If in doubt, get medical attention promptly. Never give anything by mouth to an unconscious person.
Inhalation	Remove person to fresh air and keep comfortable for breathing. If breathing stops, provide artificial respiration. Never give anything by mouth to an unconscious person. Get medical attention if symptoms are severe or persist.
Ingestion	Get medical attention immediately. Do not induce vomiting. Keep affected person warm and at rest.
Skin contact	Remove contaminated clothing immediately and wash skin with soap and water.
Eye contact	Remove any contact lenses and open eyelids wide apart. Rinse with water. Continue to rinse for at least 15 minutes. Get medical attention if symptoms are severe or persist after washing.

4.2. Most important symptoms and effects, both acute and delayed

General information	The severity of the symptoms described will vary dependent on the concentration and the length of exposure. Treat symptomatically.
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4.3. Indication of any immediate medical attention and special treatment needed

Notes for the doctor	Treat symptomatically.
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SECTION 5: Firefighting measures

5.1. Extinguishing media

Suitable extinguishing media	Extinguish with alcohol-resistant foam, carbon dioxide, dry powder or water fog.
Unsuitable extinguishing media	Do not use water jet as an extinguisher, as this will spread the fire.

5.2. Special hazards arising from the substance or mixture

Specific hazards	Containers can burst violently or explode when heated, due to excessive pressure build-up.
Hazardous combustion products	Thermal decomposition or combustion products may include the following substances: Carbon dioxide (CO ₂). Carbon monoxide (CO).

5.3. Advice for firefighters

Protective actions during firefighting	Control run-off water by containing and keeping it out of sewers and watercourses.
Special protective equipment for firefighters	Wear positive-pressure self-contained breathing apparatus (SCBA) and appropriate protective clothing. Firefighter's clothing conforming to European standard EN469 (including helmets, protective boots and gloves) will provide a basic level of protection for chemical incidents.

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SECTION 6: Accidental release measures

6.1. Personal precautions, protective equipment and emergency procedures

Personal precautions No smoking, sparks, flames or other sources of ignition near spillage. Keep unnecessary and unprotected personnel away from the spillage. Avoid inhalation of vapours and contact with skin and eyes. Provide adequate ventilation.

6.2. Environmental precautions

Environmental precautions The product is immiscible with water and will sediment in water systems. Avoid release to the environment. Avoid discharge into drains or watercourses or onto the ground.

6.3. Methods and material for containment and cleaning up

Methods for cleaning up Absorb spillage with sand or other inert absorbent.

6.4. Reference to other sections

Reference to other sections For personal protection, see Section 8. See Section 11 for additional information on health hazards.

SECTION 7: Handling and storage

7.1. Precautions for safe handling

Usage precautions Restricted to professional users. Use only in well-ventilated areas. Keep away from heat, hot surfaces, sparks, open flames and other ignition sources. No smoking.

7.2. Conditions for safe storage, including any incompatibilities

Storage precautions Store at temperatures between 5°C and 35°C. Store in tightly-closed, original container in a dry, cool and well-ventilated place. Keep away from heat, hot surfaces, sparks, open flames and other ignition sources. No smoking. Store away from the following materials: Acids. Alkalis. Avoid contact with oxidising agents.

Storage class Flammable liquid storage.

7.3. Specific end use(s)

Specific end use(s) The identified uses for this product are detailed in Section 1.2.

SECTION 8: Exposure controls/Personal protection

8.1. Control parameters

Occupational exposure limits

Xylene isomer mixture (with up to 20 % Ethylbenzene)

Long-term exposure limit (8-hour TWA): WEL 50 ppm 220 mg/m³

Short-term exposure limit (15-minute): WEL 100 ppm 441 mg/m³

Sk

Butan-1-ol

Short-term exposure limit (15-minute): WEL 50 ppm 154 mg/m³

Sk

1-Methoxy-2-propanol

Long-term exposure limit (8-hour TWA): WEL 100 ppm 375 mg/m³

Short-term exposure limit (15-minute): WEL 150 ppm 560 mg/m³

Sk

ethylbenzene

Long-term exposure limit (8-hour TWA): WEL 100 ppm 441 mg/m³

Short-term exposure limit (15-minute): WEL 125 ppm 552 mg/m³

Sk

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Phosphoric Acid

Long-term exposure limit (8-hour TWA): WEL 1 mg/m³

Short-term exposure limit (15-minute): WEL 2 mg/m³

n-Butyl Acetate

Long-term exposure limit (8-hour TWA): WEL 150 ppm 724 mg/m³

Short-term exposure limit (15-minute): WEL 200 ppm 966 mg/m³

WEL = Workplace Exposure Limit.

Sk = Can be absorbed through the skin.

Xylene isomer mixture (with up to 20 % Ethylbenzene) (CAS: 1330-20-7)

DNEL	Workers - Dermal; Long term systemic effects: 180 mg/kg/day
	Workers - Inhalation; Long term systemic effects: 77 mg/m ³
	Consumer - Dermal; Long term systemic effects: 108 mg/m ³
	Consumer - Inhalation; Long term systemic effects: 14.8 mg/m ³

PNEC	- Fresh water; 0.327 mg/l
	- marine water; 0.327 mg/l
	- Intermittent release; 0.327 mg/l
	- STP; 6.58 mg/l
	- Sediment (Freshwater); 12.46 mg/kg
	- Sediment (Marinewater); 12.46 mg/kg
	- Soil; 2.31 mg/kg

Zinc Phosphate (CAS: 7779-90-0)

DNEL	Workers - Inhalation; Long term systemic effects: 5 mg/m ³
	Workers - Dermal; Long term systemic effects: 83 mg/kg/day

PNEC	- Fresh water; 20.6 µg Zn/L
	- marine water; 6.1 µg Zn/L
	- Sediment (Freshwater); 117.8 mg/kg d.w.
	- Sediment (Marinewater); 56.5 mg/kg d.w.
	- Soil; 35.6 mg/kg d.w.
	- STP; 100 µg Zn/L

Phosphoric Acid (CAS: 7664-38-2)

DNEL	Workers - Inhalation; Long term local effects: 2.93 mg/m ³
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8.2. Exposure controls

Protective equipment



Appropriate engineering controls

Provide adequate general and local exhaust ventilation.

Eye/face protection

Wear eye protection.

Hand protection

Wear protective gloves.

Other skin and body protection

Provide eyewash station and safety shower.

Hygiene measures

Wash at the end of each work shift and before eating, smoking and using the toilet.

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Respiratory protection	If ventilation is inadequate, suitable respiratory protection must be worn.
Environmental exposure controls	Keep container tightly sealed when not in use.

SECTION 9: Physical and chemical properties

9.1. Information on basic physical and chemical properties

Appearance	Viscous liquid. Coloured liquid.
Odour	Characteristic. Organic solvents.
Initial boiling point and range	115 - 135°C
Flash point	23-60°C Closed cup.
Upper/lower flammability or explosive limits	Lower flammable/explosive limit: 0.7 %
Relative density	1.0 - 1.2
Solubility(ies)	Immiscible with water.

9.2. Other information

Volatile organic compound	This product contains a maximum VOC content of ~690 g/l.
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SECTION 10: Stability and reactivity

10.1. Reactivity

10.2. Chemical stability

Stability	Stable at normal ambient temperatures and when used as recommended.
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10.3. Possibility of hazardous reactions

10.4. Conditions to avoid

10.5. Incompatible materials

Materials to avoid	Avoid contact with the following materials: Strong acids. Strong alkalis. Strong oxidising agents.
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10.6. Hazardous decomposition products

Hazardous decomposition products	Thermal decomposition or combustion products may include the following substances: Carbon monoxide (CO). Carbon dioxide (CO ₂).
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SECTION 11: Toxicological information

11.1. Information on toxicological effects

Acute toxicity - oral

ATE oral (mg/kg)	4,094.17
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Acute toxicity - dermal

ATE dermal (mg/kg)	8,836.58
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Acute toxicity - inhalation

ATE inhalation (gases ppm)	34,141.35
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SECTION 12: Ecological information

12.1. Toxicity

12.2. Persistence and degradability

12.3. Bioaccumulative potential

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12.4. Mobility in soil

12.5. Results of PBT and vPvB assessment

12.6. Other adverse effects

SECTION 13: Disposal considerations

13.1. Waste treatment methods

General information	Waste, residues, empty containers, discarded work clothes and contaminated cleaning materials should be collected in designated containers, labelled with their contents.
Disposal methods	Absorb in vermiculite, dry sand or earth and place into containers. Dispose of waste to licensed waste disposal site in accordance with the requirements of the local Waste Disposal Authority.
Waste class	Disposal of this product, process solutions, residues and by-products should at all times comply with the requirements of environmental protection and waste disposal legislation and any local authority requirements. Dispose of contents/container in accordance with national regulations. Dispose of contents/container in accordance with local regulations. Dispose of surplus products and those that cannot be recycled via a licensed waste disposal contractor. The classification of this product, when disposed of as waste is 08 01 11 'waste paint or varnish containing organic solvents or other dangerous substances'. If this product is mixed with other wastes, this code may longer apply. If mixed with other materials , the appropriate code should be assigned, for further information contact your local waste authority.

SECTION 14: Transport information

14.1. UN number

UN No. (ADR/RID)	1263
UN No. (IMDG)	1263
UN No. (ICAO)	1263
UN No. (ADN)	1263

14.2. UN proper shipping name

Proper shipping name (ADR/RID)	PAINT (xylene, Butan-1-ol, ethylbenzene)
Proper shipping name (IMDG)	PAINT (xylene, Butan-1-ol, ethylbenzene)
Proper shipping name (ICAO)	PAINT
Proper shipping name (ADN)	PAINT

14.3. Transport hazard class(es)

ADR/RID class	3
ADR/RID classification code	F1
ADR/RID label	3
IMDG class	3
ICAO class/division	3
ADN class	3

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Transport labels



14.4. Packing group

ADR/RID packing group	III
IMDG packing group	III
ICAO packing group	III
ADN packing group	III

14.5. Environmental hazards

Environmentally hazardous substance/marine pollutant
No.

14.6. Special precautions for user

EmS	F-E, S-E
ADR transport category	3
Emergency Action Code	•3Y
Hazard Identification Number (ADR/RID)	30
Tunnel restriction code	(D/E)

14.7. Transport in bulk according to Annex II of MARPOL and the IBC Code

SECTION 15: Regulatory information

15.1. Safety, health and environmental regulations/legislation specific for the substance or mixture

EU legislation	Regulation (EC) No 1272/2008 of the European Parliament and of the Council of 16 December 2008 on classification, labelling and packaging of substances and mixtures (as amended). Regulation (EC) No 1907/2006 of the European Parliament and of the Council of 18 December 2006 concerning the Registration, Evaluation, Authorisation and Restriction of Chemicals (REACH) (as amended).
Guidance	Workplace Exposure Limits EH40.

15.2. Chemical safety assessment

SECTION 16: Other information

Issued by	HS&E Manager.
Revision date	18/07/2018
Revision	3
SDS number	5515
SDS status	Approved.

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Hazard statements in full

H225 Highly flammable liquid and vapour.
H226 Flammable liquid and vapour.
H302 Harmful if swallowed.
H304 May be fatal if swallowed and enters airways.
H312 Harmful in contact with skin.
H314 Causes severe skin burns and eye damage.
H315 Causes skin irritation.
H318 Causes serious eye damage.
H319 Causes serious eye irritation.
H332 Harmful if inhaled.
H335 May cause respiratory irritation.
H336 May cause drowsiness or dizziness.
H373 May cause damage to organs (Hearing organs) through prolonged or repeated exposure.
H373 May cause damage to organs through prolonged or repeated exposure.
H400 Very toxic to aquatic life.
H410
H412 Harmful to aquatic life with long lasting effects.

This information relates only to the specific material designated and may not be valid for such material used in combination with any other materials or in any process. Such information is, to the best of the company's knowledge and belief, accurate and reliable as of the date indicated. However, no warranty, guarantee or representation is made to its accuracy, reliability or completeness. It is the user's responsibility to satisfy himself as to the suitability of such information for his own particular use.