



STANDARD ENGINEERING INSTRUCTION

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Title: Paint – Pale Grey, Powder Coat, Low Bake

DSF 2.7.7

Type: Epoxy-Polyester Low-Cure Texture Powder Coat

Colour: RAL 7035 / M-2971-R

Please see page two for data sheet.

Change
Details

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DCR 27956

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Product Information Sheet

Sheet No. P/P8510 - 1/1

P8510 EPOXY POLYESTER POWDER COATING LOW CURE TEXTURE FINISH

DESCRIPTION: P8510 is an epoxy polyester powder coating with a texture finish for interior use. It has a low temperature curing schedule with good overcuring stability and is suitable for coating products which incorporate heat sensitive materials.

Features

P8000 series performance
Reduced temperature curing
Tough, durable finish

Benefits

Improved quality consistency
Increased cost effectiveness
Good scratch & mar resistance

TYPICAL USES:

Interior Use

Display Equipment
Hand Tools
Office Partitioning

Exterior Use

Not recommended

COLOURS:

1. Custom matching to your standard house colour
2. Standard colours from the following example ranges:
BS381c, BS4800, BS5252F, RAL, and Pantone
3. Trimite house Black (B401) and house White (W301).

GLOSS LEVELS:

The following range is available as our standard offer:

Matt(1)	5% - 15%
Eggshell(3)	25% - 35%
Semi-Gloss(6)	55% - 65%
Full Gloss(9)	Over 85%

(reflectance measured using a 60° angled head).

PACKAGING:

Standard pack size: 10 kilo carton.

AVAILABILITY:

Full details of prices and delivery may be obtained from Trimite Regional Centres.

COVERAGE:

Calculated on a **cured film** thickness of 70 microns assuming 100% utilization.

All colours: 8 - 9 square metres per kilo (85 - 95 square feet per kilo).

PREPARATION:

The substrate must be thoroughly clean, dry and free from contaminants, corrosion and grease. Trimite derusters and cleaners are recommended as follows:

1. **Derusting:**
 - manual - Deoxidine 125 (reference MP0006).
 - dip - Deoxidine 49 (reference MP0054).
2. **Cleaning:**
 - manual - "T" Degreaser J102
 - T Cleaner No 2 (reference MP0113).
 - vapour dip - Triklone N (reference MP0301).

PRETREATMENT:

Guidance on processes is as follows. The use of Alocrom for chromating and Granodine for phosphating is recommended.

Mild Steel:

Interior environment - iron phosphate.
Aggressive interior environment - zinc phosphate.

Aluminium/Light Alloys: All interior environments - chromate conversion

Zinc Substrates: All interior environments - zinc phosphate or chromate conversion

Details of the full range of Pretreatment products are available from all Trimite Regional Centres.

(continued overleaf)

Ferrous and non-ferrous metals: In the absence of chemical pretreatments, SAP3 Two Pack Self Etching Primer may be applied and stoved prior to the powder coating process.

APPLICATION: By conventional Corona Discharge equipment.

FILM THICKNESS: Recommended between 60 - 90 microns.

CURING SCHEDULE: The schedule will depend on the mass of the component and the type of oven used.
The following may be used as a general guide:
Conventional air circulating ovens: **an object temperature of 160°C - 10 minutes.**
Note: Infra-red ovens: our Technical Service Department should be consulted for specific recommendations.

STORAGE: Store in dry conditions at an ambient temperature not exceeding 25°C. All cartons should be sealed immediately after use.

SHELF LIFE: 12 months in unopened cartons stored as above.

SAFETY: Before use refer to our Individual Safety Information Sheet.

SUPPORT SERVICES: **Comprehensive product advisory service** - for additional guidance on substrate preparation and product selection.

On-site demonstrations - for assistance with process design, application procedures and finishing techniques.

Free colour consultancy - and management of approved material stocks for specifiers and subcontractors.