

DEK STANDARD ENGINEERING INSTRUCTION

Page 1 of 3

PAINT: Ruby Red (RAL 3003)

DSF 2.1.7

Manufacturer:
Weilburger Coatings (formerly TRIMITE)

Paint Description:
Plastilac® AE262 Two Pack Acrylic Topcoat

Colour:
Ruby Red (RAL 3003)

Manufacturer Specification:
Gloss: Level 1, unless otherwise stated on the engineering drawing

Finish:
To be applied as a smooth layer, unless stated otherwise on the Engineering Drawing

DEK Specific Preparation Notes:

Steel/Aluminium substrates: to be primed to accordance with DSF 2.1.0
Plastic substrates: Only ESD undercoat to DSF 2.9.32 to be applied to the topcoat.

Issue	01	02	03	04	05	06	07	08
DCR	7135	43617						

PAINT: Ruby Red (RAL 3003)**DSF 2.1.7**

PLASTILAC® AE262 TWO PACK ACRYLIC TOPCOAT

AE262-8

DESCRIPTION:	A Two Pack Acrylic Isocyanate-free finish providing similar properties to Two Pack Polyurethane finishes. The product can be used on suitably prepared and primed substrates, including most plastic substrates, metals and a variety of timbers. Please contact our Technical department for advice on suitable priming schemes. Available in a full range of colours and gloss levels. Finishes produce very durable coatings with excellent long term retention of colour and gloss for both interior and exterior use.
AVAILABILITY:	Call our Sales Hot Line 01895 201444 for full details of the container sizes and prices.
FLASH POINT:	Flash point in the range of 21°C-32°C. Tested to BS 3900 Part A8.
STORAGE:	Store between 5°-25°C for a period not exceeding six months before use. Note: When not in use cans must be kept sealed.
MIXING RATIO:	Plastilac AE262 Two Pack Acrylic Topcoat must be mixed with Curing Agent J2621 in the ratio of 4 parts Topcoat to 1 part Curing Agent, by volume.
MIXTURE (POT) LIFE:	The mixed material will remain usable for a period of up to 8 hours under normal working conditions (20°C).
COVERAGE:	Calculated on a dry film thickness of 25 microns. Conventional Spraying: 9-10 square metres per litre of mixed material.
PREPARATION:	Plastic: The substrate must be thoroughly clean and free from mould release agents and static charges. Owing to the sensitivity of many plastics to certain solvents, Antistatic Cleaner J131 should be used. However, T Wipes No. 3 - MP0305 (Antistatic Quality) are available and may be more convenient. Note: It may be necessary to use a suitable electronic or radioactive source static eliminator immediately prior to painting.
PRIMING:	Plastic: The recommended primer is Plastilac AP262 Two Pack Acrylic Primer or Plastilac AP200 Air Drying Primer. Metal: In the absence of a chemical pretreatment the recommended primer is SAP3 Two Pack Self Etching Primer.
FINISHING:	Application: Plastilac® AE262 Two Pack Acrylic Topcoat may be applied by the following method: Conventional Spraying: High Volume Low Pressure (HVLP). Conventional Spraying: To the blend of mixed material (see MIXING RATIO), approximately 20% by volume of Thinner PT1002 may be added up to obtain a suitable viscosity of between 25 - 35 seconds viscosity BS B4 cup. Adjustments may be made to the viscosity dependant on finish required. Electrostatic Spraying: Plastilac AE262 Two Pack Acrylic Topcoat when used with electrostatic Thinner M6020 is normally suitable for application with various types of electrostatic spraying equipment. It is recommended that our Technical Services Team be consulted for more detailed information.

Issue	01	02	03	04	05	06	07	08
DCR	7135	43617						

PAINT: Ruby Red (RAL 3003)

DSF 2.1.7

Film Thickness: A wet film thickness of 50-60 microns will result in a dry film thickness of approximately 25 microns.

Spatter Finish:

- a) Apply the first coat normally and allow to 'flash-off' for approximately 5 minutes.
- b) Reduce air pressure to between 5-15 pounds per square inch and apply 'spatter' coat to the desired pattern. (This application process is made easier by the use of a pressure pot which permits greater control of the resultant pattern).

Note: A higher profile may be achieved by using the material unthinned.

AIR DRYING:

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

Surface Dry:	10-15 minutes
Hard Dry:	2-4 hours
Full Properties:	7 days

Note 1: Lower temperatures will increase the drying time.

Note 2: Where an additional coat is required, this must be applied within 24 hours or after 90 hours.

FORCE DRYING:

When it is required to accelerate the drying process, a 'flash-off' period of approximately 10 minutes should be allowed for the solvents to evaporate.

Plastic: Force drying must be carried out with care to avoid component deformation. The type of plastic, conditions of moulding and post-mould time will determine the maximum temperature that can be employed. A typical curing schedule would be 2-3 hours at 60°C.

Metal: Temperatures up to 120°C for 20-30 minutes are normally 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.

End of Document

Issue	01	02	03	04	05	06	07	08
DCR	7135	43617						