

DEK STANDARD ENGINEERING INSTRUCTION

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PAINT "DEK OFF WHITE"

DSF206

TYPE

- (1) PAINT SPRAYING EPOXY TWO PACK A98/3
- (2) CURING AGENT J9812
- (3) THINNERS AT98

TRIMITE REFERENCE

R83878/A98/3

PAINT FINISH

EXTERNAL AREAS

THE DEK STANDARD IS FOR SPATTER FINISH ON THE EXTERNAL SURFACES ONLY ON PANELS, HOODS, COVERS AND FRAMES.

INTERNAL AREAS

SMOOTH FINISH ONLY

PAINT PRIMERS

TRIMITE SAP3 TWO PACK SELF ETCHING.

FEATURES

THIS SPECIFICATION RELATES TO A HIGH QUALITY AIR DRYING TWO PACK EPOXY PAINT SCHEME, PROVIDING A DURABLE SYSTEM FOR USE ON COMPONENTS USED IN THE AVIATION AND AVIONICS INDUSTRIES. THE SYSTEM IS NORMALLY APPLIED TO LIGHT ALLOYS WHICH HAVE BEEN SUITABLY CLEANED AND PRETREATED. A CORRECTLY APPLIED SCHEME WILL PRODUCE A TOUGH, ABRASION-RESISTANT SURFACE, CAPABLE OF WITHSTANDING CONTACT WITH SALINE CONDITIONS, AS WELL AS WITH A RANGE OF MINERAL AND SYNTHETIC ESTER LUBRICANTS. ADDITIONALLY, RESISTANCE TO VARIOUS CHEMICALS IS SUPERIOR TO THAT ACHIEVED BY SINGLE PACK AIR DRYING MATERIALS.

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STORAGE

THE RECOMMENDED TEMPERATURE RANGE FOR STORAGE IS BETWEEN 10°C - 15°C. IT IS NOT CONSIDERED ADVISABLE TO STORE THESE MATERIALS OUTSIDE THIS TEMPERATURE RANGE OR TO EXCEED A STORAGE PERIOD OF TWELVE MONTHS PRIOR TO USE.

DETAILS OF FLASH POINTS AND OTHER ADVICE PERTINENT TO STORAGE CONDITIONS ARE INDICATED IN SAFETY SECTION (TABLE 3)

PREPERATION

METAL : THE SUBSTRATE MUST BE THOROUGHLY CLEAN, DRY AND FREE FROM CONTAMINANTS, CORROSION AND GREASE.

MIXING RATIO

ALL MATERIALS SHOULD BE AT SHOP TEMPERATURE (15°C-25°C) BEFORE MIXING. PRIOR TO USE, ENSURE THAT INDIVIDUAL COMPONENTS ARE OF UNIFORM CONSISTENCY BY MECHANICAL SHAKING OR THOROUGH STIRRING. MIX AS DETAILED IN TABLE 1, ENSURING THAT THE RESULTANT BLEND IS THOROUGHLY STIRRED.

ALL UNUSED BLENDED MATERIALS SHOULD BE DISCARDED AFTER 8 HOURS AT NORMAL PAINT SHOP TEMPERATURES. THE POT LIFE WILL SIGNIFICANTLY DECREASE AT TEMPERATURES ABOVE 25°C.

TABLE 1 - MIXING INSTRUCTIONS

COATING TYPE	BASE COMPONENT	CURING AGENT OR HARDENER	MIXING RATIO BY VOLUME	THINNER	VISCOSITY		APPROX POT LIFE
					BS:B4	BS:B3	
					AT SHOP TEMPERATURE SECS	SECS	
Epoxy Primer: BS X 33 A & B							
Yellow	309/AP98	J9804	1:1	AT98	18-20	30-35	8
Finishes: DEF STAN 80-161							
Eggshell	Colour/A98/3	J9812	1:1	AT98	19-22	33-40	8

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APPLICATION

SPATTER FINISH

THE FOLLOWING PROCEDURE IS RECOMMENDED:-

- A) APPLY THE FIRST COAT NORMALLY AND ALLOW TO "FLASH-OFF" FOR APPROXIMATELY ½ HOUR.
- B) REDUCE AIR PRESSURE TO BETWEEN 5-15LBS PER SQUARE INCH.
- C) APPLY SPATTER COAT TO PATTERN DESIRED. THIS APPLICATION PROCESS IS MADE EASIER BY THE USE OF A PRESSURE POT WHICH PERMITS GREATER CONTROL OF THE RESULTANT PATTERN.
- D) A HIGHER PROFILE MAY BE ACHIEVED BY USING THE MATERIAL UNTHINNED.
- E) ENSURE THE SPATTER FINISH MATCHES THE "PAINT SAMPLE CHIP" SUPPLIED.

DRYING PAINTWORK

PAINT CHARACTERISTICS

WHILE THIS PAINT CAN BE AIR DRIED OR STOVED. IT IS A DEK POLICY TO DRY ALL PAINTWORK, (FRAME, PANELS, COVERS, PIECE PARTS ETC.), BY THE STOVE DRYING METHOD.

DETAILS OF THE AIR DRYING METHOD ARE NOTED SOLEY FOR THE PURPOSE OF TOUCHING-UP PAINTWORK IN A FIELD APPLICATION.

STOVE DRYING

A "FLASH-OFF" PERIOD OF A MINIMUM OF 1 HOUR, SHOULD BE ALLOWED AFTER APPLICATION AND BEFORE CARRYING OUT THE STOVE DRYING PROCEDURE, TO ALLOW THE SOLVENTS TO EVAPORATE AND AVOID THE RISK OF SOLVENT BOIL.

CONVECTION STOVING - METAL - 1 HOUR AT 70°C

AIR DRYING

AT AN AMBIENT TEMPERATURE OF 20°C, THE DRYING TIME IS APPROXIMATELY AS FOLLOWS:

SURFACE DRY :	1 HOUR
HARD DRY :	16 HOURS
FULL PROPERTIES:	7 DAYS

CAUTION : DO NOT EXPOSE WET PANELS TO DIRECT SUNLIGHT, (FOR AIR DRYING/FLASH OFF), IN ORDER TO AVOID AN ADDITIONAL RISK OF "SOLVENT BOIL".

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TABLE 2 - APPLICATION

COATING TYPE	DRY FILM WEIGHT GRAMS/M ²	DRY FILM THICKNESS MICRONS	COVERAGE M ² /LITRE	REMARKS	AIR DRYING BEFORE OVERCOATING
EPOXY PRIMER	24-34	12-17	11-15	APPLY OVER A SUITABLE PRETREATED SURFACE	4 HOURS MINIMUM
EGGSHELL FINISH	34-51	17-26	10-16	APPLY ONE OR TWO COATS	16 HOURS MINIMUM BETWEEN COATS

FORCE DRYING

WHEN IT IS REQUIRED TO ACCELERATE THE DRYING PROCESS, TEMPERATURES UP TO 70°C MAY BE USED BUT FINAL FINISHING COATS MUST BE ALLOWED TO DRY AT ROOM TEMPERATURE FOR AT LEAST ONE HOUR PRIOR TO FORCE DRYING.

SAFETY ADVICE

COATING TYPE	PRODUCT DETAILS COMPONENT	INDIVIDUAL COMPONENTS		BLENDS FLASH POINT
		REFERENCE	FLASH POINT	
EPOXY PRIMER	BASE COMPONENT	(309/AP98) or (283/AP98)	BELOW 21°C	BELOW 21°C
	CURING AGENT	J9804	BELOW 21°C	
	THINNER	AT98	21°C - 32°C	
EPOXY EGGSHELL FINISH	BASE COMPONENT	COLOUR/A98/3	21°C - 32°C	21°C - 32°C
	CURING AGENT	J9812	21°C - 32°C	
	THINNER	AT98	21°C - 32°C	

PACKAGING

THE PAINTED / STOVED ITEMS MUST BE ALLOWED TO COOL DOWN IN THE "AIR" TO AMBIENT TEMPERATURE. **NOTE:** THIS IS AN IMPORTANT FEATURE, AS IT WILL ELIMINATE ANY RISK OF LOWERING EVAPORATION, THEREBY CAUSING SOLVENT RETENTION, WITH AN END RESULT OF THE PAINTWORK NOT ACHIEVING ITS FULL PROPERTIES. THIS TYPE OF SITUATION WOULD GIVE THE EFFECT OF THE SPATTER PARTICLES BEING SOFT AND IF COMPONENTS WERE PLACED AGAINST EACH OTHER, THEY MIGHT ADHERE TOGETHER.

THE PAINTED/STOVED ITEMS CAN THEN BE WRAPPED FOR PROTECTION AGAINST DIRT/MARKS/SCRATCHES WITH (EG) BUBBLE WRAP.

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