

TECHNICAL DATA SHEET**T Phos 53****Organic Phosphate for Steel**

Description	A ready to use liquid that gives a phosphate coating on steel, which increases corrosion resistance and the adhesion of paint and powder coatings.
Features	<ul style="list-style-type: none">• A good equivalent when orthodox phosphating is impractical.• A liquid blend of resin and phosphate base, in solvent.• Ready for use by brush, dip, spray, rolling or wiping.• Similar properties to a lightweight zinc phosphate.• A simple process, with no rinsing, heating or effluent.• Prevents rusting before painting – the work can be stored for several weeks before subsequent painting.• Very economical, dry film of only 2 microns required.• Can also be used on aluminium, zinc and brass.
Product Code	MP0007 (also T Phos Tinter Green – MP0031)
SG	0.90 ± 0.1 kg/l at 20°C.
Coverage	The rate of consumption will depend on overspray or draining efficiency. As a guide the following ranges have proved reliable: Spray: 10 – 15 m ² /kilo of T Phos 53 Clear Dip: 15 – 25 m ² /kilo of T Phos 53 Clear
Equipment	<p>Spray: all equipment should be acid and solvent resistant. Work must be sprayed in a properly exhausted spray booth.</p> <p>Dipping: an acid and solvent-resistant tank such as stainless steel is required, with a drain area back to the tank. The area must have good ventilation but not be subject to excessive draughts. High tank sides and a lid will reduce solvent losses.</p> <p>Brushing: small quantities of T Phos 53 Clear may be decanted into an acid resistant plastic beaker for small area work. Uncontaminated surplus product should be returned to the original container after each work period.</p>
Initial Fill	T Phos 53 is ready to use. Green Tinter (MP0031) can be used to assist application and subsequent inspection, as follows: 0.5 kg Green Tinter to 20 kg of T Phos 53.
Application	Work pieces must be clean, dry and rust free. The process sequence is: <ol style="list-style-type: none">1. Degrease if necessary by solvent wiping with: T Cleaner 2 (MP0113); or T Wipes 2 (MP0302); or alkaline cleaner for heavily grease/oiled work.2. Apply T Phos 53 Clear either by:<ol style="list-style-type: none">a. Spray a thin coat of T Phos 53 Clear as suppliedb. Dip at room temperature and immediately drain, jiggling the work to avoid trapping and secondary runs.

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3. Drying

Spray: a thin T Phos 53 Clear coating will normally dry at ambient temperatures sufficiently in 3 - 5 min for subsequent paint and powder application.

Dip: work must be drained at the best angle to avoid secondary runs and until all dripping has ceased. Paint or powder can usually be applied after a further 10 - 30 min depending on the ambient temperature, although force drying for 3 min at 100°C will help in avoiding run marks or drain points.

Flash Point	21° – 32°C.
Shelf Life	For best before date, see label.
Storage	The product should be stored in cool, dry, frost-free conditions, in sealed containers.
Health & Safety	Refer to the product's Safety Data Sheet and safety advice on the product label before use.
Technical Support	For technical support in using this product, please contact: e: birminghamtech@trimite.com , or t: 0121 554 7000.
Date of Issue	June 2021.

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