

TECHNICAL DATA SHEET

Trimagard 15MB**Organic Pigmented Phosphate for Steel**

Description	A ready to use liquid that gives a pigmented or clear phosphate coating on steel, which increases corrosion resistance and the adhesion of paint and powder coatings.
Features	<ul style="list-style-type: none">• A liquid blend of resin and phosphate base, in solvent.• Acts as a self-etch primer.• Gives protection to friction surfaces.• Ready for use by brush, dip or spray.• A simple process, with no rinsing or heating.• Prevents rusting before painting – the work can be stored for several weeks before subsequent painting.• Very economical - a dry film of only 5 microns is required for most purposes.
Complies With	Carries NATO approval numbers as shown below.
Product Code	MP0680 Clear - NATO number 8010-99-958-7848 (for UK sales) or 8030-99-668-5901 (for Export sales outside the UK) MP0681 Green - Nato number 8030-99-337-1703 MP0682 Black - Nato number 8030-99-676-6764 MP0683 Red MP0684 Yellow MP0685 Blue - Nato number 8030-99-571-3989.
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: 8 – 15 m ² /kilo of Trimagard 15MB Dip: 12 – 20 m ² /kilo of Trimagard 15MB
Equipment	Spray: all equipment should be acid and solvent resistant. Work must be sprayed in a properly exhausted spray booth. 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. Brushing: to coat rough surfaces such as castings, small quantities of Trimagard 15MB 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.
Initial Fill	Trimagard 15MB is ready to use.
Application	Normally 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).

TECHNICAL DATA SHEET**Trimagard 15MB****Organic Pigmented Phosphate for Steel**

2. Apply Trimagard 15MB either by:
 - a. **Spray** - a thin coat as supplied. May be thinned by up to 1 part thinner (**MP0450**) to 3 parts Trimagard 15MB.
 - b. **Dip** - at room temperature and drain, jiggling the work to avoid trapping and secondary runs. The bath may be thinned with thinner (**MP0450**).
 - c. **Brush** - if other methods are not possible.

Application Notes:

- (i) Trimagard 15MB must be stirred prior to use.
- (ii) Trimagard 15MB needs a minimum application temperature of 15°C to achieve good phosphating.
- (iii) Steel should be free of rust and scale before applying Trimagard 15MB. T Deruster 4 (**MP0054**) is normally effective as a dip chemical treatment, or use T Wipes 4 (**MP0306**) for an easy manual technique.

Control Points

Bath Temperature:	Ambient (15°C minimum)
Immersion Time:	No dwell time required, avoid air traps
Film Thickness:	3 – 5 µm.

The immersion bath is controlled by measuring the viscosity. Since the bath will lose solvent by evaporation, it may be necessary to add Thinner (**MP0450**) adjust the viscosity. The ready for use material is supplied at a viscosity of 30 – 34 seconds at 23°C, measured using a 4 mm ISO Flow cup.

Drying

A standard coating of Trimagard 15MB will be touch dry in about 15–30 min. Force drying for 20 min at 80°C will accelerate the through hardening of the film. Dipped components should be drained at the best angle to avoid drips and runs, and force drying can help avoid run marks and drain points.

Flash Point

21° – 32°C.

Shelf Life

2 years from date of manufacture when correctly stored.

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.

Trimagard 15MB is a mildly acidic liquid.

Both Trimagard 15MB and Thinner (MP0450) contain VOCs. The contents are:
Trimagard 15MB –900 g/kg; Thinner (MP0450) – 850 g/l.

Technical Support

For technical support in using this product, please contact:
e: birminghamtech@trimite.com, or
t: 0121 554 7000.

Date of Issue

Dec 2021.

Information provided in this leaflet is given in good faith but without warranty or assumed liability, as the conditions of application and use are beyond our control. Data are accurate to the best of our knowledge at the time of issue but may be revised in the light of new knowledge and the user should check that data are current before use. The user must satisfy themselves about the product's suitability for their own purpose and refer to the Safety Data Sheet for this product before use. For industrial use only unless specifically stated otherwise.