

# Trimakote HS4

## High Solids Compliant Primer/Finish

<b>Description</b>	A reduced VOC, fast drying alkyd anticorrosive primer/finish for steel and other metals.
<b>Finish</b>	Eggshell (15 - 25 units) and Semi-gloss (45 – 50 units) (measured with a 60° head).
<b>Features</b>	<ul style="list-style-type: none"> <li>• Designed for use as an anticorrosive primer or primer/finish for steel machinery and equipment, both for new build and maintenance.</li> <li>• Single pack, high solids formulation to minimise solvent use.</li> <li>• Excellent water soak resistance.</li> <li>• Excellent Hot Salt Spray Resistance (ASTM B117) anticorrosive performance results – exceeds 600 hours at 100 µm dft.</li> <li>• Trimakote HS4 is a reduced VOC version of Trimagard HS3 to aid compliance with solvent regulations.</li> </ul>
<b>Complies With</b>	Please consult Trimite.
<b>Product Code</b>	-HS4-
<b>Volume Solids</b>	53% ± 2%.
<b>VOC's</b>	Below 395 g/l.
<b>Colour Range</b>	Nakamura Grey Eggshell (A30485/HS4) and shades to order.

<b>Film Thickness &amp; Coverage</b>	<b>Typical:</b>	<b>Dry</b> 75 µm	<b>Wet*</b> 142 µm	<b>Approx. Coverage*</b> 7 - 8 m <sup>2</sup> /l
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\* The above wet film thickness and approximate coverage rate will vary with colour and application method.

Actual coverage varies considerably with factors including surface porosity, roughness, application methods and conditions.

<b>Drying &amp; Overcoating Times</b> at Typical DFT		<b>10°C</b>	<b>20°C</b>	<b>30°C</b>
	Surface Dry:	2 h	1 h	30 min
	Hard Dry:	4 h	2 h	1 h
	Overcoat Min:	8 h*	4 h*	2 h*
	Overcoat Max:	Indefinite	Indefinite	Indefinite

**Force Drying:** can be force dried at up to 80°C for 30 min, after a flash-off period of 10 min.

\* This product is not normally overcoated. Minimum overcoating times are therefore given for guidance only - please consult Trimite for detailed advice before overcoating.

Drying and overcoating times can be greatly affected by method and conditions of application such as thickness applied, temperature, ventilation etc. Data above are given as a guide.

**TECHNICAL DATA SHEET****Trimakote HS4****High Solids Compliant Primer/Finish**

<b>Surface Preparation</b>	<ul style="list-style-type: none"><li>• All surfaces to be coated should be dry and cleaned as necessary to remove all rust, mill scale, grease and other contamination. Where necessary, remove weld spatter and grind smooth all sharp metal edges and weld seams. Consult Trimite for specific project advice.</li><li>• Abrasive blast clean to standard Sa2½ (ISO 8501-1:2007), with a surface profile of 50-75 microns.</li><li>• For areas where abrasive blast cleaning is not possible or not desirable, the surface should be prepared by hand or mechanical means to standard St2 (ISO 8501-1:2007), with care required to avoid 'polishing' the metal surface (producing too smooth a surface for subsequent paint adhesion). Coating lifetime will be reduced if not blast cleaning.</li></ul>
<b>Mixing</b>	Thoroughly stir the coating before use. A power mixer is highly recommended. A wide-bladed stirrer is essential for adequate mixing if only hand stirring. Stir occasionally during use to maintain a homogenous mix.
<b>Mix Ratio</b>	Not applicable – single pack product.
<b>Application Conditions</b>	Throughout the application and the drying/curing time of coatings: (a) good ventilation is required; (b) do not apply when damp weather conditions are likely; (c) the substrate temperature should be at least 3°C above the Dew Point; and (d) the RH (Relative Humidity) should be below 85%. It is advisable not to apply the product when the ambient temperature falls below 5°C. The paint temperature at the time of application should ideally be 15° - 20°C.
<b>Application Details</b>	<ul style="list-style-type: none"><li>• Designed for application by airless spray or air-assisted airless spray. Use tip size of 15 – 21 thou, and pressure of 2500 – 3000 psi (for air-assisted airless spray) or 3000 – 3300 psi (for airless spray).</li></ul>
<b>Thinner/Cleaner</b>	Firwood 113 Thinner or YAP 12073 Thinner.
<b>SG</b>	1.53 ± 0.15 kg/l.
<b>Flash Point</b>	23° – 60°C.
<b>Shelf Life</b>	Minimum of 1 year from date of receipt when correctly stored in unopened containers.
<b>Storage</b>	The product should be stored in cool, dry, frost-free conditions, in sealed containers. Most paint materials will apply optimally when at 15° - 20°C.
<b>Health &amp; Safety</b>	Refer to the product's Safety Data Sheet and safety advice on the product label before use.
<b>Date of Issue</b>	Jan 2022.

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.