

Trimite Plastilac® AV240

Air Drying Lacquer

Description A fast drying acrylic clear lacquer designed for the plastics industry.

Finish Matt and Gloss versions.

- Features**
- Excellent adhesion to ABS, Noryl®, most polycarbonates and similar thermoplastics (Noryl® is a trade mark of SABIC Innovative Plastics IP B.V.).
 - Suitable for metals and other types of plastic substrate over appropriate priming systems.
 - Good abrasion resistance and exterior durability.
 - Available in Matt and Full Gloss.
 - A pigmented version is available as Trimite Plastilac® AE240.

Complies With Please consult Trimite.

Product Code -/AV240/- .

Volume Solids Varies with gloss level, please consult Trimite.

VOC's Varies with gloss level, please consult Trimite.

Colour Range Clear lacquer.

Film Thickness & Coverage	Typical:		
	<u>Dry</u>	<u>Wet*</u>	<u>Approx. Coverage*</u>
	20 µm	50 µm	9 - 10 m ² /l

* The above wet film thicknesses and approximate coverage rates will vary with colour, gloss level and the degree of thinning. Wet film thicknesses are approximate and are based on the typical degree of thinning recommended under 'Application Details'.

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

Drying & Overcoating Times at Typical DFT	<u>10°C</u>	<u>20°C</u>	<u>30°C</u>
	Surface Dry:	20 min	10 min
Hard Dry:	2 h	1 h	30 min
Overcoat Min:	see below*		

* not normally overcoated, please consult Trimite for advice.

Force Drying: increased temperatures may be used to reduce the drying time. This procedure must be carried out with care to avoid component deformation. The type of plastic, condition of moulding and post-mould time will determine the maximum temperature that can be employed.

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**Trimite Plastilac® AV240****Air Drying Lacquer**

Surface Preparation	<ul style="list-style-type: none">• 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.• It may be necessary to use a suitable static eliminator immediately prior to painting.• Solid Foams: A primer is not normally required for adhesion to solid foams, but to counteract the porosity and surface defects inherent in structural foams, Trimite Plastilac APF200 Air Drying Primer Filler is strongly recommended.
Mixing	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 an homogenous mix.
Mix Ratio	Not applicable – single pack product.
Application Conditions	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.
Application Details	<ul style="list-style-type: none">• Designed for application by conventional spray.• Thinner PT1000 may be added, up to equal parts by volume, to obtain a viscosity of 16 - 18 seconds using a BS B4 viscosity cup.
Thinner/Cleaner	PT1000 Thinner / J103 Gun Cleaner.
SG	0.93 ± 0.15 kg/l.
Flash Point	Below 23°C – LOW FLASH MATERIAL.
Shelf Life	Minimum of 1 year from date of receipt when correctly stored in unopened containers.
Storage	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.
Health & Safety	Refer to the product's Safety Data Sheet and safety advice on the product label before use.
Date of Issue	May 2022.

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