

Trimite Plastilac® AE251

Two Pack Polyurethane Low Gloss/Spatter Finish

Description A two pack polyurethane-acrylic finish, for metals and various plastics.

Finish Matt to Semi-gloss available, for spatter, texture or smooth finishes.

- Features**
- Designed as a spatter or textured finish for use on computer housings, business machines and instrument panels for interior use.
 - Excellent durability, hardness, water and chemical resistance.
 - Used as a finish coat over suitable priming systems, depending on the substrate.

Complies With Please consult Trimite.

Product Code -/AE251/-.

Volume Solids Varies with gloss level and colour, please consult Trimite.

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

Colour Range Wide colour range available.

Film Thickness & Coverage	Typical DFT:	<u>Dry</u> 35 µm	<u>Wet*</u> 60 µm	<u>Approx. Coverage*</u> 7 - 8 m ² /l
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* The above wet film thickness and approximate coverage rate (for conventional spray) 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'.

Note: When applying a spatter coat, allow for a reduction of approximately 50% on the coverage figures shown above.

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:	40 min	20 min	10 min
	Hard Dry:	6 h	3 h	1½ h
	Overcoating:	not normally overcoated		

Force Drying: a 'flash-off' period of approximately 5 min should follow the application to allow the solvents to evaporate.

Plastic: force drying must be carried out with care to avoid component deformation. The type of plastic, conditions of moulding and post-mould time will determine the maximum temperature that can be employed.

Metal: when it is required to accelerate the drying process, temperatures up to 120°C for 20-30 min are normally recommended.

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® AE251****Two Pack Polyurethane Low Gloss/Spatter Finish****Surface Preparation**

- **Plastic:** 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, Trimite Antistatic Cleaner J131 should be used. It may be necessary to use a suitable static eliminator immediately prior to painting.
- **Metals:** all surfaces to be coated should be dry and cleaned as necessary to remove all contamination.
- Apply over a suitable primer. Please consult Trimite for advice.
Plastics: Noryl® and rigid polyurethane foam do not normally require a primer, provided the surface is clean; if extra filling of the surface is necessary, Trimite APF210 Two Pack Polyurethane Primer Filler is recommended. For primers for other plastics, please consult Trimite.
Ferrous Metals: in the absence of an aqueous pretreatment, the recommended primers are Trimite SAP2 Etch Primer, or Trimite AP210 Two Pack Polyurethane Primer.
Aluminium & Light Alloys: in the absence of a conversion coating, the use of Trimite SAP2 Etch Primer is recommended.
(Noryl® is a trade mark of SABIC Innovative Plastics IP B.V.).

Mixing

Mix each component separately, and then thoroughly mix together in the mix ratio stated, using a power mixer. Stir occasionally during use to maintain an homogenous mix.

Pot Life at 20°C

8 hours (do not use after this time, even though material may still look fluid).

Mix Ratio

Base (AE251)	5 volumes
Activator	1 volume (use J2511 activator).

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 10°C. The paint temperature at the time of application should ideally be 15° - 20°C.

Application Details

- Designed for application by conventional spray.
- For conventional spray, add to the mixed material up to 20% by volume of Trimite PT1002 Thinner, to obtain a viscosity of 25-30 seconds using a BS B4 viscosity cup.
- **Spatter Finish:**
 - a) apply the first coat normally and allow to 'flash-off' for approximately 5 min.
 - b) reduce the air pressure to between 5 - 15 psi and apply a 'spatter' coat to the desired pattern. This application process is made easier by the use of a pressure pot which permits greater control of the resultant pattern.
Note: a higher profile may be achieved by using the material unthinned.
- **Contains isocyanates** – the mixed product and the curing agent contain isocyanates (the base does not). Refer to base and curing agent Safety Data Sheets before use.

Thinner/Cleaner

Trimite PT1002 Thinner (as Thinner and Cleaner).

TECHNICAL DATA SHEET**Trimite Plastilac® AE251**
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SG	1.20 ± 0.20 kg/l mixed (varies with colour and gloss level).
Flash Point	23° – 60°C.
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	Jan 2023.

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.