

Trimite Plastilac® AP211A

Two Pack Epoxy Primer – Aerospace Grade

Description	A two pack epoxy primer which has low toxic fume emissions in the event of a fire, for interior components used in the aerospace industry.			
Finish	Matt.			
Features	<ul style="list-style-type: none"> • AP211A is part of a coating system formulated to maintain low toxic fume emissions in the event of a fire. The approved Aerospace Grade topcoat is Trimite Plastilac® AE265A & AB. • Has excellent adhesion to pretreated metals and composites. 			
Complies With	<p>When used with the appropriate finishing scheme, this primer is capable of satisfying the following flammability test requirements for aerospace interior parts to PS ANM 25.853-01 R2:</p> <ul style="list-style-type: none"> • Flammability F1 CS 25.853 (a) amdt 19 App. F Part 1 a & b • Heat Release F7 CS 25.853 (d) amdt 19 App. F Part 4 e & g • Smoke Density F8 CS 25.853 (d) amdt 19 App. F Part 5 a & b • Toxic Gas Emission F10 ABD 0031 Issue G. 			
Product Code	-AP211A- .			
Volume Solids	50% ± 2%.			
VOC's	430 ± 20 g/l.			
Colour Range	Grey.			
Film Thickness & Coverage	Typical:	<u>Dry</u> 40 µm	<u>Wet*</u> 75 µm	<u>Approx. Coverage*</u> 5 - 6 m ² /l
	<p>When painting aerospace components, the dry film thickness for this primer should be 60 microns maximum.</p> <p>* The above wet film thickness and approximate coverage rate (for conventional spray) will vary with colour and the degree of thinning. Wet film thicknesses are approximate and are based on the typical degree of thinning recommended under 'Application Details'.</p> <p>Actual coverage varies considerably with factors including surface porosity, roughness, application methods and conditions.</p>			
Drying & Overcoating Times at Typical DFT	<p>The preferred method for curing in all instances is Force Drying.</p> <p>Composites, Aluminium & Mild Steel: following a flash-off period of 15 min, a typical curing schedule would be 30 min at 70°C. For metals, 10 min at 120°C may be used following flash-off.</p>			

TECHNICAL DATA SHEET**Trimite Plastilac® AP211A****Two Pack Epoxy Primer – Aerospace Grade**

Surface Preparation	<ul style="list-style-type: none">• All surfaces to be coated should be dry and cleaned as necessary to remove all contamination.• Apply over a suitable priming or pretreatment system, such as:<ul style="list-style-type: none">• Composites: the surface should be degreased with Trimite J131 Anti-Static Cleaner. In cases where a degree of porosity exists, Trimite AF208 Paste Pore Filler is recommended to enhance the scheme's appearance. Then prime with Trimite AP211A.• Aluminium: SAP2 Etch Primer (or Surtec 650 pretreatment process), followed by Trimite AP211A.• Mild Steel: SAP2 Etch Primer, followed by Trimite AP211A.• Please consult Trimite for detailed project advice.
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	24 hours (do not use after this time, even though material may still look fluid).
Mix Ratio	Base 4 volumes Activator J4504 1 volume.
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	<ul style="list-style-type: none">• Designed for application by conventional spray/HVLP.• Conventional spray: up to 10% AT146 Thinner may be used in the mixed material, to gain a viscosity of 40 - 50 sec (BS B4 cup).
Thinner/Cleaner	Trimite AT146 Thinner (for thinning and cleaning).
SG	1.60 ± 0.15 kg/l.
Flash Point	23° – 60°C.
Shelf Life	Min. 1 year from date of delivery 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	Oct 2023.

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