

Trimite D22330

Lacquer, Phenol Formaldehyde, Type QX, Stoving, Spraying/Dipping to Specification Def Stan 80-92

Description	<p>The Specification relates to a clear phenolic stoving lacquer, suitable for application by spraying or dipping to metals and capable of producing a hard abrasion resistant coating which will afford good protection against saline contamination. The lacquer is normally specified for coating the inside of ammunition cases and must be 'compatible' with the explosive filling material. It is the responsibility of the subcontractor to ascertain the type of explosives with which the lacquer has to be compatible, and to gain approval from the MOD prior to using these materials.</p>			
Finish	Glossy.			
Complies With	DEF STAN 80-92.			
Product Code	D22330- .			
Volume Solids	Please consult Trimite.			
VOC's	Please consult Trimite.			
Colour Range	Clear.			
Film Thickness & Coverage	Typical:	<u>Dry</u> 8 µm	<u>Wet*</u> 40 µm	<u>Approx. Coverage*</u> 14 - 15 m ² /l
	<p>* The above wet film thickness and approximate coverage rate (for conventional spray) will vary with 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>Flash Off: a flash-off period of approx. 10 min should be allowed before stoving.</p> <p>Conventional Stoving: 30 min at 150°C.</p> <p>Radiant Heat (Infra-Red): this product is suitable for radiant heat curing, but due to the many variables such as weight, configuration, reflectivity and distance from heat source, a suitable project schedule must be determined.</p> <p>Stoving schedules will vary with the size and weight of the coated article, and the type of equipment used. The above information is given as a general guide.</p>			

TECHNICAL DATA SHEET**Trimite D22330****Lacquer, Phenol Formaldehyde, Type QX, Stoving, Spraying/Dipping
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Surface Preparation	<ul style="list-style-type: none">All surfaces should be dry and cleaned as necessary to remove all oil, grease, corrosion or other contamination.
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">Ministry Approved for conventional spraying. This material is supplied 'Ready for Use Spraying'. Thinner M6006 may be added if necessary to obtain a suitable viscosity at application temperature.
Thinner/Cleaner	Trimite J103 Gun Cleaner (for cleaning).
SG	0.94 ± 0.15 kg/l.
Flash Point	Below 23°C – LOW FLASH MATERIAL.
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	Dec 2023.

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