

Trimite D80561

Paint, Finishing For Small Arms, Epoxide, Stoving, Spraying to Specification Def Stan 80-56, Black

Description	This Epoxy Stoving Paint gives a durable, abrasion resistant surface and is formulated to meet the requirements of DEF STAN 80-56. The Specification relates to a Black stoving finish to be spray applied direct to the phosphated surface of small arms.
Finish	Sheen.
Complies With	DEF STAN 80-56.
Product Code	D80561- .
Volume Solids	Please consult Trimite.
VOC's	Please consult Trimite.
Colour Range	Black.

Film Thickness & Coverage	Typical:	<u>Dry</u> 25 µm	<u>Wet*</u> 40 µm	<u>Approx. Coverage*</u> 6 - 7 m ² /l
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* 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'.

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

Drying & Overcoating Times
at Typical DFT

Flash Off: a flash-off period of approx. 10 min should be allowed before stoving.

Conventional Stoving: 20 min at 205°C.

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.

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.

TECHNICAL DATA SHEET**Trimite D80561****Paint, Finishing For Small Arms, Epoxide, Stoving, Spraying to Specification Def Stan 80-56, Black**

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.This product should be applied to a phosphated metal surface. Please consult Trimite for details.
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 ST16 may be added up to 5% by volume, to obtain a suitable viscosity at application temperature.
Thinner/Cleaner	Trimite J103 Thinner (for cleaning).
SG	0.95 ± 0.15 kg/l.
Flash Point	Below 23° – 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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