Trimite SP59

Paint, Priming For Instruments, Stoving, Spraying, to Specification Def Stan 80-152 Vellum 365/SP59

Description	Trimite SP59 Primer is part of a fully approved Ministry of Defence Standard and must be used strictly in accordance with the individual contract requirements. The Specification relates to a stoving paint system for such items as service telecommunication equipment and fire control instruments. (A separate Technical Data Sheet is available for the Finish used in this system.)
Finish	Matt.
Complies With	DEF STAN 80-152.
Product Code	**C365/SP59-5**.
Volume Solids	Please consult Trimite.
VOC's	Please consult Trimite.
Colour Range	Vellum (C365/SP59).

Film Thickness & Coverage

Typical:	Dry	Wet*	Approx. Coverage*
	20 µm	50 µm	5 - 6 m^2/l

* 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: 30 min at 160°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.

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Surface Preparation	• All surfaces should be dry and cleaned as necessary to remove all oil, grease, corrosion or other contamination. • Where Ministry of Defence specified materials are used, the following procedures may be relevant and, where applicable, should be observed: ○ DEF STAN 03-2: Cleaning and Preparation of Metal Surfaces. ○ DEF STAN 21-005: Code of Practice for Protective Finishes.
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	• Ministry Approved for conventional spraying. This material is supplied 'Ready for Use Spraying'. Thinner ST59 may be added up to 5% by volume, to obtain a suitable viscosity at application temperature.
Thinner/Cleaner	Trimite CT80 Thinner (for cleaning).
SG	1.21 $\pm$ 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	Dec 2023.