

Trimite 2402

High Solids, Finishing For Ammunition, Stoving Semi-Gloss to Def Stan 80-25

Description	A general purpose stoving semi-gloss paint for exterior use.			
Features	<ul style="list-style-type: none"> • Designed as a finish for ammunition to DEF STAN 80-25. • Can be used as a one coat finish, or applied over a suitable primer for extended durability. • A full system of one coat of primer plus one coat of finish, applied over a phosphated steel substrate, will protect against corrosion for up to 10 years, in all but the most aggressive conditions. 			
Finish	Semi-gloss.			
Complies With	DEF STAN 80-25.			
Product Code	2402- .			
Volume Solids	58% ± 2%.			
VOC's	Below 380 g/l.			
Colour Range	Service Brown and special shades made to order.			
Film Thickness & Coverage	Typical:	<u>Dry</u> 50 µm	<u>Wet</u> 86 µm	<u>Theo. Coverage</u> 11.6 m ² /l
	Actual coverage varies considerably with factors including surface porosity, roughness, application methods and conditions.			
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 120°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 2402****High Solids, Finishing For Ammunition, Stoving Semi-Gloss to Def Stan 80-25**

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.Where a Ministry Approved Primer is directed to be used, the following is normally specified: Ferrous Metals: Trimite D14570 - Paint, Priming, Zinc Phosphate, Air Drying/Stoving, Spraying to Specification DEF STAN 80-123 and 80-126 Eau-De-Nil.
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 ST60 may be added up to 10% by volume, to obtain a suitable viscosity at application temperature.
Thinner/Cleaner	Trimite 113 Thinner (for cleaning).
SG	1.57 ± 0.15 kg/l.
Flash Point	23°C – 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	Jan 2024.

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