

# Trimite Plastilac® AP211

## Two Pack Epoxy Primer

**Description** A two pack epoxy primer for Glass Reinforced Phenolic composites, which has low toxic fume emissions in the event of a fire.

**Finish** Matt.

- Features**
- AP211 is part of a coating system, formulated to maintain the low toxic fume emission of GR Phenolic (Glass Reinforced Phenolic) composites in the event of a fire. The approved topcoat is Trimite Plastilac® AE265.
  - Has excellent adhesion to GR Phenolic components.
  - Provides an aesthetic finish when used with approved topcoats.

**Complies With** Please consult Trimite.

**Product Code** 40/AP211.

**Volume Solids** 50% ± 2%.

**VOC's** 430 ± 20 g/l.

**Colour Range** Grey.

Film Thickness & Coverage	Typical:	Dry	Wet*	Approx. Coverage*
		40 µm	80 µm	5 - 6 m <sup>2</sup> /l

\* 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'.

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

Drying & Overcoating Times at Typical DFT		10°C	20°C	30°C
		Surface Dry:	4 h	2 h
Hard Dry:	16 h	8 h	4 h	
Overcoat Min:	16 h	8 h	4 h	
Overcoat Max:	12 days	7 days	3 days	

**Force Drying:** can be force dried for 30 minutes at 70°C, after a flash-off period of 15 min.

Drying and overcoating times can be greatly affected by method and conditions of application such as thickness applied, temperature, ventilation etc. Data above are given as a guide.

**TECHNICAL DATA SHEET****Trimite Plastilac® AP211****Two Pack Epoxy Primer**

<b>Surface Preparation</b>	<ul style="list-style-type: none"><li>• All surfaces to be coated should be dry and cleaned as necessary to remove mould release agent and any other contamination. The use of a hot detergent solution followed by thorough rinsing and drying is normally effective.</li><li>• GR Phenolic composite should be suitably post-cured, to stabilise the moisture content arising from the initial curing process.</li><li>• Since many forms of GR Phenolic exhibit a degree of porosity, it is usually necessary to apply a pore filler such as Trimite Plastilac® <b>AF208</b>.</li></ul>
<b>Mixing</b>	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.
<b>Pot Life at 20°C</b>	24 hours (do not use after this time, even though material may still look fluid).
<b>Mix Ratio</b>	Base 4 volumes Activator <b>J4504</b> 1 volume.
<b>Application Conditions</b>	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.
<b>Application Details</b>	<ul style="list-style-type: none"><li>• Designed for application by conventional spray/HVLP.</li><li>• 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).</li></ul>
<b>Thinner/Cleaner</b>	Trimite AT146 Thinner (for thinning and cleaning).
<b>SG</b>	1.60 ± 0.15 kg/l.
<b>Flash Point</b>	23° – 60°C.
<b>Shelf Life</b>	Min. 1 year from date of delivery when correctly stored in unopened containers.
<b>Storage</b>	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.
<b>Health &amp; Safety</b>	Refer to the product's Safety Data Sheet and safety advice on the product label before use.
<b>Date of Issue</b>	Jan 2024.

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