

TECHNICAL DATA SHEET

Trimite APF45

Two Pack Epoxy HB Primer

Description	A two pack epoxy primer/filler for steel and other metals.
Finish	Matt.
Features	<ul style="list-style-type: none"> • Designed as a high build primer/filler for steel and non-ferrous metals. • Has excellent corrosion and water resistance.
Complies With	Please consult Trimite.
Product Code	-/APF45.
Volume Solids	50% ± 2%.
VOC's	530 ± 20 g/l.
Colour Range	White (90/APF45) and shades to order.

Film Thickness & Coverage	Typical:	<u>Dry</u> 75 µm	<u>Wet</u> 150 µm	<u>Approx. Coverage*</u> 3 - 4 m ² /l
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* The above approximate coverage rates will vary with the degree of thinning and application technique.

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

Drying & Overcoating Times at Typical DFT		<u>10°C</u>	<u>20°C</u>	<u>30°C</u>
	Surface Dry:	4 h	1½ h	45 min
	Hard Dry:	14 h	6 h	3 h
	Overcoat Min:	2 h	1 h	30 min
	Overcoat Max:	12 days	7 days	3 days

Force Drying: can be force dried at temperatures up to 60°C after a flash-off period of 20 min. Force drying above 60°C will require longer flash-off times.

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.

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Surface Preparation	<ul style="list-style-type: none">All surfaces to be coated should be dry and cleaned as necessary to remove all rust, mill scale, grease and other contamination. Where necessary, remove weld spatter and grind smooth all sharp metal edges and weld seams.Steel: blast clean to standard Sa2½ (ISO 8501-1:2007), with a surface profile of 50-75 microns. Alternatively, use a zinc phosphate or iron phosphate pretreatment process – please consult Trimite for full details.Non-ferrous metals: a chromate-conversion pretreatment process is recommended, please consult Trimite for specific advice. Do not use an etch primer.Wood: sanding and de-nibbing is recommended.
Mixing	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.
Pot Life at 20°C	8 hours (do not use after this time, even though material may still look fluid).
Mix Ratio	Base 4 volumes Activator J4502 1 volume.
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">Designed for application by airless or conventional spray.Up to 5% AT46 Thinner may be used in the mixed material, to gain a viscosity of 120 sec (BS B4 cup).
Thinner/Cleaner	Trimite AT46 Thinner (for thinning and cleaning).
SG	1.36 ± 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	Jan 2024.

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