

TECHNICAL DATA SHEET

Trimite S33

Stoving Eggshell Structured Finish

Description	A high quality structured stoving finish, used for a range of industrial applications.
Finish	Eggshell structured finish.
Features	<ul style="list-style-type: none"> • May be applied to produce a distinctive spatter texture, smooth eggshell finish, or a pleasing ripple effect (see Application Details). • Specially designed for the finishing of computer housings, business machines, instrument panels and many other similar products. • Good durability and excellent appearance.
Complies With	Please consult Trimite.
Product Code	-/S33/- .
Volume Solids	Varies with colour, please consult Trimite.
VOC's	Varies with colour, please consult Trimite.
Colour Range	Black (B401/S33-) and colours to customers' requirements.

Film Thickness & Coverage	Typical:	<u>Dry</u> 40 µm	<u>Wet*</u> 80 µm	<u>Approx. Coverage*</u> 7 - 8 m ² /l
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Note: when applying a spatter coat, allow for a reduction of approximately 50% on the coverage figures shown.

* 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

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

Conventional Stoving: 30 min at 120°C, or 20 min at 140°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	<ul style="list-style-type: none">All surfaces should be dry and cleaned as necessary to remove all contamination.This product is usually applied over Trimite SP60 Stoving Primer – see separate Technical Data Sheet for SP60.
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">Designed for application by conventional spray.For conventional spray, Trimite ST33 Thinner may be added up to 20% by volume, to obtain a viscosity of 35 - 40 seconds using a BS B4 viscosity cup.Spatter Finish:<ul style="list-style-type: none">Apply the first coat normally and allow to 'flash off' for approximately 10 minutes.Reduce the air pressure to between 5-15 psi and apply a 'spatter' coat to the desired pattern. This procedure is made easier by the use of a pressure pot, which permits greater control of the resultant pattern.Ripple Effect:<ul style="list-style-type: none">A pleasing ripple effect can be produced when using as a single coat application at higher viscosities and reduced air pressure.
Thinner/Cleaner	Trimite CT80 Thinner (for cleaning).
SG	1.10 ± 0.15 kg/l.
Flash Point	23° – 60°C.
Shelf Life	Minimum of 1 year from date of receipt 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	Feb 2023.

Information provided in this leaflet is given in good faith but without warranty or assumed liability, as the conditions of application and use are beyond our control. Data are accurate to the best of our knowledge at the time of issue but may be revised in the light of new knowledge and the user should check that data are current before use. The user must satisfy themselves about the product's suitability for their own purpose and refer to the Safety Data Sheet for this product before use. For industrial use only unless specifically stated otherwise.