

Trimite Plastilac® B461

Two Pack Polyurethane High Solids Finish

Description	A high solids, two pack polyurethane finish, for steelwork, various plastics and general use.
Finish	Available in all gloss levels from Matt to Full Gloss.
Features	<ul style="list-style-type: none"> • Provides a finish with excellent colour and gloss retention in exterior environments. • Excellent durability, hardness, water and chemical resistance. • Can be used for a wide range of industrial applications on steel, plastic and non-ferrous metals. • Can be applied as a pleasing spatter finish.
Complies With	Please consult Trimite.
Product Code	-/B461/-.
Volume Solids	Varies with gloss level and colour, please consult Trimite.
VOC's	Below 420 g/l.
Colour Range	Wide colour range available.

Film Thickness & Coverage	Typical DFT:	Dry 25 µm	Wet* 50 µm	Approx. Coverage* 9 - 10 m ² /l
--------------------------------------	---------------------	---------------------	----------------------	--

* The above wet film thicknesses and approximate coverage rates (for conventional spray) will vary with colour, gloss level 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	1 h
	Hard Dry:	12 h	6 h	3 h
	Overcoat Min*:		see below	

Force Drying:

Can be force dried at up to 80°C for 30 minutes minimum, following a flash-off period of 15 min.

* not normally overcoated. Overcoating times are given for guidance only, please consult Trimite for detailed advice.

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® B461****Two Pack Polyurethane High Solids Finish****Surface Preparation**

- **Plastic:** The substrate must be thoroughly clean and free from mould release agents and static charges. Owing to the sensitivity of many plastics to certain solvents, Trimite Antistatic Cleaner J131 should be used. It may be necessary to use a suitable static eliminator immediately prior to painting.
 - **Metals:** all surfaces to be coated should be dry and cleaned as necessary to remove all corrosion, oil, grease and other contamination.
 - Apply over a suitable primer. Please consult Trimite for advice.
 - **Plastics:** Noryl® polycarbonate and rigid polyurethane foam do not normally require a primer, provided the surface is clean. If extra filling of the surface is necessary, Trimite APF210 Two Pack Polyurethane Primer Filler is recommended. For primers for other plastics, please consult Trimite.
 - **Ferrous Metals:** in the absence of an aqueous pretreatment, the recommended primers are Trimite SAP2 Etch Primer or Trimite AP45 Epoxy Primer.
 - **Aluminium & Light Alloys:** in the absence of a conversion coating, the use of Trimite SAP2 Etch Primer is recommended.
- (Noryl® is a trade mark of SABIC Innovative Plastics IP B.V.).

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

2 hours (do not use after this time, even though material may still look fluid).

Mix Ratio

For Matt (B461/1), Low Sheen (B461/2), Eggshell (B461/3), Satin (B461/4), Semi-Matt (B461/5):

Base 3 volumes
Activator 1 volume (use **J4611** activator)

For Semi-Gloss (B461/6), Off Gloss (B461/7), Low Gloss (B461/8), Full Gloss (B461/9):

Base 2 volumes
Activator 1 volume (use **J4611** activator)

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

- Designed for application by conventional spray and HVLP spray.
- For conventional spray, use as supplied. Up to 10% of Trimite PT1002 Thinner may be used if required, depending on equipment used.
- **Contains isocyanates** – the mixed product and the curing agent contain isocyanates (the base does not). Refer to base and curing agent Safety Data Sheets before use.

Spatter Finish:

- Apply the first coat normally and allow to flash off for approximately 10-15 min.
- Reduce air pressure to between 5-15 psi and apply spatter coat to the desired pattern. This application process is made easier by the use of a pressure pot, which permits greater control of the resultant pattern.

TECHNICAL DATA SHEET**Trimite Plastilac® B461**
Two Pack Polyurethane High Solids Finish

Thinner/Cleaner	Trimite PT1002 (Thinner) / Trimite J103 (Cleaner).
SG	1.20 ± 0.20 kg/l mixed (varies with colour and gloss level).
Flash Point	Below 23°C – LOW FLASH MATERIAL (except Full Gloss: 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	Feb 2024.

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 or professional use only unless specifically stated otherwise.