

# Trimite H65

## Stoving Hammer Finish

<b>Description</b>	An alkyd/amino stoving hammer finish for metal surfaces.
<b>Finish</b>	Hammer Sheen.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Produces a durable surface with a distinctive ‘hammer’ pattern, ideal for covering substrate imperfections or providing a cosmetic hammer-effect finish.</li> <li>• Has excellent non-sag properties, making it ideal for larger vertical surfaces where consistent results are difficult to achieve.</li> <li>• Can be used direct to metal as a one coat finish in certain areas, but a primer is recommended for optimum longer term protection.</li> </ul>
<b>Complies With</b>	Please consult Trimite.
<b>Product Code</b>	-/H65 .
<b>Volume Solids</b>	Varies with colour, please consult Trimite.
<b>VOC’s</b>	Varies with colour, please consult Trimite.
<b>Colour Range</b>	Shade range to customers’ requirements.

<b>Film Thickness &amp; Coverage</b>	<b>Typical:</b>	<u>Dry</u> 30 µm	<u>Wet*</u> 55 µm	<u>Approx. Coverage*</u> 5 - 6 m <sup>2</sup> /l
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\* 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.

<b>Stoving &amp; Overcoating Times</b>	<p>A flash-off period of 10 min should be allowed before stoving.</p> <p>The stoving schedule will vary with the size, weight of the article and the type of equipment used. The following schedule may be used as a general guide:</p> <p><b>Conventional stoving:</b> 30 min at 120°C.</p> <p><b>Radiant Heat (Infra-red):</b> this product is suitable for radiant heat curing, but due to the many variables of weight, configuration, reflectivity and distance from heat source, a suitable schedule must be determined for each process to obtain the best results.</p>
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**TECHNICAL DATA SHEET****Trimite H65****Stoving Hammer Finish**

<b>Surface Preparation</b>	<ul style="list-style-type: none"><li>• All surfaces to be coated should be dry and cleaned as necessary.</li><li>• For optimum results, Trimite H65 should be applied over a suitable primer.</li><li>• <b>Steel:</b> recommended primers include Trimite <b>HP20</b> One Pack Primer or Trimite <b>SAP2</b> Etch Primer.</li><li>• <b>Aluminium and Light Alloys:</b> recommended primers include Trimite <b>SAP2</b> Etch Primer, or Trimite <b>HP20</b> One Pack Primer where a single pack primer is required, but HP20 is not suitable for extruded aluminium.</li><li>• Consult Trimite for specific project advice.</li></ul>
<b>Mixing</b>	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 a homogenous mix.
<b>Mix Ratio</b>	Not applicable - single pack product.
<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 5°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 or airless spray.</li><li>• <b>Conventional spray:</b> up to 5% ST60 Thinner may be used in the mixed material, to gain a viscosity of 80 - 100 seconds using a BS B4 viscosity cup.</li><li>• <b>Airless spray:</b> use as supplied, with small additions of ST60 Thinner if required.</li></ul>
<b>Thinner/Cleaner</b>	Trimite ST60 Thinner (for thinning) / Trimite PT1002 (for cleaning).
<b>SG</b>	0.98 ± 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>	Aug 2024.

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