

## TECHNICAL DATA SHEET

# Trimite HP20

## One Pack Etch Primer

<b>Description</b>	A pigmented, epoxy-modified etch primer for non-ferrous metals and steel.
<b>Finish</b>	Matt.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Provides excellent adhesion to steel and non-ferrous metals.</li> <li>• Designed for drying by stoving. If air drying, the addition of Trimite SAR2 acid component is recommended.</li> <li>• Improves the corrosion and water resistance of the finishing system.</li> </ul>
<b>Complies With</b>	Please consult Trimite.
<b>Product Code</b>	-/HP20 .
<b>Volume Solids</b>	15% ± 2%.
<b>VOC's</b>	Below 710 ± 20 g/l.
<b>Colour Range</b>	Black (8/HP20), Red Oxide (85/HP20), Light Grey (40/HP20), White (90/HP20).

<b>Film Thickness &amp; Coverage</b>	<b>Typical:</b>	<u>Dry</u>	<u>Wet*</u>	<u>Approx. Coverage*</u>
		12 µm	37 µm	7 - 8 m <sup>2</sup> /l

\* The above approximate wet film thickness and coverage rate (for conventional spray) will vary with the degree of thinning and application technique. Actual coverage varies considerably with factors including surface porosity, roughness, application methods and conditions.

<b>Drying &amp; Overcoating Times (using SAR2) at Typical DFT</b>		<u>10°C</u>	<u>20°C</u>	<u>30°C</u>
	Surface Dry:	1 h	30 min	5 min
	Hard Dry:	10 h	4 h	2 h
	Overcoat Min:	10 h	4 h	2 h
	Overcoat Max:	overcoat as soon as practicable		

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.

<b>Stoving (HP20 only)</b>	<p>A 'flash-off' period of approximately 10 min should be allowed after application, for the solvents to evaporate, before stoving. The stoving schedule will vary with the size, weight of article and the type of equipment used. The following schedule may be used as a general guide:</p> <p><b>Convection Stoving:</b> 15 min at 120°C.</p> <p><b>Radiant Heat (Infra-red):</b> the systems outlined in this sheet are suitable for radiant heat curing but due to the many variables, e.g. weight, configuration, reflectivity, distance from heat source, a suitable schedule must be determined.</p> <p><b>Note:</b> It is not essential to stove the priming coat prior to applying the finishing coat providing that the primer has been allowed to dry for at least 30 min at 20°C, and the complete system is then cured at the recommended stoving schedule. However, for optimum adhesion, stoving the primer prior to applying the finishing coat is strongly recommended.</p>
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<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 all rust, mill scale, grease and other contamination. Where necessary, remove weld spatter and grind smooth all sharp metal edges and weld seams.</li> <li>For non-ferrous metals, all surfaces should be thoroughly degreased. Any very smooth, shiny areas should be lightly abraded to provide a key.</li> <li>HP20 is not considered suitable for extruded aluminium.</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>	12 hours (if using SAR2 acid component for air drying. Do not use after this time, even though material may still look fluid).									
<b>Mix Ratio</b>	<table border="0"> <tr> <td style="padding-right: 10px;"><b>If air drying:</b></td> <td>Base (<b>HP20</b>)</td> <td>2 volumes</td> </tr> <tr> <td></td> <td>Activator (<b>SAR2</b>)</td> <td>1 volume.</td> </tr> <tr> <td><b>If stoving:</b></td> <td colspan="2">Use only HP20 as supplied, do not mix with SAR2.</td> </tr> </table>	<b>If air drying:</b>	Base ( <b>HP20</b> )	2 volumes		Activator ( <b>SAR2</b> )	1 volume.	<b>If stoving:</b>	Use only HP20 as supplied, do not mix with SAR2.	
<b>If air drying:</b>	Base ( <b>HP20</b> )	2 volumes								
	Activator ( <b>SAR2</b> )	1 volume.								
<b>If stoving:</b>	Use only HP20 as supplied, do not mix with SAR2.									
<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 (for HP20 and HP20/SAR2 mix) or electrostatic spray (if using only HP20).</li> <li><b>Conventional spray:</b> Trimite Thinner PT1002 may be added, up to 30% by volume of mixed material, to a viscosity of 20 – 30 seconds using a BS B4 viscosity cup.</li> <li><b>Electrostatic spray:</b> HP20 (when not mixed with SAR2) is suitable for many types of electrostatic spray, using Trimite T100 Thinner. Please consult Trimite for details.</li> </ul>									
<b>Thinner/Cleaner</b>	Trimite T100 (as thinner) / Trimite PT1002 (for thinning & cleaning – see above).									
<b>SG</b>	1.0 ± 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.									

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.