

Trimite D80256-series

Paint, Finishing For Ammunition, Stoving, Spraying to Specification Def Stan 80-25

Description	This finish is formulated and tested to a Defence Standard and must be used strictly in accordance with the individual contract requirements. This specification relates to a stoving Semi-gloss or Matt finish which may be used with or without the recommended primer as directed. The paint is suitable for application by spraying and is required to protect steel ammunition against corrosion.
Finish	Semi-gloss or Matt.
Complies With	DEF STAN 80-25.
Product Code	See Colour Range.
Volume Solids	Please consult Trimite.
VOC's	Please consult Trimite.
Colour Range	Service Brown (D80256), Deep Sax Blue (D68700).

Film Thickness & Coverage	Typical:	<u>Dry</u> 25 µm	<u>Wet*</u> 50 µm	<u>Approx. Coverage*</u> 6 - 8 m ² /l
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Note: The contract specification will detail the number of coats of finish required.

* The above wet film thickness and approximate coverage rate (for conventional spray) will vary with 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.

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.

TECHNICAL DATA SHEET**Trimite D80256-series****Paint, Finishing For Ammunition, Stoving, Spraying to Specification
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Surface Preparation	<ul style="list-style-type: none">All surfaces should be dry and cleaned as necessary to remove all oil, grease, corrosion or other contamination.Where a Ministry Approved Primer is directed to be used, the following is normally specified: Ferrous Metals: Trimite D14570 - Paint, Priming, Zinc Phosphate, Air Drying/Stoving, Spraying to Specification DEF STAN 80-123 and 80-126 Eau-De-Nil.Where Ministry of Defence specified materials are used, the following procedure may be relevant, and where applicable, should be observed:<ul style="list-style-type: none">Def Stan 03-2: Cleaning and Preparation of Metal Surfaces.
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">Ministry Approved for conventional spraying. This material is supplied 'Ready for Use Spraying'. Thinner ST60 may be added up to 20% by volume, to obtain a suitable viscosity at application temperature.Also suitable for application by electrostatic spray, airless spray or hot spray.
Thinner/Cleaner	Trimite PT1002 Thinner (for cleaning).
SG	1.04 ± 0.15 kg/l.
Flash Point	23°C – 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	Nov 2024.

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