

TrimaThane AE251/0

Two Pack Polyurethane ‘Dead-Matt’ Finish

Description A two pack polyurethane-acrylic finish with a completely Matt finish, for use in ‘light-tight’ situations on metals and various plastics.

Finish Complete Matt.

- Features**
- Designed as a ‘dead-matt’ finish for electro-optical systems where light reflectivity must be an absolute minimum; e.g. on computer housings, business machines and instrument panels for interior use.
 - Excellent durability, hardness, water and chemical resistance.
 - Fast drying.
 - Used as a finish coat over suitable priming systems, depending on the substrate.

Complies With Please consult Trimite.

Product Code B401/AE251/0 .

Volume Solids 44% ± 2% (mixed product).

VOC’s 520 ± 20 g/l (mixed product).

Colour Range Matt Black. Other shades to special order.

| Film Thickness & Coverage | Typical DFT: | | | <u>Approx. Coverage*</u> 7 - 8 m ² /l |
|---------------------------|--------------|-------------|--|---|
| | <u>Dry</u> | <u>Wet*</u> | | |
| | 35 µm | 60 µm | | |

* 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 | <u>10°C</u> | <u>20°C</u> | <u>30°C</u> |
|---|-------------------------|-------------|-------------|
| | Surface Dry: | 40 min | 20 min |
| Hard Dry: | 6 h | 3 h | 1½ h |
| Overcoating: | not normally overcoated | | |

Force Drying: a ‘flash-off’ period of approximately 5 min should follow the application to allow the solvents to evaporate.

Plastic: force drying must be carried out with care to avoid component deformation. The type of plastic, conditions of moulding and post-mould time will determine the maximum temperature that can be employed.

Metal: when it is required to accelerate the drying process, temperatures up to 120°C for 20-30 min are normally recommended.

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

TrimaThane AE251/0

Two Pack Polyurethane Low Gloss/Spatter 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 contamination.
- Apply over a suitable primer. Please consult Trimite for advice.
Plastics: Noryl® and rigid polyurethane foam do not normally require a primer, provided the surface is clean; if extra filling of the surface is necessary, **TrimaThane 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 **TrimaKote AP45** Two Pack Epoxy Primer, **TrimaThane AP210** Two Pack Polyurethane Primer or **TrimaEtch SAP2** Etch Primer.
Aluminium & Light Alloys: in the absence of a conversion coating, the use of **TrimaEtch 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

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

Mix Ratio

| | |
|-------------------|-----------|
| Base (AE251) | 5 volumes |
| Activator (J2511) | 1 volume. |

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 10°C. The paint temperature at the time of application should ideally be 15° - 20°C.

Application Details

- Designed for application by conventional spray.
- For conventional spray, add to the mixed material up to 20% by volume of Trimite PT1002 Thinner, to obtain a viscosity of 25-30 seconds using a BS B4 viscosity cup.
- **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.

Thinner/Cleaner

Trimite PT1002 Thinner (as Thinner and Cleaner).

SG

1.20 ± 0.20 kg/l mixed (varies with colour and gloss level).

Flash Point

23° – 60°C.

Shelf Life

Min. 1 year from date of delivery when correctly stored in unopened containers.

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| | |
|----------------------------|---|
| 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 | Dec 2024. |

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