

TECHNICAL DATA SHEET

TrimaPrime IL3509

Red Oxide Primer

Description	A fast drying, epoxy/PVB weldable anticorrosive primer for steel.
Finish	Matt.
Features	<ul style="list-style-type: none"> • Designed as a weldable primer for steel to give temporary anticorrosive protection during transit or fabrication stages. • Can be top coated with a range of coating types, but is specially designed for use with TrimaKote IL3842 High Solids Epoxy. • Fast drying.
Complies With	Please consult Trimite.
Product Code	IL3509- .
Volume Solids	24% ± 2%.
VOC's	652 ± 20 g/l.
Colour Range	Red Oxide.

Film Thickness & Coverage	Typical:	<u>Dry</u> 20 µm	<u>Wet*</u> 82 µm	<u>Approx. Coverage*</u> 12 m ² /l
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* The above wet film thickness and approximate coverage rate will vary with method of application and the degree of any thinning. Wet film thicknesses are approximate.

Actual coverage varies considerably with factors including surface porosity, roughness, application methods and conditions.

Drying & Overcoating Times at Typical DFT	Curing schedule:	Air Dry recommended. Can be force dried following a minimum flash off time of 40 mins. Do not force dry if applying over blast cleaned steel.
	Force Dry:	30 min @ 80°C (object temperature) after minimum 40 min flash off time @20°C.
	Overcoating Min.	Air dry – min. 40 mins., or after cooling to below 30°C if force dried. Always allow product to air dry if applying over blast cleaned steel.
	Overcoating Max.	Indefinite if clean and sound, but 7 days 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.

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Surface Preparation	<ul style="list-style-type: none">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.Always allow product to air dry if applying over blast cleaned steel.
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 a 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">Designed for application by conventional, airless or air-assisted airless spray.For all spray methods, thin by 1:1 with PT1100.
Thinner/Cleaner	Trimite PT1100 Thinner (as Thinner and Cleaner).
SG	1.09 ± 0.05 kg/l.
Flash Point	25°C.
Shelf Life	12 months from date of manufacture 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	April 2026.

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.