Trimite PA8000

Aerospace Grade Epoxy Polyester Powder Coating - Smooth

Description	An internal grade epoxy polyester powder coating with a smooth surface, designed for Aerospace applications.
Finish	Available in a range of gloss levels – please consult Trimite.
Features	• Internal grade, smooth powder coating with excellent flow and decorative appearance. • Good colour and gloss stability. • Good over-stoving ability. • Extremely tough and mar resistant. • Good resistance to oils, paraffin and alcohols.
Complies With	Generic indicative tests comply with FAR 25.853. It is the responsibility of the end user to ensure full compliance to the regulations.
Product Code	**-/PA8000/-** .
Colour Range	Shade range to customers' requirements.
Film Thickness & Coverage	Range 60 - 80 µm dft. Typical coverage rate: 8 – 12 m^2/kg.
Cure Schedule	10 min @ 180°C (substrate temperature). Target time for the curing process overall should be 20-25 min (10-15 min for rise from ambient to cure temperature, then 10 min at cure temperature).
Surface Preparation	• Pretreatment using SurTec 650 (Trimite ref **MP0206**) or TrimaEtch **SAP2** Etch Primer is recommended.
Application Details	By conventional Corona equipment. The use of a 20 kg Fluidising Hopper is strongly recommended for metallic colours ("M" reference codes).
Repairs	Minor repairs can be carried out using TrimaSol 1K (single pack) or TrimaSol 2K (two pack) colour-matched aerosols. An additional coat of TrimaSol Clear aerosol lacquer may be required to achieve the required reflectivity, gloss level or effect. Please see separate **Repair Procedures** document for Trimite PA8000 in the relevant colour.
Shelf Life	Min. 1 year from date of despatch when correctly stored in unopened containers.
Storage	The product should be stored in cool, dry, frost-free conditions not exceeding 25°C, in sealed containers. Avoid exposure to direct sunlight when in storage & in use.
Health & Safety	Refer to the product's Safety Data Sheet and safety advice on the product label before use.

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Product Performance

TEST	RESULT – UK Spec	RESULT – ISO/ASTM Spec
Cross Hatch Adhesion	BS3900 E6 - Class '0'	ISO2409 – Pass Gt0
Impact Resistance	BS3900 E3 – Pass 20 lb.	ASTM D2794 – Pass 2.5 Nm
Flexibility	BS3900 E11 - Pass 6 mm	ISO6860 – Pass 6 mm
Cupping Test	BS3900 E4 - Pass 6 mm	ISO1520 – Pass 6 mm
Scratch Resistance	BS3900 E2 – Pass 4 kg	n/a
Hot Salt Spray	ASTM B117 – Pass 1000 h	ASTM B117 – Pass 1000 h
Humidity Resistance	BS3900 F2 – Pass 1000 h	ASTM 2247 – Pass 1000 h
Chemical Resistance	Resistant to many acids, alkalis and oils at ambient temperatures. May be affected by chlorinated solvents.	

Mechanical tests and corrosion trials were carried out on 0.7 mm aluminium test panels, pretreated with SurTec 650 (Trimite ref MP0206). A nominal powder thickness of 60 µm was used.

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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.