

TECHNICAL DATA SHEET

TrimaLac Monocoat IL-series

Water Based Gloss

Description	A water borne gloss coating for metal items.
Finish	Gloss ($95 \pm 5 @60^\circ$).
Features	- Specially designed for metal substrates in the engine manufacturing industry. - Use on aluminium, cast aluminium, aluminised steel, steel and cast iron substrates.
Complies With	Please consult Trimite.
Product Code	IL- (varies with colour).
Volume Solids	$25\% \pm 2\%$ (varies with colour).
VOC's	160 g/l.
Colour Range	Selected range to customer's requirements.

Film Thickness & Coverage	Typical:	<u>Dry</u>	<u>Wet</u>	<u>Theo. Coverage</u>
		35 μm	140 μm	7.1 m²/l
Theoretical Coverage assumes 100% transfer efficiency. Actual coverage varies considerably with factors including surface porosity, roughness, application methods and conditions.				

Drying & Overcoating Times		<u>10°C</u>	<u>20°C</u>	<u>30°C</u>
at Typical DFT	Surface Dry:	2 hr	1 hr	30 min
	Hard Dry:	8 h	4 hr	2 hr
	Overcoat Min:	16 hr	8 hr	4 hr

Force drying:

Flash off:	30 min @ 25°C (77°F) (object temperature)
Curing schedule:	30 min @ 60°C (140°F) (object temperature)

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	• All surfaces to be coated should be dry and cleaned as necessary. • A range of surface pretreatment products and primers is available from Trimite, please consult Trimite for advice.
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 70%. 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	• Designed for use by hand or automatic air-assisted spray. • Recommended application viscosity – please consult Trimite.
Thinner/Cleaner	Clean, cold fresh water.
SG	1.13 ± 0.03 kg/l (wet); 1.59 ± 0.04 kg/l (dry); (varies with colour)
Flash Point	Above 55°C.
Shelf Life	4 months from date of manufacture (see Expiry Date on label) 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	Sep 2026.

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