

TECHNICAL DATA SHEET

TrimaLac Monocoat QD Finish

Water Based Finish

Description	A specially formulated low VOC water borne coating for metal substrates.		
Finish	Matt (5-15%), Semi-Gloss (40-60%), Gloss (>80% @60°).		
Features	• Can be applied direct-to-metal or over water based primers. • Durable, high quality finish for metal components. • Low VOC formulation with flexible curing options. • Can be air dried or cured using low temperature stoving.		
Complies With	2004/42/EC (2012) sub-category A(i) - VOC level below 140 g/l.		
Product Code	IL- series.		
Volume Solids	35% ± 2%.		
VOC's	25 ± 5 g/l.		
Colour Range	Wide range of RAL and BS colours available.		
Film Thickness & Coverage		<u>Dry</u>	<u>Wet</u>
	Range:	35 - 45 µm	100 - 128 µm
			<u>Theo. Coverage</u>
			10.0 – 7.7 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	Air dry:	Touch-dry - 30 min. Hard dry – 8 hr.	
	Overcoating:	Not normally required.	
at Range DFT	Flash off:	10-15 min @ 20°C (68°F) object temperature	
	Curing schedule:	30-45 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. - If applying over bare metal, Trimite T Cleaner 8 (MP0207) is recommended for the removal of all oils and grease prior to coating. - For optimum results it is recommended to apply over TrimaLac QDP WB Primer.
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. 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. Conventional spray Fluid pressure 1.5 - 3.0 bar (22 - 44 psi) Atomising air pressure 2.0 – 4.0 bar (29 – 58 psi) Nozzle size: 1.2 to 1.8 mm. Air-assisted airless spray Fluid pressure 40 - 100 bar (580 - 1450 psi) Atomising air pressure 0.7 – 2.0 bar (10 – 29 psi). Tip size: 0.009" to 0.015" Recommended application viscosity – typically between 5 - 6 poise @20°C. Adjust pressures and tip sizes as necessary to achieve optimum atomisation, transfer efficiency and finish quality. Excessive pressure may result in overspray and material waste, while insufficient pressure can cause poor atomisation and an uneven finish. Always perform a test spray before full-scale application.
Thinner/Cleaner	Clean, cold fresh water.
SG	1.09 ± 0.03 kg/l (wet) – varies with shade.
Flash Point	Above 65°C.
Shelf Life	6 months 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	Sep 2026.

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Typical test results for TrimaLac Monocoat QD Finish applied over TrimaPrime Monocoat QD Primer:

Test	ASTM Standard	Monocoat QD Result
VOC	ASTM D3960	<30 g/L
Sag Resistance	ASTM D4400	200µm wet film
Dry to Touch	n/a	30 minutes @ 20°C
Substrate Adhesion	ASTM D3359, Method B	>95% adhesion
Intercoat Adhesion	ASTM D3359, Method B	>95% adhesion
Recoatability Adhesion	ASTM D3359, Method B	>95% adhesion
Pencil Hardness	ASTM D3363	H
Salt Spray/CCT	SAE J2334	250 hours no defects (20 cycles)
Humidity	ASTM D2247	200 hours no defects
Elongation	ASTM D522	32%
Immersion - Water	ASTM D1308 25°C	300 hours @ 25°C DTM - >95% adhesion
Immersion - Diesel	ASTM D975 60°C	300 hours @ 60°C DTM - >95% adhesion
Immersion - Hydraulic Oil	ASTM D975 110°C	300 hours @ 110°C DTM- >95% adhesion
Xenon Arc Weathering Test	SAE J2527 Xenon WOM 1000 hours	1000 hours good colour and gloss retention

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