

## TECHNICAL DATA SHEET

# TrimaPrime Monocoat QD Primer

## Water Based Primer

|                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                    |                                                                      |                                                      |
|----------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------|------------------------------------------------------|
| <b>Description</b>                                 | A specially formulated low VOC water borne primer designed for use on metal substrates, including aluminium, cast iron and mild steel.                                                                                                                                                                                                                                                                             |                                                                      |                                                      |
| <b>Finish</b>                                      | Matt (IL4072) and Semi-Gloss (IL4094).                                                                                                                                                                                                                                                                                                                                                                             |                                                                      |                                                      |
| <b>Features</b>                                    | <ul style="list-style-type: none"> <li>Designed for use with TrimaLac Monocoat QD Finishes.</li> <li>Durable, high quality primer for metal components.</li> <li>Low VOC formulation with flexible curing options.</li> <li>Can be air dried or cured using low temperature stoving.</li> </ul>                                                                                                                    |                                                                      |                                                      |
| <b>Complies With</b>                               | 2004/42/EC (2012) sub-category A(i) - VOC level below 140 g/l.                                                                                                                                                                                                                                                                                                                                                     |                                                                      |                                                      |
| <b>Product Code</b>                                | See Colour Range.                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                      |                                                      |
| <b>Volume Solids</b>                               | 33% $\pm$ 2%.                                                                                                                                                                                                                                                                                                                                                                                                      |                                                                      |                                                      |
| <b>VOC's</b>                                       | 25 $\pm$ 5 g/l.                                                                                                                                                                                                                                                                                                                                                                                                    |                                                                      |                                                      |
| <b>Colour Range</b>                                | Light Grey <b>IL4072</b> (approx. BS676)<br>Dawn Grey <b>IL4094</b> (approx. RAL7037).<br>Other shades to order.                                                                                                                                                                                                                                                                                                   |                                                                      |                                                      |
| <b>Film Thickness &amp; Coverage</b>               | <b>Range:</b><br><br>Theoretical Coverage assumes 100% transfer efficiency. Actual coverage varies considerably with factors including surface porosity, roughness, application methods and conditions.                                                                                                                                                                                                            | <b>Dry</b><br>40 - 60 $\mu$ m<br><br><b>Wet</b><br>121 - 182 $\mu$ m | <b>Theo. Coverage</b><br>8.2 – 5.5 m <sup>2</sup> /l |
| <b>Drying &amp; Overcoating Times at Range DFT</b> | Air dry: Touch-dry - 30 min.<br>Hard dry – 8 hr.<br>Overcoating: 60 min. minimum @ 20°C<br><br>Flash off: 10-15 min @ 20°C (68°F) object temperature<br>Curing schedule: 30-45 min @ 60°C (140°F) object temperature<br><br>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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| <b>Surface Preparation</b>    | <ul style="list-style-type: none"> <li>All surfaces to be coated should be dry and cleaned as necessary.</li> <li>Trimite T Cleaner 8 (MP0207) is recommended for the removal of all oils and grease prior to coating.</li> </ul>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |
| <b>Mixing</b>                 | 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.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |
| <b>Mix Ratio</b>              | Not applicable – single pack product.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |
| <b>Application Conditions</b> | <p>Throughout the application and the drying/curing time of coatings:</p> <ul style="list-style-type: none"> <li>a) good ventilation is required.</li> <li>b) do not apply when damp weather conditions are likely.</li> <li>c) the substrate temperature should be at least 3°C above the Dew Point.</li> <li>d) the RH (Relative Humidity) should be below 70%.</li> </ul> <p>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.</p>                                                                                                                                                                                                                                                                                                                                                            |
| <b>Application Details</b>    | <p>Designed for use by hand or automatic air-assisted spray.</p> <p><b>Conventional spray</b><br/>           Fluid pressure 1.5 - 3.0 bar (22 - 44 psi)<br/>           Atomising air pressure 2.0 – 4.0 bar (29 – 58 psi)<br/>           Nozzle size: 1.2 to 1.8 mm.</p> <p><b>Air-assisted airless spray</b><br/>           Fluid pressure 40 - 100 bar (580 - 1450 psi)<br/>           Atomising air pressure 0.7 – 2.0 bar (10 – 29 psi).<br/>           Tip size: 0.009" to 0.015"<br/>           Recommended application viscosity – typically between 5 - 6 poise @20°C.</p> <p>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.</p> |
| <b>Thinner/Cleaner</b>        | Clean, cold fresh water.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |
| <b>SG</b>                     | 1.13 ± 0.05 kg/l – varies with shade.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |
| <b>Flash Point</b>            | Above 65°C.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |
| <b>Shelf Life</b>             | 6 months from date of delivery when correctly stored in unopened containers.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |
| <b>Storage</b>                | 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.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |
| <b>Health &amp; Safety</b>    | Refer to the product's Safety Data Sheet and safety advice on the product label before use.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |
| <b>Date of Issue</b>          | Sep 2026.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |

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