TrimaKote AP45

Two Pack Epoxy Primer

Description

A two pack polyamide-cured epoxy primer designed for the protection of steel, aluminium, other non-ferrous metals, and composite substrates.

Finish

Matt.

Features

- Provides optimum corrosion resistance, adhesion and filling properties.
- Designed for use with TrimaKote A46 Two Pack Epoxy Finish.
- May also be used with a wide range of other air drying and stoving finishes.

Complies With

Please consult Trimite.

Product Code

-/AP45.

Volume Solids

50% ± 2%.

VOC's

480 ± 20 g/l.

Colour Range

Mid Grey (41/AP45), Black (8/AP45), White (90/AP45).

Film Thickness & Coverage

	Dry	Wet*	Approx. Coverage*
Typical:	40 µm	80 µm	5 - 6 m^2/l

* The above wet film thickness and approximate coverage rate (for conventional spray) will vary with colour and the degree of thinning. Wet film thicknesses are approximate and are based on the typical degree of thinning recommended under 'Application Details'.

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

Drying & Overcoating Times
at Typical DFT

	10°C	20°C	30°C
Surface Dry:	4 h	2 h	1 h
Hard Dry:	16 h	8 h	4 h
Overcoat Min:	16 h	8 h	4 h
Overcoat Max:	12 days	7 days	3 days

Force Drying: can be force dried at temperatures up to 60°C after a flash-off period of 10 min. Force drying above 60°C will require longer flash-off times.

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.

TrimaKote AP45

Two Pack Epoxy Primer

Surface Preparation

- 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.
- **Steel**:
  - Ideally, abrasive blast clean to standard Sa2½ (ISO 8501-1:2007), with a surface profile of 50-75 microns.
  - For areas where abrasive blast cleaning is not possible, the surface should be prepared by hand or mechanical means to standard St2 (ISO 8501-1:2007), with care required to avoid 'polishing' the metal surface. Coating lifetime will be significantly reduced if not blast cleaning.
  - Alternatively, use a zinc phosphate or iron phosphate pretreatment process – please consult Trimite for full details.
- **Non-ferrous metals:** a suitable etch primer is recommended, please consult Trimite for specific advice.
- **Composite substrate** - Ensure the substrate is clean, dry, and free from all contaminants. Clean with Trimite Antistatic Cleaner J131 before coating application. Light abrasion or denibbing is recommended where appropriate to maximise adhesion. Remove all dust and residues before applying the primer.

Mixing

Mix each component separately, and then thoroughly mix together in the mix ratio stated, using a power mixer. Stir occasionally during use to maintain an homogenous mix.

Pot Life at 20°C

24 hours (do not use after this time, even though material may still look fluid).

Mix Ratio

Base	2 volumes
Activator **J4501**	1 volume.

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 10°C. The paint temperature at the time of application should ideally be 15° - 20°C.

Application Details

- Designed for application by conventional spray, electrostatic spray or brush.
- Conventional spray: up to 15% T100 Thinner may be used in the mixed material, to gain a viscosity of 40 - 50 sec (BS B4 cup).
- Electrostatic spray: suitable for most types of equipment, please consult Trimite for specific advice.
- Brush: may be used as supplied. Small additions of T100 Thinner may be made depending on conditions.

Thinner/Cleaner

Trimite T100 Thinner (for thinning and cleaning).

SG

1.36 ± 0.15 kg/l.

Flash Point

23° – 60°C.

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Two Pack Epoxy Primer

Shelf Life	Min. 1 year 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	Nov 2026.

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