TrimaKote APF45

Two Pack Epoxy HB Primer

Description

A two pack epoxy primer/filler for steel, aluminium and other non-ferrous metals, and composite substrates.

Finish

Matt.

Features

- Designed as a high build primer/filler for steel and non-ferrous metals.
- Has excellent corrosion and water resistance.

Complies With

Please consult Trimite.

Product Code

-/**APF45**.

Volume Solids

50% ± 2%.

VOC's

530 ± 20 g/l.

Colour Range

White (90/APF45) and shades to order.

Film Thickness & Coverage

	Dry	Wet	Approx. Coverage*
Typical:	75 µm	150 µm	3 - 4 m^2/l

* The above approximate coverage rates will vary with the degree of thinning and application technique.

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	1½ h	45 min
Hard Dry:	14 h	6 h	3 h
Overcoat Min:	2 h	1 h	30 min
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 20 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 APF45

Two Pack Epoxy HB 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 chromate-conversion pretreatment process is recommended, please consult Trimite for specific advice. **Do not use** an etch primer.
- **Wood:** sanding and de-nibbing is recommended.
- **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

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

Mix Ratio

Base	4 volumes
Activator **J4502**	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 5°C. The paint temperature at the time of application should ideally be 15° - 20°C.

Application Details

- Designed for application by airless or conventional spray.
- Up to 5% Trimite T100 Thinner may be used in the mixed material, to gain a viscosity of 120 sec (BS B4 cup).

Thinner/Cleaner

Trimite T100 Thinner (for thinning and cleaning).

SG

1.36 ± 0.15 kg/l.

Flash Point

23° – 60°C.

Shelf Life

Min. 1 year from date of delivery when correctly stored in unopened containers.

TrimaKote APF45

Two Pack Epoxy HB Primer

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.

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.