



# TRIMAGARD 15MB

## INTRODUCTION

A liquid blend of resin and phosphating base in solvent. It gives a thin protective coating on iron and steel to which most paints and powder coatings adhere well. It is supplied ready for use by dipping, spraying or brushing. Trimagard 15MB acts as a self-etching etch primer. It will provide several months protection prior to over-coating at a later date. Trimagard 15MB will give protection to friction surfaces. Trimagard 15MB carries NATO approval numbers show in the Range section.

## BENEFITS

- Simple process - no heating, no rinsing.
- Improves the adhesion of most industrial paints and powder coatings.
- Improves the rust resistance of painted iron and steel.
- Prevents rusting of items stored in good conditions awaiting final painting.
- Economic; a dry film thickness of 5 microns is sufficient for most purposes.

## RANGE

Trimagard 15MB is available in the following colours:

- (1) **CLEAR MP0680 (Nato number 8010-99-958-7848 (UK SALES ONLY)**
- (2) **CLEAR MP0680 (Nato number 8030-99-668-5901 (EXPORT)**
- (3) **GREEN MP0681 (Nato number 8030-99-337-1703)**
- (4) **BLACK MP0682 (Nato number 8030-99-676-6764)**
- (5) **RED MP0683**
- (6) **YELLOW MP0684**
- (7) **BLUE MP0685 (Nato number 8030-99-571-3989)**

## COVERAGE

The rate of consumption will depend on over-spray or draining efficiency. As a guide, the following ranges have proved reliable:

Dip: 12–20 m<sup>2</sup> /litre of Trimagard 15MB  
Spray-gun: 8–15 m<sup>2</sup> /litre of Trimagard 15MB



## **FLASHPOINT**

Tested to BS 3900 Part A8. Flashpoint is in the range 21°C – 32°C.

## **APPLICATION**

Normally, the process sequence is:

1. Degrease if necessary, by:

- a) Solvent wiping with T Cleaner 2 (MP0113) or T Wipes 2 (MP0302), or,
- b) Solvent vapour degreasing with Triklone 'N' (MP0301).

2. Apply Trimagard 15MB either by:

- a) Dip at room temperature and drain, jigging the work to avoid trapping and secondary runs, or,
- b) Spray a thin coat of Trimagard 15MB as supplied.

NOTE: Trimagard 15MB needs a minimum application temperature of 15°C to achieve good phosphating.

## **CONTROL POINTS**

|                        |                                         |
|------------------------|-----------------------------------------|
| Bath Temperature °C    | Ambient (15°C minimum)                  |
| Immersion Time mins    | No dwell time required, avoid air traps |
| Film Thickness microns | 3–5                                     |

## **BATH CONTROL AND REPLENISHMENT**

The immersion bath is controlled by measuring the viscosity. Since the bath will lose solvent by evaporation, it may be necessary to add Thinner (MP0450) to adjust the viscosity. The ready for use material is supplied at a viscosity of 30 – 34 seconds @ 23°C, measured using a 4mm ISO Flow cup.

## **DRYING**

A standard coating of Trimagard 15MB will be touch dry in about 15–30 minutes. Force drying for 20 minutes @ 80°C will accelerate the through hardening of the film. Dipped components should be drained at the best angle to avoid drips and runs, and force drying can help avoid run marks and drain points.



## **EQUIPMENT**

### **Spraying:**

All equipment should be acid and solvent resistant. Work must not be sprayed outside an exhausted spray booth.

### **Dipping:**

An acid and solvent resistant tank such as stainless steel is required, with a drain area back to the tank. The area must have good ventilation but not be subject to excessive draughts. High tank sides and a lid will reduce solvent losses.

### **Brushing:**

To coat rough surfaces such as castings, a suitable quantity of the undiluted product is decanted into an acid resistant container. Any surplus uncontaminated material should be returned to the original container.

## **ENVIRONMENTAL CONSIDERATIONS**

Trimagard 15MB is a mildly acidic liquid. Both Trimagard 15MB and Thinner (MP0450) contain VOCs. The contents are: Trimagard 15MB –900 gm/kg; Thinner (MP0450) – 850 gm/litre.

## **SAFETY**

Before use please refer to the Product Safety Data Sheet.

## **DISPOSAL**

Dispose of in accordance with local authority requirements.

## **PRODUCT FAMILIES**

The following products are referred to in this data sheet.

| PRODUCT NAME          | PRODUCT NUMBER |
|-----------------------|----------------|
| TRIMAGARD 15MB CLEAR  | MP0680         |
| TRIMAGARD 15MB GREEN  | MP0681         |
| TRIMAGARD 15MB BLACK  | MP0682         |
| TRIMAGARD 15MB RED    | MP0683         |
| TRIMAGARD 15MB YELLOW | MP0684         |
| TRIMAGARD 15MB BLUE   | MP0685         |
| T CLEANER 2           | MP0113         |
| T WIPES 2             | MP0302         |
| TRIKLONE N            | MP0301         |
| TRIMAGARD 19 THINNER  | MP0450         |

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