



TRIMAGARD 19

INTRODUCTION

A high performance self-phosphating coating that gives a black, low gloss coating on steel. It gives a thin protective coating on iron and steel, significantly increasing corrosion protection, to which most paints and powder coatings adhere well. It is supplied ready for use by dipping, spraying or brushing.

BENEFITS

- Simple process - no heating, no rinsing.
- A normal thin film (~8µm) has good corrosion resistance when stoved, and enhanced durability can be achieved by applying further coats.
- Improves the adhesion of most industrial paints and powder coatings.
- Can be air dried, force dried or stoved.

COVERAGE

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

Dip: 12–16 m² /litre of Trimagard 19
Spray-gun: 7–10 m² /litre of Trimagard 19

APPLICATION

Normal 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 19 either by:
 - a. Dip at room temperature and drain, jiggling the work to avoid trapping and secondary runs, or,
 - b. Spray a thin coat of Trimagard 19 as supplied.
 - c. Brush if other methods not possible.
3. Drain/flash off until coating is set up, then air dry, force dry or stove.



CONTROL POINTS

Viscosity (BSB4 cup 25°C)	Dip 35-55 sec, Spray 2-30 sec
Spray pressure	2.5-3.5 bar
Bath Temperature	Ambient
Immersion Time	No dwell time required, avoid air traps
Film Thickness	8–16µm

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 (MP0011) to adjust the viscosity.

DRYING

Either air dry for up to 45 mins at 18°C or warmer, before handling and up to 24 hour before assembly etc.

Alternatively flash off for 10 mins and dry at 175°C for 10 mins or 125°C for 30 mins..

EQUIPMENT

Spraying:

Normal spray guns and equipment are satisfactory using a pot pressure of 0.3-0.7 bar. Work must be sprayed in an exhausted spray booth.

Dipping:

Mild steels required with high tank sides and a lid will reduce solvent losses with a drain area back to the tank. The area must have good ventilation but not be subject to excessive draughts.

SAFETY

Before use please refer to the Product Safety Data Sheet. Trimagard 19 contains VOCs 790g/kg
FLASHPOINT

Flashpoint <21°C

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 19 BLACK	MP0486
TRIMAGARD 19 THINNER	MP0011

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