

PermaKote Plus™ Aluminum

General Purpose, Product Finishing Aluminum Enamel

SELECTION DATA

DESCRIPTION:

PermaKote Plus is a high solids, single component, solvent base, aluminum alkyd topcoat. This product has the option of adding a catalyst, that will increase chemical resistance, color retention and gloss retention. It has superior gloss, depth and clarity for most alkyd systems. It is designed for hand cleaned iron and steel SSPC-SP2 or SP3.

Intended for spray application, but where spray application is not possible, very limited brush application may provide acceptable results. It is designed HVLP air assisted airless systems but, where legal, it can be applied with conventional or airless systems.

USE:

PermaKote Plus is formulated for OEM application to misc. metal parts, decorative metal parts, and many other ferrous and nonferrous substrates where aesthetics are important.

ADVANTAGES:

- Meets 420 g/l VOC as applied.
- Can be catalyzed.
- Lead, and chromate free.
- Gloss has superior depth and clarity.
- Very sprayable viscosity at 75° F.
- Good weatherability **for an alkyd** coating.
- No 1,1,1, trichloroethane

LIMITATIONS:

- Must be recoated **before 2** hours or **after 48** hours.
- Low paint temperatures will **greatly** increase viscosity.
- Not intended for severe chemical exposure.
- Not recommended over mill scale.
- Severe exterior exposure will cause chalking and gloss loss.

PHYSICAL PROPERTIES

VOC: [as packaged] 420 g/l – (3.5 lbs./gal.)

APPEARANCE: [Gloss at 60°]

Gloss (G) 70 – 80

WEIGHT PER GALLON: [average] 10.5 lbs.

FLASH POINT: [setaflash] 81° F.

PACKAGE VISCOSITY: [#3 Zahn] 25 - 30 sec.

SOLIDS: [average]

By Weight 67 ± 2%

By Volume 50 ± 2%

COVERAGE: [average]

Theoretical at 1 mil DFT 800 sq.ft./gal.

Theoretical at 1.5 mils DFT 533 sq.ft./gal.

Required Minimum DFT 1.5 mils

DRY SCHEDULE: [at 50% RH and 1.5 mils DFT]

	45° F.	60° F.	75° F.	90° F.
Dry to Touch	3 hrs.	1½ hrs.	50 mins.	35 mins.
Handle	4½ hrs.	3 hrs.	2 hrs.	1½ hrs.
Cured	36 hrs.	30 hrs.	24 hrs.	24 hrs.
Recoat	2½ hrs.	2 hrs.	2 hrs.	2 hrs.
	Or after 48 hours which then requires deglossing the surface.			

COLOR AVAILABILITY: Aluminum

ORDER CODE: 37G798

Individual products are identified by the product series number, followed by a gloss identifier (G=gloss, S=semigloss) and ending in the color number For example, 37G798 is **PermaKote Plus** (37) gloss (G) Aluminum (798).

PACKAGING: [average]

Four ea. 1 gallon cans per case 50 lbs.

One ea. 5 gallon metal pail 62 lbs.

Continued 

TRIANGLE COATINGS, INC.

Tel: 510-895-8000

800-895-8000

Fax: 510-895-8800

TRIANGLE™



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APPLICATION DATA

SURFACE PREPARATION AND PRIMERS:

All substrates must be dry and in sound condition. Remove oil, dust, loose rust, peeling paint or other contamination to ensure good adhesion.

Steel and Iron: For maximum durability of paint system, prepare the steel for painting using iron phosphate treatment (iron phosphate preparation will enhance the adhesion of topcoat or primer to all metal surfaces) and or 900P109 primer. Minimum surface preparation should be no less than SSPC-SP3, Power Tool Cleaning. Where high performance and corrosion resistance is a requirement, Triangle's 900 Series *Envirotech EAP Premium* primer should be used.

Non-Ferrous Metal: Remove all oil, grease, dirt, oxide and other foreign material by solvent cleaning. Etch the surface and use non-chromate phosphate or wash primer prior to applying **PermaKote Plus**.

Galvanized Metal: Prime all surfaces with a water-borne acrylic primer or a two part epoxy primer. Allow paint to dry 1 week before testing adhesion to primer. If adhesion is poor, brush blasting is necessary to remove these treatments. Rusty galvanizing requires a minimum of hand tool cleaning per SSPC-SP2, then prime.

Wood: Clean surface of all contaminants. Knots and pitch streaks should be scraped or burned, sanded and spot primed before first coat of **PermaKote Plus** is applied. For interior use 291 Wood Undercoat and for exterior use 290 Alkyd Wood Primer. See Individual data sheets for application.

Concrete & Masonry: Surface should be thoroughly clean and dry. Surface temperatures must be at least 55° F. before coating. Poured, troweled, or tilt up concrete, plater mortar, etc. must be thoroughly cured for at least 30 days at 75° F. Form release compounds and curing membranes must be removed by brush blasting. Wash glazed areas and laitance with 10% muriatic acid solution and thoroughly rinse with water removing all salts. Apply one coat Triangle Aquapoxy 283.

Previously Coated: If in sound condition, clean

the surface of all foreign material. Apply a test patch to assure compatibility to the previous coating. Spot prime bare areas. If previous paint is peeling or badly weathered, clean surface to sound substrate and treat as a new surface.

CATALYZING: [Using mix ratio of 8:1]

When catalyzing is preferred use one part 500B to eight parts 37 series.

RECOMMENDED THINNING: Not required

Maximum Thinning Allowed By Regulation:

420 g/l VOC reg. None

Thinner: VM&P Naptha if allowable

APPLICATION METHOD:

This coating may be applied by conventional or airless spray application methods. Apply using crossing pattern. Heating the paint prior to application using an in-line paint heater will allow for greater atomization resulting in less orange peel.

TIP SELECTION: [@ 80° F. min.]

High Volume Low Pressure Air Assisted Airless:

Use fluid tip size011 - .013

Paint fluid pressure 1600 - 1800 psi

Air pressure to gun 75 - 80 psi

Aircap pressure 10 psi maximum

Conventional Air Spray:

Use fluid tip size040

Paint fluid pressure 10 - 15 psi

Aircap pressure 65 - 75 psi

CLEANUP SOLVENT: Lacquer Thinner

SAFETY AND HANDLING

FLASH POINT: [setaflash] 81° F. (27° C.)

SHIPPING DESCRIPTION: [CFR 49]

Ground/Air/Vessel: Paint, 3, UN1263, PG II

Required Label: FLAMMABLE LIQUID

Required Marking: PAINT UN1263

IMDG PACKAGING:

FLAMMABLE LIQUID, class 3.3, UN1263, III

IMDG STOWAGE: Category A

UNIFORM FIRE CODE: [CFR 29] CLASS I-C

STORAGE TEMPERATURE: 120° F. max.

SHELF LIFE: [warranted] 1 Year

"HMIS" RATINGS: H - 2; F - 3; R - 0; PP - H

(01/15/09)

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