

# Tripoxy™

## Two Component, Polyamide Cure, Epoxy Enamel

### SELECTION DATA

#### DESCRIPTION:

**Tripoxy 41** series is a two component (1:1 mix ratio), high solids, solvent borne, polyamide cure, high gloss, epoxy enamel with USDA approval for incidental food contact. The cured film is extremely dense and very hard without being brittle. It is impermeable and insensitive to water and is suitable for submersion service. It has excellent resistance to common solvents, all alkalis and excellent splash and spill resistance to most acids. **41** series has excellent adhesion but just adequate wetting and penetration. Like all epoxies **Tripoxy** chalks heavily with exposure to sunlight; noticeable at 6 months and complete in 12–18 months. **Tripoxy** is also available as a clear; see Data Sheet 41G900.

#### USES:

**Tripoxy** is recommended for the plant maintenance of machinery, structural steel, catwalks, rails, lining of storage tanks, metal doors, walls and floors. It is also used as an abrasion and chemical resistant floor finish for industrial concrete floors, warehouses, fire stations, garages, even residential showers. **41** series is also recommended to protect wood in constantly damp environments and as a "tile like glaze coat" for heavy wear commercial/institutional walls and doors. Such uses include jail cells, hospital walls, school corridors, gyms, public rest rooms, commercial kitchens, etc. Other uses included surfaces in meat and poultry processing plants, sulfur fume problem areas in geothermal plants, and fertilizer handling equipment. It has even been used on the lining of oyster larvae storage tanks.

#### ADVANTAGES:

- Superior performance + competitive price.
- Resists many common acids, alkalis, chemicals solvents, gasoline, fumes and many harsh chemicals. USDA approved.
- No hazards in dry state.

#### LIMITATIONS:

- Read Chemical Resistance Guide before using in areas subject to regular direct chemical contact.
- On grade concrete must have sheet type moisture barrier. If moisture can get into the slab from below any impermeable coating will fail.
- White exhibits moderate yellowing.
- Limited color selection.

### PHYSICAL PROPERTIES

**VOC:** [catalyzed @ unreduced]....394 g/l – (3.3 #/gal.)  
[Also classed as an architectural Tile Like Glaze Coat.]

**APPEARANCE:** [Gloss at 60°]

High Gloss (G) [use 41B] ..... 85 – 92  
Semigloss (S) [use 941B] ..... 45 – 60

**WEIGHT PER GALLON:** [catalyzed] ..... 12.4 lbs.

**FLASH POINT:** [setaflash][mixed] ..... 45° F.

Part A [color] ..... 81° F.

Part B [hardener] ..... 45° F.

**PACKAGE VISCOSITY:** [catalyzed] ..... 80 – 85 KU

**SOLIDS:** [catalyzed]

BY Weight ..... 73 ± 1%

BY Volume ..... 54 ± 1%

**COVERAGE:** [catalyzed]

Theoretical at 1 mil DFT ..... 869 sq.ft./gal.

Theoretical at 1.5 mils DFT ..... 579 sq.ft./gal.

Minimum DFT ..... 2 mils

Recommended DFT ..... 2 – 4 mils

**DRY SCHEDULE:** [at 50% RH and 2 mils DFT]

	45° F.	60° F.	75° F.	90° F.
<b>Tack free</b>	8 hrs.	4 hrs.	2 hrs.	1½ hrs.
<b>Rainproof</b>	24 hrs.	12 hrs.	6 hrs.	4 hrs.
<b>Light use</b>	48 hrs.	24 hrs.	12 hrs.	8 hrs.
<b>Full cure*</b>	20 days	10 days	6 days	4 days

\* Recommended prior to driving on.

#### COLOR AVAILABILITY:

**Tripoxy** is stocked in white, black and a typical industrial gray (ANSI 61). White **41** series can be tinted to pastel colors using Colortrend 844 Industrial Colorants. Clear **Tripoxy** does not accept colorants. Any non metallic color can be made with a 25 gallon minimum order.

**ORDER CODE:** ..... 41 + gloss + color #  
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, 41G633 is **Tripoxy** (41) gloss (G) Lt. Gray ANSI 70 (633). Use 941B hardener if semigloss finish is desired.

#### PACKAGING:

Four ea. 1 gallon cans per case ..... 56 lbs.

Two ea. 5 gallon metal pails ..... 132 lbs.  
[2 containers per kit – color container and hardener container.]

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## APPLICATION DATA

### REQUIREMENTS FOR APPLICATION:

- Proper curing occurs only above 50° F.
- Surfaces must be completely dry and applied **Tripoxy** must be protected from all forms of moisture until "rainproof" as per preceding chart.
- **41** series will lift alkyd enamels and primers and may soften/wrinkle latex enamels. Test a painted surface for compatibility before painting.
- New iron and steel should be abrasive blasted to SSPC-SP6 and must be blasted to SSPC-SP10 for submersion.
- **Tripoxy** can be applied over itself or similar epoxies if the existing paint is abraded to dull. However for chemical environment or submersion service, SSPC-SP10 is required.
- Concrete floors require special treatment, reference Tech. Advisory # 4 for complete review.
- Fumes are flammable; extinguish all pilot lights and open flames.

### PRIMING:

**Tripoxy** is self priming on metal, wood and concrete but requires clean, profiled, rust free metal. Significant reduction is required for proper penetration into wood and concrete. On iron and steel, epoxy primers with corrosion inhibiting pigmentation can be used for additional protection. Primers are used on sheetrock, plaster and CMU to provide a uniform gloss. On non ferrous metal and iron/steel that cannot be abrasive blasted, the use of 994P PreEtch is recommended.

### FILM DEVELOPMENT & THICKNESS:

**Tripoxy** develops its full hardness and chemical resistance at 3 mils. Heavier films attempted in one coat may cause pinhole voids. Use 2 coats on profiled iron and steel. **Tripoxy** repaints over itself in on coat. Drywall and CMU will vary significantly as to texture/profile. In shower rooms or similar constantly wet environments, 2 coats to produce a 4 mils DFT are recommended. In dry areas such as school corridors or jail cells, one coat to produce a 2 – 3 mils DFT is appropriate. Spread rates can vary from 200 – 400 sq.ft./gal. per coat.

### MIXING:

**Catalyzing:** Mix ratio is 1:1 by volume. Pour Part B into a third container. Stir Part B while adding Part A until homogenous.

**Induction Time:** 30 min. After being catalyzed,

**Tripoxy** must stand without being agitated or used for 30 minutes. Only after induction time may **Tripoxy** be thinned if necessary. Discontinue use if mixture starts to gel.

Pot Life	50°	65°	80°	95°
Time @ :	12 hrs.	8 hrs.	6 hrs.	3 hrs.

### THINNING:

**Tripoxy** cannot be thinned with solvents in VOC regulated areas. In unregulated areas use up to 5 to 10% of AT65 Thinner.

### APPLICATION:

Steel and wood are brushed or sprayed. Masonry and drywall walls and concrete floors are typically rolled. Rolling will introduce bubbles and when protection from water or chemicals is required, two or more coats are mandatory when rolling.

**Brush:** Any professional quality.

**Rolling:** ¼" mohair for smooth surfaces and ½" lambswool for CMU and/or textured walls.

**Conventional Spray:** At package viscosity, pressure feed only. Binks 18 or 2001 gun, .055 fluid nozzle @ 15 – 25 psi fluid and 80 – 90 psi air pressure.

**HVLP:** Binks BBR with a 94 nozzle or equivalent.

**Airless:** ¾ – 1 gpm; 20:1 + ratio pumps capable of sustaining +2000 psi with .019" – .021" tips.

**CLEANUP:** ..... AT17 Wash Thinner  
Rinse clear with clean AT65 Epoxy Thinner or Xylene

## SAFETY AND HANDLING

**FLASH POINT:** [Part A] ..... 81° F. (28° C.)

**FLASH POINT:** [Part B] ..... 45° F. (07° 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 3.2, UN1263, II

**IMDG STOWAGE:** ..... Category B

**UNIFORM FIRE CODE:** [CFR 29] ..... CLASS I-B

**STORAGE TEMPERATURE:** ..... 120° F. max.

**SHELF LIFE:** [warranted] ..... 1 Year

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

(11/16/01)

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