

AquaTech™

Water Reducible, Epoxy Ester Primer

SELECTION DATA

DESCRIPTION:

AquaTech Primer 945P is a single component, water reducible, non-sanding, corrosion inhibitive primer. It requires a contaminate free metal surface prepared to SSPC-SP2 or SP3 specifications. **945P** series may be air or force dried. It is designed for application by brush, HVLP air spray and HVLP air assisted airless systems but, where legal, it can be applied with conventional or airless systems.

USES:

AquaTech Primer is formulated for shop application to steel, galvanized steel and aluminum parts, equipment and structural components that require excellent protection from the elements and good impact and abrasion resistance. Typical applications include; ski lifts, bike racks, stadium seats, vehicle gas tanks and construction and farm equipment. Recommended topcoats include; water and solvent reducible alkyds, silicone alkyds, and acrylic topcoats.

ADVANTAGES:

- Meets 340 g/l VOC as applied.
- Lead, and chromate free.
- Excellent application characteristics.
- Very good flow, leveling and uniformity.
- Will not support combustion.
- Can be force dried for rapid handling and recoat.
- No 111 trichloroethane.

LIMITATIONS:

- Requires a very clean surface, minimum SSPC-SP1.
- Do not apply if surface or ambient temperature is below 48° F. (9° C.)
- Do not apply if surface temperature is above 120° F. (40° C.) or if ambient temperature is above 105° F. (49° C.)
- Air dry time varies significantly with ambient temperatures.
- Requires 24 hour dry for urethane and water reducible topcoats.

PHYSICAL PROPERTIES

VOC: [as packaged] 300 g/l – (2.46 lbs./gal.)

APPEARANCE: [gloss at 60°]

Flat 2 – 10

WEIGHT PER GALLON: [average] 10.5 lbs.

FLASH POINT: [setaflash] 150° F.

PACKAGE VISCOSITY: [#2 Zahn] 30 – 40 sec.

SOLIDS: [average]

By Weight 46 ± 1%

By Volume 31 ± 1%

COVERAGE: [average]

Theoretical at 1 mil DFT 495 sq.ft./gal.

Theoretical at 1.5 mils DFT 330 sq.ft./gal.

Required Minimum DFT 1.5 mils

DRY SCHEDULE: [at 50% RH and 1.75 mils DFT]

	45° F.	60° F.	75° F.	90° F.
Dry to Tack	1½ hrs.	30 mins.	15 mins.	10 mins.
Dry to Touch	3 hrs.	1 hrs.	35 mins.	20 mins.
Dry to Handle	12 hrs.	9 hrs.	5 hrs.	4 hrs.
Hard Cure	36 hrs.	30 hrs.	24 hrs.	24 hrs.
Min. Recoat	12 hrs.	5 hrs.	3½ hrs.	1½ hrs.

NOTE: Allow primer to dry 24 hours before topcoating with a urethane or a water reducible topcoat.

ORDER CODE & COLOR AVAILABILITY:

945P609 Gray

945P109 Red Oxide

945P710 Black

Any color can be made with 25 gallon min. order.

Individual products are identified by the product series number, followed by an identifier (P=primer) and ending in the color number For example, 945P609 is **AquaTech** (945) primer (P) Gray (609).

PACKAGING: [average]

Two ea. one gal. cans per case [UPS] 24 lbs.

Four ea. gal. cans per case [truck] 46 lbs.

One ea. five gal. metal pail 56 lbs.

Continued 

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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 in accordance with SSPC-SP6, Commercial Blast Cleaning. Minimum surface preparation should be no less than SSPC-SP2, Hand Tool Cleaning or SSPC-SP3, Power Tool Cleaning. On smooth metal, etching the surface is necessary. Iron phosphate preparation will enhance the adhesion of topcoat or primer to most metal surfaces.

Aluminum: Remove all oil, grease, dirt, oxide and other foreign material by solvent cleaning per SSPC-SP1. Etch the surface prior to applying 945P series.

Galvanized Metal: Allow to weather a minimum of 6 months prior to coating. Solvent clean per SSPC-SP1. Etch the surface prior to priming. Apply one even coat of **AquaPrime Primer**. When weathering is not possible or the surface has been treated with chromates or silicates, first solvent clean per SSPC-SP1 and apply a coat of 945P series to the area. Allow paint to dry 1 week before testing adhesion. If adhesion is poor, brush blasting is necessary to remove these treatments.

Rusty galvanizing requires a minimum of hand tool cleaning per SSPC-SP2.

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.

Previously Coated: If in sound condition, clean the surface of all foreign material. Apply a test patch to assure compatibility to the previous coating. If previous paint is peeling or badly weathered, clean surface to sound substrate and treat as a new surface.

RECOMMENDED THINNING:

This product is a water reducible primer that meets 340 g/l VOC limits. Sprayable viscosity will vary with temperature and equipment.

Brush or Roller: Thinning is not necessary

Airless Spray: Thinning is not necessary

Conventional Spray: Thin up to 5% with water if required

APPLICATION METHOD:

This coating may be applied by brush or spray application methods.

TIP SELECTION:

High Volume Low Pres. Air Assisted Airless:

Use fluid tip size011 – .013

Paint fluid pressure 600 – 650 psi

Air pressure to gun 75 – 80 psi

Aircap pressure 10 psi maximum

Conventional Air Spray:

Use fluid tip size040 – .055

Paint fluid pressure 10 – 15 psi

Aircap pressure 65 – 75 psi

High Volume Low Pressure Conventional Air:

Use fluid tip size040 – .055

Paint fluid pressure 10 – 15 psi

Air pressure to gun 75 – 80 psi

Aircap pressure 10 psi maximum

Conventional Airless

Use carbide fluid tip size .011–.015 @ 1800 psi.

CLEANUP SOLVENT:..... Water

SAFETY AND HANDLING

FLASH POINT: [setaflash] 151° F. (65.6° C.)

SHIPPING DESCRIPTION: [CFR 49]

Ground/Air/Vessel: Non Regulated Material

Required Label & Marking: Not Required

IMDG PACKAGING: Not Required

IMDG STOWAGE: Not Regulated

UNIFORM FIRE CODE: [CFR 29] CLASS III-A

STORAGE TEMPERATURE: 120° F. max.

SHELF LIFE: [warranted] 1 Year

“HMIS” RATINGS:..... H - 2; F - 2; R - 0; PP - H

(11/16/01)

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