

TRIANGLE INDUSTRIAL

Tripoxy™ Primer

Two Part, Polyamide, Epoxy Primer

941P SERIES

Part A 941P309 Primer
Part B 941B Activator

Specifications

DESCRIPTION:

Tripoxy Primer is a two part, solvent based, high performance maintenance primer. This primer uses a combination of rust inhibitors to provide outstanding corrosion protection. **Tripoxy Primer** exhibits excellent adhesion and water resistance when applied to properly prepared surfaces. This primer also exhibits good flow and leveling characteristics.

USE:

Tripoxy Primer is recommended for maintenance applications on iron, steel, galvanized, and aluminum substrates. Uses include:

- exterior structures, ferrous and nonferrous
- bridges
- power line towers
- microwave towers
- metal buildings
- structural steel components
- large fabricated structures

COLOR AVAILABILITY:

Tripoxy Primer is stocked in medium yellow.

ORDER CODE:

Part A 941P309
Part B [activator] 941B

Individual products are identified by the product series number, followed by an identifier and color number.

PACKAGING:

Part A:	Part B:
1 gallon cans	1 gallon cans
5 gallon pails	5 gallon pails

ADVANTAGES:

- Excellent primer for use with topcoats containing strong solvents, ex: urethanes, epoxies, vinyls
- Moisture and chemical resistant
- Contains no lead or chromate
- Economical cost per square foot ratio

LIMITATIONS:

- Substrate temperatures must be above 45° F
- Requires adequate ventilation in confined spaces
- Not for use in submersion applications
- Must be topcoated and protected from UV exposure

Properties

DRY SCHEDULE: [at 50% RH and 2.0 mils DFT]

	60° F	77° F	90° F
Dry to Touch	60 mins	30 mins	20 mins
Recoat	8 hrs	4 hrs	2 hrs
Dry to Handle	24 hrs	8 hrs	4 hrs
Full Cure	7 days	7 days	7 days

Critical Recoat Window: After two weeks power wash or mechanically abrade all surfaces.

VOC: [mixed] 405 g/l (3.38 lbs/gal)

FLASH POINT: [mixed] 58° F

WEIGHT PER GALLON: [mixed] 11.49 lbs

PACKAGE VISCOSITY: [mixed]

#3 Zahn @ 77° F 35

SOLIDS: [mixed]

% By Weight 71 ± 2%

% By Volume 54 ± 2%

COVERAGE: [average]

Theoretical at 1.0 mil DFT 866 sq ft/gal

Theoretical at 2.0 mils DFT 433 sq ft/gal

REQUIRED FILM THICKNESS:

ASTM D1005 Minimum Dried Film 2-3 mils

ASTM D4414 Minimum Wet Film 3.7-5.6 mils

ASTM D523 GLOSS:

@ 60° 10-15

@ 20° N/A

ASTM D3363 PENCIL HARDNESS:

H Pass

ASTM D5402 MEK RUBS:

50 Double Pass

ASTM D2794 IMPACT RESISTANCE:

60 inlb forward, 40 inlb reverse Pass

ASTM B117 SALT SPRAY RESISTANCE:

5% Salt Spray, 300 hours Pass

ASTM D5894UV CORROSION WEATHERING:

ASTM D610 Rusting 7 cycles, 300 hours Pass

ASTM D714 Blistering 7 cycles, 300 hours Pass

ASTM D4587/D523/D4214 QUV-UVA

500 hours @ 60° N/A

1000 hours @ 60° N/A

ASTM D2247/D714 HUMIDITY RESISTANCE:

800 hours Pass

ASTM D4585 MOISTURE CONDENSATION:

100° F, 800 hours Pass

ASTM D3359 ADHESION:

5B..... Pass

ASTM D4060 ABRASION RESISTANCE:

CS17 wheel, 200 cycles, 1 kg load Pass

ASTM D522 FLEXIBILITY:

180° bend, 1/8" mandrel Pass

ASTM D3170 CHIP RESISTANCE:

Rating N/A

ASTM D2485 DRY HEAT RESISTANCE:

N/A N/A

ASTM D2243 WATER-BORNE FREEZE THAW:

3 cycles N/A

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Part A **941P309** Primer
 Part B **941B** Activator

Application Data

SURFACE PREPARATION:

All surfaces must be clean, dry, and free of contaminants. All dirt, grease, rust, mill scale, or loose chalky paint must be removed in conformance with the provisions in section 59-2, "Painting Structural Steel", or Section 59-3, "Painting Galvanized Surfaces" of the State of California Department of Transportation Standard Specifications unless otherwise specified in the contract special provisions.

The retrieval and analysis of soluble salts on substrates shall be conducted in accordance with "SSPC: The Society for Protective Coatings," rule. The substrate must be cleaned so that the maximum level of soluble salts does not exceed 10 micrograms per square centimeter. Areas should be tested at the rate of 3 tests for the first 1000 square feet prepared per day, and one test for each additional 1000 square feet or portion thereof, at randomly selected locations.

When less than 1000 square feet of surface area is prepared in a shift, at least 2 tests should be performed. If levels of soluble salts exceed the maximum, the entire area represented by the test should be cleaned again and tested until soluble salt levels conform to this requirement.

Unpainted new structural steel: Blast clean near white with appropriate abrasive media. All surfaces must be clean, dry, and free of contaminants. Apply appropriate primer to the recommended dry film thickness.

- SSPC-SP1S • SSPC-SP10

Previously painted structural steel: Steam clean or power wash to remove all dirt, grease, contaminants, and gloss from existing paint. Spot clean rusty areas to remove all rust and mill scale.

- SSPC-SP1 • SSPC-SP6
- SSPC-SP2 • SSPC-SP11
- SSPC-SP3

Galvanized steel: Steam clean or power wash to remove all dirt, grease, and contaminants. Spot clean to remove rust and mill scale. Roughen surface by whip blasting or light sanding. Do not remove intact galvanizing.

- SSPC-SP1 • SSPC-SP7
- SSPC-SP2 • SSPC-SP11
- SSPC-SP3

Note: Blast cleaned surfaces must be primed the same day blast cleaning is done.

MIXING PARAMETERS:

Ratio: [Part A : Part B]
 By Weight 1 : 1
 By Volume 1 : 1

Sweat-in Time: 30 mins

ASTM D2196 Pot Life: [valid for qtys of 1 gallon or more]

50° F	60° F	77° F	85° F
4 hrs	4 hrs	4 hrs	3 hrs

APPLICATION:

Tripoxy Primer can be applied by HVLP, air assist airless, brush or roller.

HVLP:

Fluid Tip and Needle:050"
 Fluid Pressure: 8-10 psi
 Air Cap Pressure: 60 psi

Air Assist Airless:

Fluid Tip:015"
 Fluid Pressure: 800-900 psi
 Air Cap Pressure 10-15 psi

THINNING: xylene, oxsol, or acetone

CLEANUP: xylene, oxsol, or acetone

Health & Safety

WARNING:

FLAMMABLE LIQUID AND VAPOR. May be harmful if swallowed or inhaled. Vapor may affect the brain or nervous system causing dizziness, headache, or nausea and can cause nose and throat irritation. Keep away from sparks, heat, or open flames. Use with adequate ventilation. Avoid breathing of vapor. Avoid contact with eyes, skin, and clothing. Wash hands thoroughly after using and before eating and smoking. Wear an appropriate, properly fitted respirator (NIOSH/MSHA approved) during and after application unless air monitoring demonstrates vapor levels are below applicable limits. Follow respirator manufacturer's directions for use. Keep container closed when not in use. If spillage occurs, absorb and dispose of according to local regulations.

NOTICE:

Intentional misuse by deliberately concentrating and inhaling the contents may be harmful or fatal. Reports have associated repeated and prolonged occupational overexposure to solvents with permanent brain and nervous system damage.

FIRST AID:

Should eye contact occur, flush with plenty of water for at least 15 minutes and get medical attention if vision is disturbed. For skin, wash thoroughly with soap and water. If swallowed, seek medical attention immediately. **DO NOT** induce vomiting.

THIS PRODUCT IS FOR PROFESSIONAL USE ONLY.

KEEP THIS PRODUCT OUT OF THE REACH OF CHILDREN.

Shipping & Handling

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

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