

Tripoxy HB

High Build, Epoxy Primer

SPECIFICATIONS

DESCRIPTION:

Tripoxy HB is an excellent surface tolerant, high build, low VOC, two-component epoxy primer. This high performance primer is designed for ferrous and nonferrous metals (zinc, galvanizing, inorganic zinc rich, copper, and brass) where conventional primers may cause adhesion failures. This primer exhibits good flow and leveling characteristics. When used in conjunction with a two-part urethane topcoat, **Tripoxy HB** provides an extremely high performance coating system. This product can be used for immersion applications when applied to properly prepared surfaces.

USE:

Tripoxy HB is recommended for iron, steel, galvanized, or concrete. Uses include:

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

COLOR AVAILABILITY:

Tripoxy HB is stocked in buff. Custom colors available; 100 gallon minimum order is required. Special costing will be applied.

ORDER CODE: [Mix Ratio: 4 Parts A : 1 Part B, by volume]

Part A [buff] 943P309
Part B [activator] 43B

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 quart cans
5 gallon pails (4 gal full)	1 gallon cans
55 gallon drums	5 gallon pails

KITS: Containers may be partially filled.

Total Yield:	Part A:	Part B:
1.25 gallons	1 gal can	1 qt can
5 gallons	5 gal pail (4 gal full)	1 gal can

ADVANTAGES:

- Long term corrosion protection
- Surface tolerant, high build
- Very low VOC
- Contains no lead or chromate
- Low toxicity

LIMITATIONS:

- Limited use in submersion applications; requires white metal blast cleaning
- Must be topcoated and protected from UV exposure
- Limited use for tank lining. Testing required.
- **Not available in light colors; subject to yellowing**

PROPERTIES

DRY SCHEDULE: [at 50% RH and 3.0 mils DFT]

	60° F	77° F	90° F
Dry to Touch	4 hrs	2.5 hrs	60 mins
Recoat	8 hrs	6 hrs	3 hrs
Dry to Handle	11 hrs	9 hrs	6 hrs
Full Cure	7 days	7 days	7 days

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

VOC: [mixed, as supplied] 70 g/l (0.59 lbs/gal)

VOC: [mixed, excluding exempt materials] 98 g/l (0.82 lbs/gal)

FLASH POINT: [setaflash] 90° F

WEIGHT PER GALLON: [mixed] 13.5 lbs

PACKAGE VISCOSITY: [as applied]

3 Zahn Seconds 35-40

SOLIDS: [average, mixed]

% By Weight 73 ± 2%

% By Volume 65 ± 2%

COVERAGE: [average]

Theoretical at 3.0 mils DFT 346 sq ft/gal

REQUIRED FILM THICKNESS:

ASTM D1005 Minimum Dried Film 2 - 3 mils (48-72µ)

ASTM D4414 Minimum Wet Film 3 - 4.6 mils (72-111µ)

[2 wet coats are required to obtain the correct DFT]

ASTM D523 GLOSS:

@ 60° 35-40

@ 20° N/A

ASTM D3363 PENCIL HARDNESS:

3H-4H Pass

ASTM D5402 MEK RUBS:

100 Double Pass

ASTM D2794 IMPACT RESISTANCE:

60 inlb forward, 15 inlb reverse Pass

ASTM B117 SALT SPRAY RESISTANCE:

5% Salt Spray, 3,000 hours Pass

ASTM D5894UV CORROSION WEATHERING:

ASTM D610 Rusting 7 cycles, 200 hours N/A

ASTM D714 Blistering 7 cycles, 300 hours N/A

ASTM D4587/D523/D4214 QUV-UVA

500 hours @ 60° N/A

1000 hours @ 60° N/A

ASTM D2247/D714 HUMIDITY RESISTANCE:

>2,000 hours [unscribed] Pass

ASTM D4585 MOISTURE CONDENSATION:

100° F, 400 hours Pass

ASTM D3359 ADHESION:

5B Pass

ASTM D4060 ABRASION RESISTANCE:

CS17 wheel, 140 cycles, 1 kg load Pass

ASTM D522 FLEXIBILITY:

180° bend, 1/4" mandrel Pass

ASTM D3170 CHIP RESISTANCE:

Rating N/A

ASTM D2485 DRY HEAT RESISTANCE:

275° F Pass

WET HEAT RESISTANCE:

200° F Non-immersion Pass

ASTM D2243 WATER-BORNE FREEZE THAW:

3 cycles N/A

All tests conducted at 1.5-2.0 mils DFT on Bondrite™ 1000 Q-steel panels, fully cured, 7 days, air dry, at 77° F and 50% RH

Triproxy HB™

High Build, Epoxy Primer

Part A 943P309 Buff
Part B 43B 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.

Unpainted new structural steel: Blast clean commercial with appropriate abrasive media. Limit blast profile to 0.5 - 1.0 mil maximum. All surfaces must be clean, dry, and free of contaminants. Apply primer to the recommended dry film thickness.

- SSPC-SP6
- SSPC-SP11

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-SP2
- SSPC-SP3
- SSPC-SP6
- SSPC-SP11

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-SP2
- SSPC-SP3
- SSPC-SP7
- SSPC-SP11

Concrete: Clean in accordance with:

- SSPC-SP13 / NACE6

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

Submersion Applications: White blast (SSPC-SP5, NACE1) cleaning required. 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 5 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.

MIXING PARAMETERS:

Ratio: [Part A : Part B]

By Weight 6.13 : 1.00

By Volume 4 : 1

Sweat-in Time: 10 mins

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

50° F	65° F	77° F	85° F
4 hrs	4 hrs	4 hrs	3 hrs

APPLICATION:

Triproxy HB 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" - .018"

Fluid Pressure: 800-900 psi

Air Cap Pressure 10-15 psi

Brush or Roller: yes

THINNING: AT 75 as needed

CLEANUP: AT 75 as needed

Clean tools with AT 75 while **Triproxy HB** is still wet.

HEALTH & SAFETY PRECAUTIONS

WARNING: FLAMMABLE LIQUID AND VAPOR. HARMFUL VAPOR IF 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.

Contains:

Xylene, CAS# 1333-20-7

Isobutanol, CAS# 78-83-1

Formaldehyde, CAS# 50-00-0

4-chlorobenzotrifluoride, CAS# 98-56-6

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.

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.

CA PROP 65: This product contains a chemical(s) known to the state of California to cause cancer.

**THIS PRODUCT IS FOR PROFESSIONAL USE ONLY.
KEEP THIS PRODUCT OUT OF REACH OF CHILDREN.**

SHIPPING & HANDLING

SHIPPING DESCRIPTION: [CFR 49]

Ground, Air, Vessel Paint, 3, UN1263, PG III

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® III RATINGS: H - 2; F - 3; R - 0; PP - H

HMIS® III ratings are from the HMIS® Third Edition. Please refer to www.tricoat.com for complete descriptions of ratings categories.

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