

Tripoxy HB™

High Build Epoxy Coating

SELECTION DATA

DESCRIPTION:

Tripoxy HB is a high solids surface tolerant, epoxy mastic. It is an amine adduct cured epoxy with excellent chemical and water resistance. Surface tolerant coatings are intended for application to hand cleaned iron and steel. **Tripoxy HB** is recommended for application over existing, fully adherent coatings, adherent lightly rusted surfaces, and surfaces that have not been blasted. It has excellent surface wetting properties. When applied over blasted clean metal **Tripoxy HB** is recommended for submersion service in fresh, salt and waste water. It is recommended equally for interior and exterior uses but will chalk quickly with sun exposure. However, the chalk itself is UV stable and the process does not reduce service life.

USE:

Tripoxy HB was designed as a surface tolerant coating for the petrochemical industry providing corrosion protection for offshore platforms and similar high demand sites where abrasive blasting was not possible. Limited surface preparation remains the product's most important advantage. It is used on tugs, tankers, barges, bridges, tanks, pipelines, factories, etc. It is also effective on concrete, plaster and wood and withstands splash and spill exposure to most chemicals.

Tripoxy HB has two additional design uses: as a chemical resistant, high build primer for urethane finishes and as an environmentally responsible replacement for coal tar epoxies.

ADVANTAGES:

- Surface tolerant
- Does not require abrasive blasting.
- Up to 8 mil DFT in one coat.
- Amine cure and superior chemical resistance.
- Very low VOC; no chemical hazard in dry state.

LIMITATIONS:

- Check chemical resistance before using .
- Submersion service requires abrasive blasting.

PHYSICAL PROPERTIES

VOC: [catalyzed] 2.4 lb/gal.- 286 g/l.

APPEARANCE: [Gloss at 60°]

Satin (S) 25-35

WEIGHT PER GALLON: [catalyzed] 11.4 lbs.

FLASH POINT: [T.C.C. & catalyzed] 86° F.

Base (A) 95° F.

Catalyst (B) 86° F.

VISCOSITY: [catalyzed] 95 – 100 KU

SOLIDS: [catalyzed]

By Weight 80.36%

By Volume 67.51%

COVERAGE: [catalyzed]

Theoretical at 5 mils DFT 215 sq.ft./gal.

Recommended DFT 5 – 8 mils

DRY SCHEDULE: [at 50% RH and 5 mils DFT]

Without Accelerator	50° F.	60° F.	70° F.	90° F.
Dust Dry	6 hrs	4 hrs	2½ hrs	1 hrs
Handle/Rainproof	12 hrs	8 hrs	6 hrs	3 hrs
Full Cure/Emrsn.	10 days	7 days	5 days	4 days
Recoat Min. Time	24 hrs	18 hrs	14 hrs	8 hrs
Recoat Max. Time	28 days	28 days	28 days	14 days
With Accelerator	40° F.	55° F.	75° F.	90° F.
Dust Dry	10 hrs	5 hrs	2½ hrs	1¼ hrs
Handle/Rainproof	20 hrs	10 hrs	4½ hrs	3 hrs
Full Cure/Emrsn.	7 days	4 days	3 days	2 days
Recoat Min. Time	10 hrs	6¼ hrs	3½ hrs	2½ hrs
Recoat Max. Time	28 days	16 days	5 days	4 days

COLOR AVAILABILITY: (Part number format)

Series # + gloss code + color # (43S700)

700 =White; 710 =Black 630 =Gray. White Base; Midtone Base & Clear Base. Factory batch tinting is available with 25 gallon minimum orders. Allow up to 5 working days for delivery. See Triangle Industrial Color Chart for additional selections.

43B Hardener

43X1560 Accelerator

PACKAGING:

One gallon kit [2 cases]: 55 lbs.

4 ea. 102.4 fl.oz. short filled 1 gal. cans of base & 4

ea. 25.6 short filled qt. cans of hardener/ case.

Five gallon kit 62 lbs.

Four gallons in short filled 5 gallon pail of base & a full 1 gallon can of hardener.

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TRIANGLE™



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APPLICATION DATA

REQUIREMENTS FOR APPLICATION:

- Surface & ambient temperatures must be +40° F.
- **Tripoxy HB** must be +50° F. when mixing and applying.
- Non-adherent paint and rust must be removed; SSPC-SP3 is recommended.
- Surfaces must be free of visible water.
- Steel going into immersion service must be abrasive blasted to SSPC-SP10, "near white metal".
- On grade concrete slabs must have membrane type vapor barriers. If water can enter a slab from below, any coating system can peel. Reference Concrete Floors Tech Advisory for a complete review of concrete floors.
- Use only with adequate ventilation. Applicators must wear NIOSH approved respirators.

PRIMING:

Tripoxy HB is self priming on metal surfaces.

FILM DEVELOPMENT & THICKNESS:

Dry film thickness is a function of use. Number of coats is a function of usage and method of application.

Use	DFT	Coats
<i>Normal maintenance</i>	5 mils	1
<i>Chemical environment</i>	7 – 8 mils	1 or 2
<i>Submersion</i>	10 mils	2
<i>Use as a primer</i>	5 – 8 mils	1

With airless spray one coat application to 10 mils DFT is possible in one coat. When rolling two or more coats are necessary. Maximum DFT per coat rolling is 5. Normal DFT brushing is 3 mils.

THINNING:

Tripoxy HB is designed for use at package viscosity. A slight reduction may be advantageous when brushing or spraying with undersized pumps but otherwise is not recommended. When necessary, reduce with epoxy reducer after **Tripoxy HB** is properly catalyzed. Thinning is not legally permissible when it is necessary to meet a 240 g/l (2.0 lbs./gal.) VOC requirement. Maximum reduction to meet 340 g/l (2.5 lbs./gal.) is 11 fl.oz. of xylene per gallon; the maximum recommended reduction for any purpose is 10% or 12 fl.oz./gal.

MIXING:

The liquid material should be +50° F. during mixing.

Stir A Component to uniform consistency. Add B to A in prepackaged kit ratio only. Use a mechanical mixer and mix for minimum 4 minutes. After mixing, **Tripoxy HB** is ready for use, or reduction and use. *There is no induction time.*

Ratio: Base to hardener 86 : 14 by weight
 Base to hardener 4 : 1 by volume

POT LIFE: [valid for quantities of 1 gal or more]

50° F.	65° F.	75° F.	85° F.	95° F.
12 hrs.	6 hrs.	4 hrs.	3 hrs.	1 hr.

APPLICATION:

Tripoxy HB must be catalyzed prior to use. **Tripoxy HB** is designed for one coat application using airless spray, air-assisted airless, but can be applied using brush, roller, or conventional spray.

Brush to pre-stripe welds, bolt heads, outside corners and similar difficult or sensitive areas. Brush to cutin or touch up. Use any professional quality brush. Roll using ½" lambswool covers and a heavy duty frame. Spread uniformly. Cross roll or scrub as necessary to ensure complete coverage; lay off in one direction only. Use moderately heavy pressure on the roller throughout. Use airless spray whenever feasible. Use 2 gpm pumps with a 30:1 ratio. Use max. 100' ¾" I.D. material hose with an optional ¼" I.D. whip. .017 tip @ 2400 psi is recommended. Hold gun 90° to surface at all times. Overlap passes 10%.

CLEANUP: Xylene

SAFETY AND HANDLING

FLASH POINT: [T.C.C.] Part A 90° F. (32° C.)
 Part B 86° F. (30° 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 B

UNIFORM FIRE CODE: [CFR 29] CLASS II

STORAGE TEMPERATURE: 120° F. max.

SHELF LIFE: [warranted] 1 Year

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

(11/21/01)

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