

# Permakote FD

## Fast Dry, Gloss OEM Enamel

### SELECTION DATA

#### DESCRIPTION:

**PermaKote FD, 30G series**, is a FAST air dry general purpose, modified alkyd industrial enamel. It has good gloss and abrasion resistance for original equipment product finishing. **30G** series is designed for spray or dip application to primed surfaces but can be applied directly to clean iron and steel or previously painted surfaces that have been abraded to dull.

#### USE:

Primary design use is the OEM finishing of industrial iron and steel. **30G** is also used as an OEM finish on larger air dried iron and steel fabrications, structural steel, doors, storage tanks, farm and construction equipment, hand rails, patio furniture, cabinets, shelving, railings, tanks, machinery, trailers, poles, table tops, utility equipment, piping, etc.

#### ADVANTAGES:

- Very sprayable viscosity at 75° F.
- Excellent water/weather resistance and protection for iron, steel and wood.
- Superior wetting provides secure adhesion & forgiving application.

#### LIMITATIONS:

- Low temperatures will *greatly* increase viscosity.
- This product is for industrial use and may not conform to air quality regulations for use on architectural surfaces.
- No corrosion inhibiting pigmentation; direct application to iron and steel does not provide resistance to "undercutting" from scraped or otherwise bare metal.
- Wood and galvanized must be primed.
- Not recommended for surfaces subject to continuous submersion or direct contact with chemicals.
- All alkyds chalk with exterior exposure; normal gloss retention is some chalking after 18 – 24 months, chalking to flat with 4 – 5 years full exposure, loss of film integrity at 5 – 7 years.
- Compatible with 500B urethane hardener.

### PHYSICAL PROPERTIES

**VOC:** [as packaged] ..... 274 g/l – (2.2 lbs./gal.)

**APPEARANCE:** [Gloss at 60°]

Gloss (G)..... Above 80

**WEIGHT PER GALLON:** [average]..... 9.2 ± 0.5 lbs.

**FLASH POINT:** [setaflash] ..... -4° F.

**PACKAGE VISCOSITY:**..... 75 – 80 KU

**SOLIDS:** [average]

By Weight..... 39 ± 1 %

By Volume..... 36 ± 1 %

**COVERAGE:** [average]

Theoretical at 1 mil DFT ..... 577 sq.ft./gal.

Theoretical at 1.5 mils DFT ..... 384 sq.ft./gal.

Required Minimum DFT ..... 1.5 – 2 mils

**DRY SCHEDULE:** [at 50% RH and 1.5 mils DFT]

	45° F.	60° F.	75° F.	90° F.
<b>Touch</b>	1 hrs	30 mins	20 mins	10 mins
<b>Handle</b>	6 hrs	4 hrs	3 hrs	2 hrs
<b>Max Recoat*</b>	4 hrs	3 hrs	2 hrs	1 hrs
<b>Hard Cure</b>	7 days	6 days	5 days	4 days

\*[If recoat window exceeds "Max Recoat" time, wait over night to recoat.]

#### COLOR AVAILABILITY:

**30G** series is packaged in a full line of bases designed for field or store tinting with 844 "Industrial" (solvent only) Colorants. Factory batch production available with min. 30 gallon orders. All colors are lead and chromate free.

**ORDER CODE:** ..... 30 + gloss + color #  
Individual products are identified by the product series number, followed by a gloss identifier (G=gloss) and ending in the color number. For example, 30G700 is (30 series) gloss (G) white (700).

**PACKAGING:** [average]

Four ea. 1 gallon cans per case ..... 50 lbs.

One ea. 5 gallon metal pail ..... 60 lbs.

Continued 

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## APPLICATION DATA

### REQUIREMENTS FOR APPLICATION:

- Surface and ambient temperatures must be between 42° F. and 95° F. and minimum 5° F. above dewpoint for normal application. Special procedures required from 28° F. to 42° F. and 95° – 115° F. Secure procedures from Triangle representative.
- Surfaces must be free of moisture, corrosion (flash rust OK), oils, loose paint, dirt, all forms of silicone, waxes, etc. SSPC-SP1, SP2 or SP3 as minimum.
- Performance over mill scale cannot be predicted. All scale should be removed.
- Enamelled surfaces must be abraded to dull.

### PRIMING:

Iron & Steel ..... 900 Series Primer  
Galvanized ..... 941 Primer

### FILM DEVELOPMENT:

Optimum dry film thickness is 1.5 mils per coat. Use one coat over primed or previously painted surfaces, two or more coats over bare metal. However, without reduction it is difficult to apply VOC compliant alkyds that thin. Typical, acceptable DFTs range between 1.75 and 2.0 mils. Maximum recommended wet film thickness is 4 wet mils unreduced or 2 mils DFT. Thicker films surface dry, are less durable and have no benefit. Unreduced, **30G** series applied at 370 sq.ft./gal. over smooth, sealed surfaces will produce a 1.50 mil DFT and allow for 3% waste (1.75 mils DFT = 320 sq.ft./gal.).

### RECOMMENDED THINNING:

No thinning is required. If thinning is required when this product is used in very cold environments, thin with up to 10% reduction.  
VOC regulations vary by state and county. Contact Triangle representatives directly for guidelines and recommendations.

### APPLICATION:

**30G** series is designed spray application. Apply as necessary for complete coverage and finish with light vertical strokes. Use airless spray for large surface maintenance, and conventional, HVLP or air assist airless for shop finishing. HVLP or con-

ventional for field finishing. NIOSH respirators, hoods and gloves are recommended when spraying.

**Airless:** 1/3 gpm pumps or larger; .013 – .015 tips.

**Air Assist Airless:** Maximum fluid pressure possible to 2,000 psi; .011" tip and air pressure as necessary to eliminate tails or orange peel.

**HVLP:** .040" – .055" fluid nozzles (1.0 – 1.4 mm), fluid, pressure as needed for 6" stream without air cap, air to gun 60 – 80 psi and 16 – 18 CFM, air cap pressure, 10 psi.

**Conventional Spray:** Fluid nozzle .040" – .050"; air cap appropriate for available air, feed (pressure or siphon) and spray viscosity. Typical psi with pressure feed. 20 – 40 fluid, 60 – 80 air.

**CLEANUP:** ..... AT17 Wash Thinner  
Rinse with mineral spirits. Xylene or lacquer thinner can be substituted for AT17.

## SAFETY AND HANDLING

**FLASH POINT:** [setaflash] ..... -4° F. (-20° 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

(12/05/01)

**WARRANTY:** The statements made herein, on labels, product bulletins, or by any of Triangle Coatings', Inc. employees or agents concerning this product are given for general information only. Due to variables beyond Triangle's control in application, surface preparation, surface temperature, humidity and other variable factors Triangle assumes no liability for any claim that may arise out of the use of its products and disclaims any warranty expressed or implied relating to the storage, application, thinning, merchantability, Buyer's assumption of performance, and the fitness for a particular purpose. Receipt of products from Triangle or its agents constitutes acceptance of the terms of this warranty. In the event that Triangle finds that the product delivered is not of Triangle's standard quality, Triangle will at its sole discretion, either replace the product or refund the purchase price. Triangle's choice of one of these remedies shall be the Buyer's sole remedy. Triangle will under no circumstances be liable for consequential damages, except insofar as liability is mandated by law. Triangle will deliver products at agreed times insofar as it is reasonably able to do so, but it will not be liable for failure to deliver on time when the failure is beyond its reasonable control.