

# TriPrime™

## Fast Dry, Corrosion Inhibiting, Recoatable "Work Horse" Primer

### SELECTION DATA

#### DESCRIPTION:

**TriPrime** is a high solids, solvent reducible, corrosion inhibitive, very fast drying primer for iron and steel. It is designed for shop and OEM application and for use under all typical finishes including polyurethanes. It is designed for hand cleaned iron and steel SSPC-SP1, SP2 or SP3. It provides active corrosion inhibition and protection against undercutting. It is designed for HVLP and air assisted airless systems but, where legal, it can be applied with conventional or airless systems. Thinning is required for most systems; see instructions under "Recommended Thinning". Recommended Topcoats include: alkyd, silicone alkyd and acrylic finishes.

#### USE:

Typical applications include; construction and industrial equipment, structures, boxes and utility parts.

#### ADVANTAGES:

- Compatible with epoxies and similar topcoats that may lift other primers.
- 902P710 (black) may also be used as a finish for wrought iron.
- Excellent corrosion inhibition.
- No critical recoat window.
- Very fast dry.

#### LIMITATIONS:

- Requires 111 Trichloroethane for thinning in VOC regulated areas.
- Requires clean steel.
- Contains zinc chromate pigments.

### PHYSICAL PROPERTIES

**VOC:** [as packaged] ..... 332 g/l – (2.77 lbs./gal.)

**APPEARANCE:** [Gloss at 60°]

Flat ..... 2 – 7

**WEIGHT PER GALLON:** [average] ..... 12.9 lbs.

**FLASH POINT:** [setaflash] ..... 60° F.

**PACKAGE VISCOSITY:** ..... 72 – 78 KU

**SOLIDS:** [average]

By Weight ..... 79 ± 1%

By Volume ..... 63 ± 1%

**COVERAGE:** [average]

Theoretical at 1 mil DFT ..... 1010 sq.ft./gal.

Theoretical at 1.5 mils DFT ..... 673 sq.ft./gal.

Required Minimum DFT ..... 2 mils

**DRY SCHEDULE:** [at 50% RH and 2 mils DFT]

	45° F.	60° F.	75° F.	90° F.
<b>Tack Dry</b>	45 mins.	20 mins.	10 mins.	7 mins.
<b>Dry to Touch</b>	2 hrs.	45 mins.	30 mins.	20 mins.
<b>Dry to Handle</b>	5 hrs.	3 hrs.	2 hrs.	1½ hrs.
<b>Hard Cure</b>	36 hrs.	30 hrs.	24 hrs.	22 hrs.
<b>Recoat * 1</b>	50 mins.	20 mins.	10 mins.	7 mins.

\*After 1 week wash clean of all foreign matter. 1 Light sanding may be necessary if cured coating is subject to exterior exposure for extended periods.

#### ORDER NUMBER AND COLOR:

902P609 (AF-7) ..... Gray

902P109 (144-52) ..... Red Oxide

902P710 (B385E) ..... Black

Individual products are identified by the product series number, followed by an identifier P=primer) and ending in the color number For example, 902P109 is **TriPrime** (902P) primer (P) Red Oxide (109).

**PACKAGING:** [average]

Four ea. 1 gallon cans per case ..... 55 lbs.

One ea. 5 gallon metal pail ..... 67 lbs.

Continued 

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TRIANGLE™



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Fast Dry, Corrosion Inhibiting, "Work Horse" Recoatable Primer

## APPLICATION DATA

### SURFACE PREPARATION:

TriPrime series primers are designed for use over hand cleaned iron and steel, SSPC-SP1, SP2 or SP3.

- Surface and ambient temperatures must be above 45° F. Recommended maximum surface temperature is 120° F. Temperatures above 95° F. may require the use of a "slow" solvent. Contact Triangle and AQMD, if necessary, for advice.
- Surfaces must be 100% free of all contaminants except small amounts of fully adherent rust. All loose and scaling material, grease, oils, asphalt, silicones, dirt, dust, chemical contaminants and moisture must be removed.
- Existing paint should be removed, SSPC-SP2. Completely sound paint may be left, but service life of new system will become that of the existing paint and that will be less than new products alone.
- Temperatures must be +5° F. above dewpoint. Fresh primer must be protected from all moisture until rainproof as per chart above.

### REQUIRED THINNING:

Designed for 25 – 30% reduction with 111 trichloroethane in VOC regulated areas and xylene in unregulated areas. Before using 111 trichloroethane, check restrictions on its use.

#### Maximum Thinning Allowed By Regulation:

340 g/l ..... 0 fl. oz. /gallon  
420 g/l ..... Thin up to 22 fl. oz. /gallon

**Thinner:** ..... 111 Trichloroethane or Xylene  
Brush or Roller: ..... Thin as required  
Airless Spray: ..... Thin as required  
Conventional Spray: ..... Thin as required

### APPLICATION METHOD:

This coating may be applied by conventional or airless spray application methods. Apply using crossing pattern.

### TIP SELECTION:

#### High Volume Low Pressure Air Assisted Airless:

Use fluid tip size ..... .011 - .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 size ..... .040 - .055  
Paint fluid pressure ..... 10 - 15 psi  
Aircap pressure ..... 65 - 75 psi

#### High Volume Low Pressure Conventional Air:

Use fluid tip size ..... .040 - .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.

#### Electrostatic Equipment:

Consult Triangle representative.

**CLEANUP SOLVENT:** ..... Xylene or Toluene

## SAFETY AND HANDLING

**FLASH POINT:** [setaflash] ..... 60° F. (15° 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

(11/16/01)

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