

Tripoxy™ Primer

Two Component Polyamide Epoxy Primer for Steel and Iron

SELECTION DATA

DESCRIPTION:

Tripoxy Primer, 941P309 is a two part, VOC compliant, relatively thin film polyamide cure epoxy primer for iron and steel. **Tripoxy Primer** uses zinc chromate as a corrosion inhibiting pigment. Corrosion prevention is superior combining epoxy's water resistance with the active electrochemical protection of zinc chromate. Hardness, general durability and adhesion are also excellent. **941P309** is designed to provide optimum protection in a relatively thin film of 1 – 2 mils and for a primer have good flow and leveling. For a hard drying primer **Tripoxy Primer** provides a smooth, orange peel free finish. It uses a traditional 1:1 mix ratio.

USE:

Tripoxy Primer was formulated as an OEM primer for iron and steel fabrications going into corrosive environments: racking and structural steel for canneries, pulp plants, waste water facilities, sulfur fume problem areas, geothermal plants, and fertilizer handling equipment. Because of its relatively thin film and leveling, **941P309** may not be well suited for some industrial maintenance. However, these properties make it an excellent choice for heavy use vehicle maintenance: priming truck trailers, stationary military field equipment, fixed field equipment such as pump housings. It is suitable for submersion but with the zinc chromate pigmentation, use on inland lakes, rivers and reservoirs may be regulated. It is ideal on gates, pipes and pumps used for industrial waste with a pH 5 to 12.

ADVANTAGES:

- It is an excellent base coat for topcoats such as two part epoxies, two part urethanes, and vinyls.
- Resists corrosion on ferrous metal surfaces better than amine-cured epoxies.
- Has excellent resistance to moisture, abrasion, weather, acids, alkalis, and other chemicals.
- Inexpensive: competitive price and thin film.
- Produces a good finish, minimal orange peel.

LIMITATIONS:

- Contains zinc chromate, heavy metal hazard.
- Cannot be applied above 2 mils per coat. Sags above 4 wet mils, risk of solvent entrapment above 5 mils (horizontal pieces).
- Normal limitations of 2 part epoxy: temperature sensitive drying, need to catalyze & clean up, etc.
- Minimum surface temperature for curing is 50° F.
- Only for trained, professional applicators.

PHYSICAL PROPERTIES

VOC: [as packaged & mixed] ... 415 g/l – (3.41 lbs./gal.)

APPEARANCE: [Gloss at 60°]

Flat 7 – 15

WEIGHT PER GALLON: [mixed] 10.85 lbs.

FLASH POINT: [setaflash]

Part A 68° F.

Part B 63° F.

PACKAGE VISCOSITY: [mixed] 90 – 100 KU

SOLIDS: [mixed]

By Weight 66 ± 1%

By Volume 51 ± 1%

COVERAGE: [mixed]

Theoretical at 1 mil DFT 818 sq.ft./gal.

Recommended DFT 1 – 2 mils

DRY SCHEDULE: [at 50% RH and 1 mil DFT]

	45° F.	60° F.	75° F.	90° F.	150° F. ¹
Tack Free	3 hrs.	1 hrs.	30 mins.	25 mins.	25 mins.
Recoat ²	24 hrs.	8 hrs.	4 hrs.	3 hrs.	1½ hrs.
Full Cure	32 days	16 days	8 days	6 days	2 days

¹ Force cured at 150° F.

² Rainproof and recoat occur at the same time. Recoat window closes at 3 days in warm weather and at 5 in cooler weather.

COLOR AVAILABILITY:

Dull medium chrome yellow only

ORDER CODE:

Part A Zinc Chromate Yellow 941P309

Part B Catalyst 941B

Individual products are identified by the product series number, followed by an identifier (P=primer) and ending in the color number For example, 941P309 is **Tripoxy** (941) Primer (P) Yellow Oxide (309).

PACKAGING:

One gallon kits [total wt. for 2 cases] 100 lbs.

Four each full fill 1 gallon cans of Part A & four each full fill gallon cans of Part B.

Five gallon kit [total for 2 fives] 120 lbs.

One each full fill 5 gallon pail of Part A & a full fill 5 gallon pail of Part B.

Continued 

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TRIANGLE™



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APPLICATION DATA

REQUIREMENTS FOR APPLICATION:

- Both the surface and ambient temperatures must be above 50° F. at application and for a minimum of 24 hours after application.
- Surfaces to be painted must be abrasive blasted or hand cleaned with a tool using impact or a very coarse grinder to produce a contaminant free surface with minimum 1 mil profile that meets the general requirements of SSPC-SP7.
- Surfaces going into severely corrosive environments must meet SSPC-SP6 as a minimum.
- Surfaces going into submersion service must meet minimum SSPC-SP10 near white blast .

FILM DEVELOPMENT & THICKNESS:

Tripoxy Primer is designed for application at 1 mil DFT. Technically, there is no limit to the number of coats that can be applied, the maximum number that is recommended and cost efficient is 2. If a very high build is necessary, a non chromated, high build intermediate coat is more cost efficient.

MIXING:

Catalyzing: Mix ratio is 1:1 by volume using 941B.

Pour Part B into a third container. Stir Part B while adding Part A until homogenous.

Induction Time: 30 min. After being catalyzed, **Tripoxy Primer** must stand without being agitated or used for 30 minutes. Only after induction time may **941P309** be thinned if necessary. Discontinue use if mixture starts to gel.

Pot Life	50°	65°	80°	95°
Time @ :	12 hrs.	8 hrs.	6 hrs.	3 hrs.

THINNING:

Tripoxy Primer is designed for application at package viscosity. It cannot be reduced in VOC regulated areas. In unregulated areas, xylene is the recommended reducer. Even in unregulated areas, reduce carefully due to product's low sag point. In regulated areas exempt solvents exist that will effectively reduce **941P309** and are accepted by most AQMD's. Contact Triangle for technical advice and the appropriate AQMD for the current regulation.

APPLICATION:

Tripoxy Primer is designed for application by conventional spray. Initial dry is too fast to allow large

areas to be brushed. Brushing is used to spot prime, pre-stripe difficult or vulnerable areas like sharp edges, touch up welds or bolt heads and paint small areas. If reducing is permitted, a 10% reduction with a slow solvent should make it possible to brush larger areas, pipes, wheel rims, etc. Airless spray is not recommended. Air assist airless should work but its use would require careful monitoring of film thickness.

Conventional Spray: .045" – .055" fluid nozzles with an air cap sized for feed and available air. Relatively high pressures are recommended, 25 to 35 psi fluid and 75 – 85 psi air.

HVLP: Pressure only, Binks 92 or 94, .045" and .055", nozzle with fluid pressure at whatever produces a 6" fluid stream with no air. Use maximum legal air pressure.

Air Assist Airless: .013" tip with maximum fluid pressure to 2000 psi and air as necessary to produce a proper fan. Apply with careful attention to film build. Trigger off and on when reversing pass direction, do each component of an inside corner separately with vertical passes, etc.

CLEANUP: AT17 Wash Thinner
Rinse tools with clear xylene. Recommend distilling or settling and decanting clean up solvent. Dry residue is hazardous waste. Dispose using professional service or into approved/designated facility.

SAFETY AND HANDLING

FLASH POINT: [setaflash] 63° F. (16° 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, MIXED: H - 3; F - 3; R - 1; PP - H

(12/27/01)

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