

**TRIANGLE INDUSTRIAL****TriBake W™****Production Baking Finish Topcoat****Specifications****DESCRIPTION:**

**TriBake W** is a water based baking finish. This product was formulated for fast cure using low oven temperatures. **TriBake W** is an extremely hard (3H), impact, abrasion, and chemical resistant, flexible coating. This product has very good gloss and color retention on exterior exposure. **TriBake W** provides a corrosion resistant, water resistant, durable baking finish.

**USE:**

**TriBake W** is designed for direct application to properly prepared metal surfaces. This is a heat cured coating; application is limited to production lines and job shops. This product is an excellent choice for steel shelving, appliance finishing, drum coating, aluminum extrusion and miscellaneous metal parts.

**ADVANTAGES:**

- Very fast cure
- Extremely durable and abrasion resistant
- Cost effective

**LIMITATIONS:**

- Will not air dry; for baking only
- Must be applied to properly prepared metal surfaces
- Requires corrosion resistant primer for long term salt spray resistance
- Six month shelf life

**Properties**

**VOC:** [as packaged] ..... 250 g/l – (2.1 lbs/gal)

**FLASH POINT:** [setaflash]..... >200° F

**APPEARANCE:**

Gloss (G) @ 60° ..... 85-90+

**WEIGHT PER GALLON:** [average] ..... 11.0 lbs

**PACKAGE VISCOSITY:** [#3 Zahn] ..... 25-30 sec

**SOLIDS:** [average]

By Weight ..... 69 ± 10%

By Volume ..... 54 ± 10%

**COVERAGE:** [average]

Theoretical at 1.5 mils DFT ..... 584 sq ft/gal

Required Minimum DFT ..... 1.5 mils

**BAKING SCHEDULE:**

325°F (metal temperature) ..... 15 min

**COLOR AVAILABILITY:**

**TriBake W** is available in factory stock colors. Triangle stocks safety and traditional implement colors. Many colors may be tinted, however, special costing will be applied.

**ORDER CODE:** ..... 20 + gloss + color #

Individual products are identified by the product series number, followed by a gloss identifier and color number.

Ex: 20G632 is TriBake W, Gloss, Med. Gray ANSI 61

G = gloss

S = semi-gloss

M = matte

F = flat

**PACKAGING:**

Four 1 gallon cans per case

5 gallon pails

55 gallon drums

250 gallon totes

# TriBake W™

## Production Baking Finish Topcoat

### Application Data

#### SURFACE PREPARATION:

- Surfaces to be coated must be clean, dry, and free of oil, grease, dust, flaky rust, mill scale, and other foreign matter that could interfere with adhesion.
- Recommended surface preparation includes iron phosphate, zinc phosphate, and surface blasting that removes all mill scale.

#### RECOMMENDED PRIMERS:

Consult your Triangle Coatings representative.

#### APPLICATION:

Apply **TriBake W** using HVLP, air-assisted airless, or airless.

#### HVLP:

Fluid Tip and Needle: .....030 - .045"  
Fluid Pressure: ..... 10 - 15 psi  
Pressure pot application is recommended

#### Air Assist Airless:

Fluid Tip:.....013 - .015"  
Fluid pressure: ..... 800 - 1,200 psi  
Air Cap Pressure: ..... 10 psi

#### Airless:

Fluid Tip:.....013 - .015"  
Fluid Pressure: ..... 2,000 - 2,500 psi

THINNING: .....none

CLEANUP: .....water

### Health & Safety

#### WARNING:

COMBUSTIBLE LIQUID AND VAPOR. May be harmful if swallowed or inhaled. Vapor may affect the brain or nervous system causing dizziness, headache or nausea and can cause nose and throat irritation. Liquid contact with eye and skin causes 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.

#### 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.

#### 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.

**THIS PRODUCT IS FOR PROFESSIONAL USE ONLY.**

**KEEP THIS PRODUCT OUT OF THE REACH OF CHILDREN.**

### Shipping & Handling

#### SHIPPING DESCRIPTION: [CFR 49]

Ground, Air, Vessel ..... Non Regulated Material  
Required Label & Marking ..... Not Required

IMDG PACKAGING: ..... Not Regulated

IMDG STOWAGE: ..... Not Regulated

UNIFORM FIRE CODE: [CFR 29] ..... CLASS III-B

STORAGE TEMPERATURE: ..... 120° F max

SHELF LIFE: [warranted] ..... 6 MONTHS

HMIS RATINGS: ..... H - 1; F - 1; R - 0; PP - H

**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.