

TRIANGLE INDUSTRIAL

PermaKote S™

Product Finishing Topcoat

Specifications

DESCRIPTION:

PermaKote S is a semi-high solids, solvent based topcoat. This topcoat exhibits very good adhesion to properly prepared ferrous metals. **PermaKote S** has a very high gloss and DOI. This product has a fast hard dry and early water resistance. **PermaKote S** has the option of adding a hardener to increase chemical resistance, color and gloss retention.

USE:

PermaKote S was formulated for use on ferrous metal parts, not requiring special chemical or extreme abrasion resistance. It is an excellent choice as a topcoat for heavy construction equipment, off-road vehicles, architectural components, farm implement parts, and other miscellaneous metal parts.

ADVANTAGES:

- Extremely smooth surface
- Fast dry
- Very high gloss and DOI
- Good surface hardness and scratch resistance
- Can be catalyzed

LIMITATIONS:

- Formulated for spray application
- Not recommended for submersion below grade, or direct chemical contact service
- Requires corrosion resistant primer for long term salt spray resistance

Properties

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

FLASH POINT: [setaflash]..... >80° F

APPEARANCE:

Gloss (G) @ 60°85-90+

WEIGHT PER GALLON: [average] 11.0 lbs

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

SOLIDS:

By Weight69 ± 10%

By Volume54 ± 10%

COVERAGE:

Theoretical at 1.5 mils DFT 584 sq ft/gal

Required Minimum DFT 1.5 mils

DRY SCHEDULE:

	45° F	60° F	75° F	90° F
Dry to Touch	2 hrs	1 hrs	30 mins	15 mins
Handle/Recoat	5 hrs	2 hrs	1 hrs	45 mins
Full Cure	7 days	7 days	7 days	5 days

After 1 week, light sanding may be necessary if cured coating is subject to exterior exposure for extended periods.

COLOR AVAILABILITY:

PermaKote S 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:

..... 37 + gloss + color #

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

Ex: 37G632 is PermaKote S, 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

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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.
- Wood and galvanized metal must be primed

RECOMMENDED PRIMERS:

- 955P TriPrime S
- 956P TriBond S
- 954P ShopCoat S

Consult your Triangle Coatings representative for water based primer recommendations.

APPLICATION:

Apply **PermaKote S** using HVLP, air-assisted airless, or airless. **PermaKote S** has the option of adding a catalyst. When catalyzing, refer to mixing instructions and pot life limitations below.

Ratio: [base:hardener]
 By Weight.....
 By Volume..... 7:1

Pot Life: [valid for quantities of 1 gallon or more]

50°F	65° F	75°F	85° F	95° F
12 hrs	8 hrs	5 hrs	4 hrs	2 hr

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: solvent

Health & Safety

WARNING:

FLAMMABLE 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. Keep away from sparks, heat or open flame. Use with adequate ventilation. Avoid breathing of vapor. Avoid contact with eyes, skin, and clothing. 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 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 Paint, 3, UN1263, PG III
 Required Label FLAMMABLE LIQUID
 Required Marking PAINT UN1263

SMALL QUANTITY SHIPMENTS ORM-D-PAINT

IMDG PACKAGING:

FLAMMABLE LIQUID, class 3.3, UN1263, III

IMDG STOWAGE: Category A

UNIFORM FIRE CODE: [CFR 29] CLASS I-C

STORAGE TEMPERATURE: 120° F max

SHELF LIFE: [warranted] 1 YEAR

HMIS RATINGS: H - 2; F - 3; 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.