

TRIANGLE INDUSTRIAL**TriBond S™****2-Part, Fast Dry, Epoxy Primer****Specifications****DESCRIPTION:**

TriBond S is a semi-high solids 2 part, epoxy primer. This primer has a very short recoat time. **TriBond S** bonds extremely well to properly prepared iron phosphate and blasted surfaces. **TriBond S** can be applied over zinc galvanizing, inorganic zinc and adheres well to most other non-ferrous metal surfaces. Corrosion resistance, water resistance, adhesion and general durability are excellent.

USE:

TriBond S was designed as a fast recoat primer for spray applications. Primarily used by job shops and metal part manufacturers as an extremely high performance corrosion resistant primer. It is an excellent choice for heavy construction equipment, off-road vehicles, truck priming, and light rail applications. **TriBond S**, when used with high performance topcoats, provides a total system that yields 3,000+ hours salt spray results. Recommended topcoats include: urethanes, epoxies, acrylics, silicone alkyds, and alkyds.

ADVANTAGES:

- Compatible with epoxy, urethane, and vinyl strong solvent topcoats
- Very fast dry
- Good adhesion and protection for ferrous and non-ferrous substrates
- Excellent resistance to moisture, abrasion, acids, alkalis, and other chemicals
- Good one pass film development
- Limited below grade use; contact Triangle for more information regarding application

LIMITATIONS:

- Not for immersion
- Not for exterior exposure
- Requires adequate topcoat film build to prevent epoxy deterioration and topcoat delamination

Properties

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

FLASH POINT: [T.C.C. & catalyzed] >80° F

APPEARANCE:

Gloss (G) @ 60° 20-30

WEIGHT PER GALLON: [catalyzed] 13.1 lbs/gal

VISCOSITY: [catalyzed, #3 Zahn] 25 ± 5 sec

SOLIDS: [catalyzed]

By Weight 80 ± 10%

By Volume 68 ± 10%

COVERAGE: [catalyzed]

Theoretical at 2.0 mils DFT 545 sq ft/gal

Recommended DFT 2.0 - 5.0 mils

DRY SCHEDULE: [at 50% RH and 2.0 mils DFT]

	45° F	60° F	75° F	90° F
Dry to Touch	2 hrs	20 mins	10 mins	5 mins
Recoat	50 mins	45 mins	30 mins	15 mins

Maximum Recoat: 5 days

After maximum recoat dry time, **TriBond S** must be checked for topcoat adhesion.

COLOR AVAILABILITY:

Red Oxide (color will shift between batches)

Buff (approximately yellow oxide)

PACKAGING:

Four 1 gallon cans per case

5 gallon pails

55 gallon drums

250 gallon totes

TriBond S™

2-Part, Fast Dry, Epoxy Primer

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.

APPLICATION:

TriBond S is best applied with air assisted airless, airless, or HVLP. **TriBond S** is a 2-part epoxy, and requires both parts be mixed together to initiate cure.

Ratio: [base:hardener]
 By Weight..... 80:20
 By Volume..... 3:1

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

50°F	65° F	75°F	85° F	95° F
8 hrs	4 hrs	2.5 hrs	2 hrs	1 hr

Air Assist Airless:

Fluid Tip012" - .013"
 Fluid Pressure 900 - 1,400 psi
 Air Cap Pressure 10 psi

Airless:

Fluid Tip013" - .015"
 Fluid Pressure 2,000 - 2,500 psi

HVLP:

Fluid Tip and Needle030" - .040"
 Fluid Pressure 10 - 15 psi
 Air Cap Pressure 60 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

FLASH POINT: [T.C.C.]

Part A >80° F (35° C)
 Part B >80° F (35° C)

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.