

#### SPECIFICATIONS

##### DESCRIPTION:

**TriBond W** is a fast dry, water based, 2 part, epoxy primer. This primer can be overcoated quickly to meet high speed production needs. **TriBond W** bonds extremely well to properly prepared iron phosphate and blasted surfaces. **TriBond W** 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.

**TriBond W** is a high performance primer for:

- zinc
- galvanizing
- inorganic zinc rich
- copper
- brass
- aluminum
- steel

##### USE:

**TriBond W** is ideal for use on:

- shop finished architectural components
- heavy construction equipment
- off road vehicles
- light rail applications
- farm implement equipment
- other miscellaneous metal parts

Product results will vary by substrate and application method.

**It is the user's responsibility to determine the suitability and performance of this product for their application.**

##### COLOR AVAILABILITY:

**TriBond W** is stocked in medium yellow. Custom colors available; minimum order is required. Special costing will be applied.

**ORDER CODE:** ..... 966P + color

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

Ex: 966P309 is TriBond W, Medium Yellow.

##### PACKAGING:

- 1 gallon cans
- 5 gallon pails
- 55 gallon drums

##### ADVANTAGES:

- Very fast dry
- Compatible with epoxy, urethane, and other strong solvent topcoats
- Excellent resistant to moisture, abrasion, acids, alkalis, and other chemicals
- Good adhesion to properly prepared substrates
- Contains no lead or chromate
- Low toxicity
- Water cleanup

##### LIMITATIONS:

- Not for immersion
- Must be topcoated for exterior use
- Limited below grade use; contact Triangle for more information regarding application
- Requires adequate topcoat film build to prevent epoxy deterioration and topcoat delamination
- Maximum RH at worksite: 75%

#### PROPERTIES

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

	60° F	77° F	90° F
<b>Dry to Touch</b>	50 mins	20 mins	5 mins
<b>Recoat</b>	90 mins	45 mins	15 mins
<b>Dry to Handle</b>	2 hrs	40 mins	20 mins
<b>Full Cure</b>	7 days	7 days	7 days

**Critical Recoat Window:** After 2 days, must sand or blast surface and reprime.

**VOC:** [excluding exempt solvents, catalyzed] .... 0.81 lbs/gal (97 g/l)

**VOC:** [including exempt solvents] ..... 0.24 lbs/gal (29 g/l)

**FLASH POINT:** [setaflash] ..... >200° F (93° C)

**WEIGHT PER GALLON:** ..... 10.52 ± 0.5 lbs (1.26 kg/liter)

**APPLICATION VISCOSITY:** [recommended, catalyzed]

# 3 Zahn Seconds ..... 30-35

**SOLIDS:** [average, catalyzed]

% By Weight ..... 48.0 ± 2%

% By Volume ..... 38.0 ± 2%

**COVERAGE:** [average, catalyzed]

Theoretical at 2.0 mil DFT ..... 305 sq ft/gal

**REQUIRED FILM THICKNESS:**

ASTM D1005 Minimum Dried Film ..... 2.0 mil (51µ)

ASTM D4414 Minimum Wet Film [2 coats] .... 5.3 mil (135µ)

**ASTM D523 GLOSS:**

@ 60° ..... 8-10

@ 20° ..... N/A

**ASTM D3363 PENCIL HARDNESS:**

HB-H ..... Pass

**ASTM D5402 MEK RUBS:**

200 Double ..... Pass

**ASTM D2794 IMPACT RESISTANCE:**

20 inlb forward, 20 inlb reverse ..... Pass

**ASTM B117 SALT SPRAY RESISTANCE:**

5% Salt Spray, 800 hours [BondRite 1000] ..... Pass

**ASTM D5894UV CORROSION WEATHERING:**

ASTM D610 Rusting 7 cycles, 500 hours ..... Pass

ASTM D714 Blistering 7 cycles, 800 hours ..... Pass

**ASTM D4587/D523/D4214 QUV-UVA:**

500 hours @ 60° ..... N/A

1000 hours @ 60° ..... N/A

**ASTM D2247/D714 HUMIDITY RESISTANCE:**

800 hours [unscribed] ..... Pass

**ASTM D4585 MOISTURE CONDENSATION:**

100° F, 1000 hours ..... Pass

**ASTM D3359 ADHESION:**

5B ..... Pass

**ASTM D4060 ABRASION RESISTANCE:**

CS17 wheel, 110 cycles, 1 kg load ..... < 10 mg

**ASTM D522 FLEXIBILITY:**

180° bend, 1/4" mandrel ..... Pass

**ASTM D3170 CHIP RESISTANCE:**

Rating ..... N/A

**ASTM D2485 DRY HEAT RESISTANCE:**

200° F ..... Pass

**WET HEAT RESISTANCE:**

180° F Non-immersion ..... Pass

**ASTM D2243 WATER-BORNE FREEZE THAW:**

0 cycles ..... Protect from freezing

Properties listed above correspond to formula for gloss, white product and may vary by gloss level and/or color. All tests conducted at 1.5-2.0 mils DFT on Bondrite™ 1000 Q-steel panels, fully cured, 7 days, air dry, at 77° F and 50% RH.

# TriBond W™

## 2-Part, Fast Dry, Water Based Epoxy Primer

### APPLICATION DATA

#### SURFACE PREPARATION:

All surfaces must be clean, dry, and free of contaminants. All dirt, grease, rust, mill scale, or loose chalky paint must be removed.

Recommended surface preparation includes:

- surface blasting to remove all mill scale (maximum profile: 0.5-1.0 mils)
  - iron phosphate\* (35-40 milligrams per square foot)
  - zinc phosphate\* (25-30 milligrams per square foot)
- \*seal coat or DI final rinse recommended

#### APPLICABLE SUBSTRATES: [when properly prepared]

- ferrous or non ferrous
- primed galvanized
- primed aluminum
- concrete

#### APPLICATION TEMPERATURE:

- Substrate must remain 10° F above the dew point during application and for 24 hours after application.
- Not recommended for substrate temperatures below 50° F or above 100° F.

#### MIXING PARAMETERS:

**Ratio:** ..... [Part A : Part B]  
 By Weight ..... 2.37 : 1.00  
 By Volume ..... 2.00 : 1.00  
**Sweat-in Time:** ..... 10 minutes  
**ASTM D2196 Pot Life:** [valid for qtys of 1 gallon or more]

50° F	65° F	77° F	85° F
8 hrs	5 hrs	4 hrs	2 hrs

#### APPLICATION METHODS:

TriBond W can be applied by HVLP, air assist airless, or airless spray. For other application methods, please contact your Triangle Coatings representative.

#### HVLP:

Fluid Tip and Needle: ..... .030 - .040"  
 Fluid Pressure: ..... 10-15 psi  
 Air Cap Pressure: ..... 60 psi

#### Air Assist Airless:

Fluid Tip: ..... .012 - .013"  
 Fluid Pressure: ..... 900-1,400 psi  
 Air Cap Pressure ..... 10 psi

#### Airless:

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

**Brush or Roller:** ..... limited; small areas only

**THINNING:** ..... water; 1-2% by volume

**CLEANUP:** ..... water  
 Clean tools with detergent and water while TriBond W is still wet.

### HEALTH & SAFETY PRECAUTIONS

#### WARNING:

LIQUID CONTACT WITH EYE AND SKIN MAY CAUSE IRRITATION. DO NOT INGEST. Avoid contact with eyes and skin. Wash hands thoroughly after using and before eating and smoking. Keep container closed when not in use. If spillage occurs, absorb and dispose of according to local regulations.

#### 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.

#### 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. This product does not contain materials listed in California Proposition 65.

**THIS PRODUCT IS FOR PROFESSIONAL USE ONLY.  
 KEEP THIS PRODUCT OUT OF REACH OF CHILDREN.**

### SHIPPING & HANDLING

#### SHIPPING DESCRIPTION: [CFR 49]

**Ground, Air, Vessel** ..... Not Regulated  
 Required Label ..... Not Required  
 Required Marking ..... Not Required  
**IMDG PACKAGING:** ..... Not Required  
**IMDG STOWAGE:** ..... Not Regulated  
**UNIFORM FIRE CODE:** [CFR 29] ..... CLASS III-B  
**STORAGE TEMPERATURE:** ..... 120° F max  
**KEEP FROM FREEZING**  
**SHELF LIFE:** [warranted] ..... 1 YEAR  
**HMS® RATINGS:** ..... H - 1; F - 1; R - 0; PP - B

**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.

Product Data Sheets are periodically updated to reflect new information relating to the product. It is important to obtain the most recent Product Data Sheet for the product being used before application. OEM966P-11/04-004