

# TECHNICAL DATA SHEET

*\*This Technical Data Sheet supersedes those previously issued.*

## DESCRIPTION

TriFLEX™ is a triple resin technology DTM coating system that combines polyurethane and polyaspartic resins modified with a proprietary polymer resin blend to deliver exceptional weathering, color and gloss retention, and mechanical performance.

## TECHNICAL DATA

Color	Grey, Black, or White   Other colors available to minimum order		
Type	High Solids DTM		
Solids Content	84%		
Finish	Gloss		
VOC's	As supplied Maximum at time of use	Grey / White 152 g/l Grey / White 196 g/l	Black 158 g/l Black 230 g/l



## SUBSTRATE & SURFACE PREPARATION

General Clean to remove all contaminants in accordance with SSPC-SP 1. Substrate must be clean and dry. Steel Substrate Abrasive blast clean to a minimum NACE No. 3/SSPC-SP 6 with a minimum of 2.0 (51 microns) anchor profile that is sharp and angular for maximum adhesion.

## MIXING & THINNING

Mixing	All coating kits are supplied at the proper mix ratio and should be mixed in their entirety. Mix Part A resin for approximately 2 – 3 minutes until color and consistency is uniform. Mix Part B catalyst until thoroughly homogenous. Slowly and Part B catalyst to Part A and mix thoroughly for approximately 2 minutes.		
Ratio (4:1)	Five Gallon Kit	Part A: 4.0 Gallons	Part B: 1.0 Gallons
Thinning	MEK, MAK, or n-butyl acetate, up to 5%. (Black may require additional thinning up to 10%)		
Pot Life	1 hour at 77°F (25°C)		

# APPLICATION GUIDELINES

Equipment Type	Coating should be applied via airless spray equipment pump size 45:1 or greater or by PC equipment at a 4:1 mix ratio – <b>OR</b> – Conventional spray (30:1), thinning may be required. <b>*Contact APC Technical Service for additional information</b>
Dry Film Thickness	Refer to application guide for recommended dry film thickness.
Theoretical Coverage	at 1 mil: 1345 sq ft / gallon (25 microns) * Allow for loss in mixing and application
Dry to Touch	2 hours at 77°F (25°C)
Full Cure	4 days at 77°F (25°C) or 1 hour at 130°F (54°C)
Recoat Window	Minimum recoat window is 3 hours at 75°F (24°C). Maximum recoat window is 30 days at 75°F (24°C). Contact APC Technical Services for recoat window parameters at other elevated temperatures. Overcoat Window: There is a 12 month window where TriFLEX™ can be applied after cleaning the surface with MEK or acetone.

# APPLICATION CONDITIONS

Material	55°F (13°C) – 90°F (32°C)
Surface	40°F (5°C) – 140°F (60°C)
Humidity	10% – 90%

# CLEAN-UP & SAFETY

Clean-up	TriFLEX™ can be cleaned up with MEK, MAK, n-butyl acetate, or acetone. Note: TriFLEX™ can potentially gel up if not properly cleaned. This can be avoided by ensuring equipment is properly cleaned after each use and <b>keeping Part B tightly sealed and the hopper empty or tightly sealed after each use.</b>
Safety	Consult SDS

# PACKAGING, HANDLING & STORAGE

Shelf Life	12 months
Storage	40°F – 110°F / 4°C – 43°C   0 – 100% RH * Keep Part B sealed tightly. If opened reseal completely.

## APC TriFLEX™ GENERAL WARRANTY STATEMENT

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