

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	162.5 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 add 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 – OR – Conventional spray (30:1), thinning may be required. *Contact APC Technical Service for additional information
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 keeping Part B tightly sealed and the hopper empty or tightly sealed after each use.
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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