TriFLEX™

ADVANCED POLYMER COATINGS

EXTERIOR APPLICATION GUIDE

SCOPE

These application instructions cover surface preparation, application equipment, and other application details on TriFLEX™.

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. After blasting clean off abrasives and dust from surface.

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 until color is uniform.
Ratio (4:1)	One Gallon Kit Part A: 0.8 Gallons I Part B: 0.2 Gallons Five Gallon Kit Part A: 4.0 Gallons I Part B: 1.0 Gallons
Thinning	MEK, MAK, or n-butyl acetate, up to 5% MAX. (Only thin if fingering occurs. Slowly increase thinner as needed)
Pot Life	1 hour at 77°F (25°C)

APPLICATION EQUIPMENT GUIDELINES

Guidelines	Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.
Spray Application (General)	Airless sprayer (45:1) or greater **-OR-** Airless plural component, heated spray equipment capable of 2000 psi or greater with a mixer manifold and whip hose is required for the application of this material. Can be applied by brush or roller when thinned. Contact Advanced Polymer Coatings Technical Service for additional information.

APPLICATION CONDITIONS

Material Temperature Range	55ºF (13ºC) – 90ºF (32ºC)
Substrate Temperature Range	50ºF (10ºC) – 100ºF (38ºC)
Substrate Minimum Temperature	5ºF (3ºC) above temperature of the dew point
Humidity Range	10% – 90%

CURING SCHEDULE

Dry to Touch	2 hours at ambient
Dry Through	6 hours at 77ºF or 30 minutes at 130ºF
Full Cure	4 days at ambient or 1 hour at 130ºF
Decals	Can be done 6 hours at 77ºF or 1 hour at 130ºF
Recoat Window	Minimum recoat window is 3 hours at 75ºF (24ºC) Maximum recoat window is 30 days at 75ºF (24ºC). Contact APC Technical Services for recoat window parameters at other elevated temperatures.

COVERAGE

Dry Film Thickness	Coating should be applied to a DFT of 6-8 mils DFT (150-200 microns)
Percentage Solids by Volume	84%
Theoretical Coverage	1345 sq ft / gallon at 1 mils (25 microns) 224 sq ft / gallon at 6 mils (150 microns) 168 sq ft / gallon at 8 mils (200 microns) ***Allow for loss in mixing and application***

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 – 110ºF I 0-100% RH	***Keep Part B sealed tightly. If opened reseal completely.***