

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
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	One Gallon Kit Part A: 0.8 Gallons Part B: 0.2 Gallons Five Gallon Kit Part A: 4.0 Gallons Part B: 1.0 Gallons
Thinning	MEK, MAK, or n-butyl acetate, up to 5%. (Only thin if fingering occurs. Slowly increase thinner as needed)
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 *Contact APC Technical Service for additional information
Dry Film Thickness	Steel: 6-8 mils DFT (+/- 2 mils)
Theoretical Coverage	at 1 mil: 1345 sq ft / gallon (25 micons) *Allow for loss in mixing and application
Dry to Touch	2 hours at ambient
Full Cure	4 days at ambient or 1 hour at 130°F

APPLICATION CONDITIONS

Material	55°F (13°C) – 90°F (32°C)
Surface	50°F (16°C) – 100°F (38°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
	40 – 110°F 0 – 100% RH *Keep Part B sealed tightly. If opened reseal completely.

APC TriFLEX™ GENERAL WARRANTY STATEMENT

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