# TRIOCOAT 2600

*Alkyd primer-enamel*

**MATERIAL DESCRIPTION:**

One-component fast-drying anti-corrosion alkyd primer-enamel.

**COATING PURPOSE:**

The primer-enamel is used for corrosion protection of external and internal surfaces of all types of freight railcars and undercar equipment of railway transport, bridges and other engineering structures, pipe racks, pipelines for various purposes, other structures of oil and gas facilities, metal structures in the construction of civil, public, industrial buildings and structures, vehicles, road and agricultural machinery, electrical equipment, crane equipment, containers (including MSW containers). Typical operation of the coating — in moderate, moderately cold and cold climates and atmospheric corrosivity from very low C1 to high C4 (GOST 34667.2 (ISO 12944-2)). The primer-enamel is tolerant to surface preparation (preparation grades Sa 2, St 2 are allowed). It can be used as a repair material and is compatible with most types of old paint and coating systems. The operating temperature of the coating is from minus 60 to plus 40 °C.

**PHYSICAL CHARACTERISTICS:**

Appearance, color:

Matte, semi-matte coating (according to GOST 35094). Tinting according to RAL.

Volume solids:

45±5 %

Theoretical spreading rate:

0.134 l/m² at DFT 60 µm.

Coating thickness:

Wet and dry film thickness table

| **Film thickness** | **WFT, µm** | **DFT, µm** |
|---|---|---|
| Minimum | 89 | 40 |
| Maximum | 267 | 120 |
| Recommended | 134 | 60 |

Drying time:

| Drying time at DFT 60 µm | | | | | |
|---|---|---|---|---|---|
| **Ambient temperature** | **0 °C** | **5 °C** | **10 °C** | **20 °C** | **30 °C** |
| Drying to overcoating with the next coat | 9 h | 6 h | 3 h | 1.5 h | 30 min |

The maximum overcoating interval is unlimited.

The drying time of the coating at a temperature of plus (20±2) °C to the possibility of transportation is not less than 12 h.

The full curing time of the coating at a temperature of plus (20±2) °C is not less than 5 days.

Drying time is determined by the actual applied layer thickness. The drying time values given in this section are for guidance only. When assessing the actual drying time values, it is also necessary to take into account the presence of air flows and relative air humidity.

**SURFACE PREPARATION:**

The material is applied to a previously prepared surface.

- **Steel surface:** the surface to be painted must be dry, clean and uniform with a temperature at least 3 °C above the dew point. A typical surface preparation scheme includes elimination of metal surface defects to grade P2 according to ISO 8501-3 (sharp edges and corners are to be rounded with a radius of at least 2 mm), abrasive blast cleaning to grade Sa 2 according to ISO 8501-1 (local application of cleaning with hand or mechanical tools to grade St 2 is allowed), degreasing to grade 1 according to GOST 9.402, desalting (if necessary), roughness assessment (must correspond to the medium (G) profile according to ISO 8503-1), and dust removal with compressed air of group 2 according to GOST 9.010 to degree not more than 2 with a particle size of not more than class 2 (according to ISO 8502-3).
- **Old compatible coatings:** must be dry, cleaned of foreign inclusions, dust, dirt, have appropriate roughness.

A more detailed description of the preparation of various types of surfaces is given in the application manual for the primer-enamel.

**APPLICATION:**

Material preparation:

The material is one-pack; before application, it must be thoroughly stirred for 5–7 minutes to a homogeneous state.

Application method:

Airless spraying / Pneumatic spraying / Manual application.

Thinner:

Thinner TRIOSOLV 0003. Dilute in increments of 1 % by volume.

Recommended dilution values:

- for airless spraying — (0–5) % by volume;
- for pneumatic spraying — (0–15) % by volume;
- for application with a brush or roller (strip painting, complex-shaped products, areas up to 1 m²) — (0–5) % by volume.

Nozzle diameter (recommended):

- for airless spraying — .013"–.019";
- for pneumatic spraying — (1.5–2.0) mm.

Operating pressure (recommended):

- for airless spraying — (150–180) bar;
- for pneumatic spraying — (2.0–3.5) bar.

Equipment cleaning:

TRIOSOLV 0003, xylene.

Environmental parameters:

- air temperature: from 0 to plus 35 °C;
- relative air humidity: not more than 85 %;
- temperature of the surface to be painted: at least 3 °C above the dew point.

In closed rooms, it is recommended to provide supply-and-exhaust ventilation in the appropriate volume for the period of application and drying.

**RECOMMENDED SYSTEMS:**

It is used as a standalone coating, as well as an enamel for application over alkyd, alkyd-modified, acrylic primer layers, as well as compatible coatings of other types. For more detailed information, contact O3-Coatings.

**STORAGE:**

| | |
|---|---|
| | 12 months from the date of manufacture. Store in a dry dark place in sealed factory packaging at a temperature from minus 40 to plus 40 °C, away from heat and ignition sources, avoiding ingress of moisture and direct sunlight. |
| **NOTE:** | Small deviations of the numerical values of physical quantities are permissible. |
| **TRANSPORT PACKAGING:** | Euro pail (net weight — 20 kg). |
| **HEALTH AND SAFETY:** | Refer to the Safety Data Sheet for the material. |