



Product Data Sheet

Transpoxy Solventfree 4.74

Product description.

A solvent free, polyamine cured epoxy coating especially designed for the protection of potable water tanks mad of steel or concrete. Transpoxy Solventfree was tested and approved by the Nehring Institute for compliance with the Plastics-drinking-water-recommendation of the German Federal Agency for Public Health.

Physical properties.

Colour / Texture White
 Volume Solids 100%
 Specific gravity 1.57 gr/ml
 VOC 0 gr/litre
 Flashpoint >200 °C

	Dry film thickness per coat (µ)	Wet film thickness per coat (µ)	Theoretical spreading rate (m ² /l)
Range	150 – 300	150 – 300	6.6 – 3.3
Recommended	150	150	6.6

Application data.

Mixing ratio By volume, base to hardener: 3:2

Pot-life 10°C: 45 minutes, 23°C: 30 minutes.

Guiding data - Airless spray Pressure at nozzle: 180 – 250 bar. Nozzle size: 0.53 - 0.66 mm.
 Spray angle: 40 - 80 degrees.
 Volume of thinner: 0 – 3%.

Brush Suitable for stripe coats and touch-up work only.
 Volume of thinner: 0 - 5%.

Thinner Ethanol. Please note that pot-life and drying times will be increased.

Cleaner Transocean Epoxy Thinner 6.03

Drying and recoating times (1).

Substrate temperature	Touch dry	Dry to handle	Full cure	Dry to recoat	
				Minimum	Maximum (2)
10 °C	16 hours	12 hours	14 days	16 hours	3 days
23 °C	8 hours	8 hours	7 days	8 hours	3 days

(1) The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, preceding paint system etc

(2) The surface should be dry and free from contaminants prior to overcoating. When the maximum recoating time is exceed it may be necessary to roughen the surface to ensure intercoat adhesion. When in doubt, consult your nearest Transocean office.

Surface preparation.

Steel

Oil and grease should be removed by solvent cleaning according to SSPC-SP1. Remove weld spatter and smooth weld seams and sharp edges as applicable. Abrasive blasting: min. Sa2,5 – ISO 8501:1. Remove all loose dirt and abrasive by vacuuming or sweeping. Apply Transpoxy Solventfree immediately after the steel has been blasted and the quality of preparation has been approved.

Additional usage instructions.

1. Preferably mix part A and part B with a mechanical stirrer. Do not mix more material than can be used in 1 hour at 20°C.
2. Corners, edges and weld seams should be stripe-coated prior to a full coat application.
3. Allow ventilation during and after application of the coating system. Temperature of the ventilation air should lie around 40°C. Continue ventilation until the system has fully cured.
4. Do not apply the coating when ambient temperature will be less than 10°C for more than 48 hours after application of the coating.
5. After application and full cure of the final coat, the tank should be flushed and cleaned once with a 2-3% lemon acid solution in water. Then the tank should be filled and flushed with clean water.

Recommended paint system.

A typical system is shown below.

Transpoxy Solventfree 4.74

3 x 150 µ dft.

Sharp edges, corners and weld seams must be stripe coated in order to achieve the specified dry film thickness.

Application conditions.

The temperature of the substrate should be at least 10°C and at least 3°C above the dew point of the air. Temperature and relative humidity should be measured in the vicinity of the substrate. The maximum recommended surface temperature is approx. 40°C. Higher steel temperatures are acceptable provided dry-spray is avoided by proper spray application and extra thinning if required. In extreme cases it may be necessary to reduce film thickness in order to avoid sagging. When applying the paint in confined spaces, provide adequate ventilation during application and drying. The temperature of the mixed paint should be at least 15°C, otherwise extra solvent may be required to obtain a proper application viscosity.

Storage and shelf life.

The product must be stored in accordance with national regulations. The cans are to be kept in a dry, cool, well ventilated space and away from source of heat and ignition. Cans must be kept tightly closed.

Worldwide availability

The product is part of the common Transocean product range but local availability is subject to confirmation. Although we strive to supply the same product through the world, slight modifications of the product in some cases may be necessary in order to comply with local conditions and/or national regulations. In such cases an alternative datasheet will be issued.

Health and safety.

Observe the precautionary notices on the label of the container. A material safety data sheet is available upon request and national or local safety regulations should be followed. This product is intended for use by professional applicators.

As a general rule, avoid skin- and eye contact by wearing overalls, gloves, goggles, mask, etc. Spraying should be carried out under well-ventilated conditions. This product contains flammable materials and should be kept away from sparks and open flames. Smoking in the area should not be permitted.

Date of issue: July, 12.