



Product Data Sheet

Transpoxy Masterbond 4.67 N

(Flooring Grade)

Product Description

A surface tolerant, self-priming, high solids epoxy mastic floor coating formulated with Masterbond binder technology. Transpoxy Masterbond 4.67N Flooring Grade has both excellent impact / abrasion resistance, along with superior adhesion characteristics. It can also be applied as a non-slip protective coating when used in conjunction with appropriate anti-slip aggregates.

Physical Properties

Colour	AS 2700 colours (Australian Standard)
Texture	Gloss "Stipple" finish when roller applied
Volume Solids	82%
Pot Life	90 minutes (at 25°C – Will be considerably reduced if FAST Hardener or Accelerator selected in mix)
Specific Gravity	1.50 g/ml
VOC	179 g/litre
Flashpoint	>25°C
Resin type	Epoxy / Polyamide

General Data

Weather resistance	Good <i>Note – Product will chalk and discolour on exposure to both U.V. & artificial light sources, and some particular chemicals, however film integrity is not compromised. The application of UV-stable Transocean or Rhinofloor® Polyurethane topcoats are highly recommended if the Transpoxy Masterbond 4.67N Flooring Grade system is specified for areas exposed to climatic conditions as per mentioned above. Severity of film discolouration is also subject to shade of colour selected, with white and light to mid grey tones most affected. Please refer Wagon Paints Technical Department for further information.</i>
Solvent resistance	Good
Chemical resistance	Very good* (mineral / vegetable oils; fats) Very good* (dilute acids / alkalis; salt solutions; brake fluid; engine coolant) <i>Note* - Product may stain / discolour on exposure to certain chemicals, and on contact with certain vehicular tyres. Please refer Wagon Paints Technical Department for further information.</i>
Abrasion resistance	Excellent

Typical Applications

- Factory & Warehouse floors
- Workshop floors
- Food processing & Commercial kitchens
- Washrooms & Amenities areas
- Plantrooms / Store rooms & 'Back of house' areas
- Demonstration areas & Training rooms
- **This is an industrial grade product and is not recommended for use in domestic situations**

How to Specify

- The flooring system shall be "Transpoxy Masterbond 4.67N Flooring Grade" as supplied by Wagon Paints Australia Pty. Ltd.
- The colour shall be
- The degree of non-slip to be similar to "Approved" sample, or to ramp rating classification of "R"

Surface Preparation

All concrete surfaces to be coated must be in sound, stable condition, with moisture content not greater than 5%. New concrete substrates must be at least 28 days old prior to application of the Transpoxy Masterbond 4.67N Flooring Grade. The recommended preparatory method for the finishing of the concrete substrate, post-pouring, is either "Steel or Helicopter trowelled". Any traces of oil, grease or other contaminants must be completely removed by detergent wash. All excess water to be mopped up and concrete allowed to thoroughly dry. All surfaces to be coated must be captive shot blasted to a profile similar to that of 80 grit sandpaper (note: Diamond grinding is generally a suitable alternative to shot blasting except where concrete substrate is highly burnished). Acid-etching can be used as a minimum preparation technique, however, we strongly recommend either blasting or grinding to ensure the substrate has been suitably prepared. Care must be taken to ensure that all existing curing compounds/agents, surface coatings, loose or flaky material and laitance are completely removed. Diamond-grind all areas that are inaccessible to shot blast machine. All surfaces to be coated should be vacuum cleaned to remove dust and other loose particles immediately prior to application of the first coat of Transpoxy Masterbond 4.67N Flooring Grade.

NOTE - 'Acid-etching' is not a suitable preparation technique for concrete substrates suspected of being pre-treated with 'Densifier' or 'Penetrating Sealer' type products. Preparation via mechanical abrasion of the substrate must be performed prior to application (i.e. Scabbling / Shot-blasting / Diamond-grinding) to permit maximum adhesion characteristics of the system as specified. Please refer Wagon Paints Technical Department for further information.

Note – This product can be applied over a wide range of well-adhered aged 2-pack coatings, subject to the application & verification of a test-patch, and with suitable mechanical preparation of the surface where necessary. Please consult your local Wagon Paints Technical Department for further information.

Mixing Recommendation

- Mix only the quantity required for 20 – 30 minutes use
- Mix Pack A with Pack B using the recommended ratio (Refer 'Application data' below)
- Stir thoroughly with a broad paddle or low-speed mechanical mixer (350 RPM) to ensure even mixing

Drying & Recoating timeframes

Note - An epoxy accelerator is also available for use in the Transpoxy Masterbond 4.67N floor coating system. Please note that these epoxy accelerators are only to be used in the cooler months of the year. The use of these epoxy accelerators may also cause some darkening / yellowing, and a reduction in gloss level, in some colours / shades. When curing under conditions of low temperatures and / or high humidity, exposure to water may cause the surface of the cured epoxy to discolour (Whiten). This water sensitivity may eventually disappear, dependant on ambient conditions. The use of the TRANSPoxy MASTERBOND 4.67N ACCELERATOR in conjunction with the TRANSPoxy MASTERBOND 4.67N FAST Pack B may attenuate this "Water-spotting" issue, but can only be used in suitable conditions, or as per recommendation of Wagon Paints Technical department. The use of the TRANSPoxy MASTERBOND 4.67N ACCELERATOR in conjunction with the TRANSPoxy MASTERBOND 4.67N FAST Pack B may still not fully attenuate "Water-spotting" issues when applied in very cold conditions (Eg. Winter). Therefore, we highly recommended that Rhinofloor Polyurethane topcoats, (such as Rhinofloor T Rollgrade or Rhinofloor AG or Transurethane Finish HB 3.44 F/G) be applied to the specified TRANSPoxy MASTERBOND 4.67N system, to eliminate the likelihood of the "Water-spotting" phenomena. Please refer Wagon Paints Technical Department for further information.

Substrate Temperature	Touch dry	Full cure	Minimum (dry to recoat)	Maximum (dry to recoat)
10°C	6 hours	8 days	18 hours	Indefinite**
23°C	3 hours	5 days	15 hours	Indefinite**
30°C	1 hour	3 days	12 hours	Indefinite**

***The best intercoat adhesion is achieved when the subsequent coat is applied before the preceding coat is fully cured. After prolonged exposure it may be necessary to mechanically roughen the surface to ensure adequate intercoat adhesion. Do not under any circumstances allow any fluid (Eg. Water, Oil, Solvent, Chemicals, etc.) to contaminate the coated surface until full cure is achieved. When in doubt, consult Wagon Paints Technical Department for further information.*

Walk-on / Drive-on times (at 20 °C and 50% relative humidity)

- Light foot traffic 24 hours
- Light mechanical loading 2 – 4 days (Premature loading may cause coating damage / failure)
- Full cure 5 – 7 days

Application Data

Mixing Ratio 4 : 1 (By volume – Base to Hardener)

The use of Transpoxy Masterbond 4.67N Flooring Grade 'RAPID' Hardener is advisable in the cooler months of the year. Please note that the use of this rapid hardener may cause some darkening / yellowing, and a reduction in gloss level, in some colours / shades.

Pot-life
(Standard hardener) 10°C : 3 hours / 23°C : 2 hours / 30°C : 1 hour

Thinner / Cleaner Transocean Epoxy Thinner 6.03 or T3 Epoxy Thinner

Roller / Brush Multiple coats are required to achieve the specified dry film thickness (DFT)
Microfibre (Non-shedding) roller covers are recommended: nap size: 10 – 15 mm (Applicator preference)
Thin up to 10% on first coat to aid in penetration of substrate. (2nd & 3rd coats thin where necessary)
Aesthetic appearance - Rolling / brushing will exhibit a definite "Stipple-texture" finish

Airless Spray Pressure at nozzle: 180 – 250 bar Nozzle size: 0.41 – 0.58 mm
Spray angle: 40 – 80 degrees
Volume of thinner: 0 – 5%
Spraying is suitable but "Rolling" is recommended / preferred application method.

Conditions **This product must not be applied over damp surfaces – Maximum moisture content less than 5%**
Do not apply when the air / surface temperature is below, or is likely to fall below 10°C, the air / surface temperature exceeds, or is likely to exceed 30°C, or relative humidity exceeds, or is likely to exceed 85%.
Substrate temperature must be at least 3°C greater than the dew point at the time of application.

Recommended Paint System

	D.F.T.* per coat (µm)	W.F.T.* per coat (µm)	Theoretical spreading rate (m ² /l)
Range	100 - 250	120 - 300	8.2 - 3.2
Recommended	150 - 200	180 - 240	5.6 - 4.2

*D.F.T. – Dry Film Thickness / W.F.T. – Wet Film Thickness

A typical system for atmospheric exposure is as follows:

Transpoxy Masterbond 4.67N Flooring Grade 2 x 150-200 µm D.F.T.
The coating can be left uncoated but may be topcoated with alternate Rhinofloor / Transocean coatings.
This product is for industrial use only (Not for residential use)
Please consult Wagon Paints Technical Department for further information.

Safety Precautions

Refer to the relevant Safety Data Sheets (SDS) for Pack A and Pack B

Pack A	Packaging Group	III	DG Class 3	UN No. 1263
Pack B	Packaging Group	II	DG Class 8	UN No. 3470

Observe the precautionary notices on the label of the container. An MSDS is available upon request and national and local safety regulations should be followed. This product is intended for use by professional / experienced applicators. Avoid contact with skin and eyes – When mixing and applying wear suitable protective clothing / gloves / glasses / mask / etc. Spillage on the skin should be immediately removed by thorough washing with lukewarm water and soap or a suitable industrial cleaner. Eyes should be flushed with fresh water and medical attention sought immediately. Spraying should be carried out under well-ventilated conditions. Avoid inhalation of solvent vapours and paint mist by wearing an approved air mask. This product contains flammable materials and should be kept away from sparks, flame and sources of ignition. Smoking in the area of application / mixing / storage should not be permitted.

Anti-slip Characteristics

If specification / contract document states that a floor must conform to a particular Australian Standard for slip resistance, then an aggregate must be added into the Rhinofloor flooring system to impart the required non-slip rating. Please refer to Wagon Paints technical department for further information. Wagon Paints Australia, incorporating Rhinofloor Coatings, does not warrant the “Anti-slip” performance of the coating system(s), with or without aggregate, as this characteristic is out of our control. It is up to the applicator / contractor / purchaser to satisfy any “Anti-slip” regulations or standards required if applied to areas which may be hazardous to pedestrian or vehicular traffic.

Pack Sizes

Pack Size	5 litre kit*	20 litre kit*
Pack A	4 litres	16 litres
Pack B	1 litre	4 litres

For all enquiries please contact:

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Disclaimer

The 'Rhinofloor / Transocean' floor-coating range has been designed / manufactured primarily to protect the concrete substrate. Please be aware that scratching, marring, colour-fading, gloss reduction, etc, will be evident, with the rate of film attack directly related to service conditions within the areas that these coatings have been applied. Wagon Paints, incorporating Rhinofloor & Transocean Coatings, take no responsibility for film attack as mentioned, as these issues are a known fact inherent to all industrial epoxy and polyurethane floor coatings.

The information in this data sheet is provided to the best of our knowledge. However, we have no control over either the quality or condition of the substrate and other factors affecting the use and application of this product. Therefore, we cannot accept any liability whatsoever or howsoever arising from the performance of the product or for any loss or damage arising from the use of this product. We reserve the right to change the product, as well as the data sheet, without notice.

Authorised: J. Skangos, Technical Manager May 2024

These technical data and recommendations are based on tests and information believed to be accurate at the time of printing. They should not be construed as containing any warranty, either expressed or implied. Users should conduct their own tests to determine final suitability of this product.

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