



Product Data Sheet

Transoxy Solventless H.B 4.74

Product description.

A solventfree, polyamine cured epoxy coating especially designed for the protection of potable water tanks mad of steel or concrete. Transoxy 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 and Light Green/Glossy
 Volume Solids 100%
 Specific gravity 1.50 gr/ml
 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: 60 to 40.

Potlife 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 potlife and drying times will be increased.

Cleaner Transocean Epoxy Thinner 6.03

Conditions Humidity: below 85% RH.
 Temperature of the paint before application: min: 10°C, max: 30°C.
 Substrate temperature: min: 10°C, max: 35°C.
 The temperature of the substrate should be at least 3°C above the dew point of the air. Air temperatures and relative humidity must be measured in the vicinity of the substrate.

Drying and recoating times.

Substrate temperature	Touch dry	Dry to handle	Full cure	Dry to recoat	
				Minimum	Maximum (1)
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 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 30 minutes at 30°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 curing 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.

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3 x 150 µ dft.

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

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. Spillage on the skin should immediately be 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 air mask.

This product contains flammable materials and should be kept away from sparks and open flames. Smoking in the area should not be permitted.

Disclaimer

The information in this data sheet is provided to the best of our knowledge. However, we have no control over either 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 without notice.

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