



Product Data Sheet

Transpoxy Solventfree 4.74

Product description.

A solventfree, 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 and Green/Glossy
 Volume Solids 100%
 Specific gravity 1.57 gr/ml
 VOC 0 gr/liter
 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 weight, base to hardener: 50 to 50.
 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.

