Product Data Sheet

Transpoxy Tankguard 4.71

Product description.

A solventfree, polyamine cured epoxy coating with excellent resistance against alkalis, diluted inorganic acids and various solvents. The product is especially suitable for carriage of wine and other low-alcoholic spirits (alcohol content <20%).

Physical properties.

Colour/Texture	Pale yellow/Glossy
Volume Solids	100%
Specific gravity	1.43 gr/ml
Flashpoint	>55°C

	Dry film thickness per coat (µ)	Wet film thickness per coat (µ)	Theoretical spreading rate (m^2/l)
Range	150 – 250	150 – 250	6.6 – 4.0
Recommended	200	200	5.0

Application data.

Mixing ratio: By volume, base to hardener: 60 to 40.

Potlife: 10°C: 3 hours, 23°C: 2 hours, 30°C: 1 hour.

Guiding data Airless spray: Heavy duty single feed airless equipment is advised. Compression 45 : 1, preferably 60 : 1.
Pressure at nozzle: 180 – 250 bar. Nozzle size: 0.48 - 0.63 mm.
Spray angle: 40 - 80 degrees.
Volume of thinner: 0 - 5%.

Brush: Suitable for stripe coats and touch-up work only.
Volume of thinner: 0 - 10%.

Thinner/Cleaner: Transocean Epoxy Thinner 6.03. For the final coat ethanol is recommended.

Conditions: Humidity: below 85% RH.
Temperature of the paint before application: min: 10°C, max: 30°C.
Substrate temperature: min: 5°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	12 hours	48 hours	10 days	36 hours	4 days
23 °C	6 hours	24 hours	7 days	24 hours	2 days
30 °C	4 hours	18 hours	4 days	16 hours	1 day

(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. Roughness profile: 50 – 75 micron. Remove all loose dirt and abrasive by vacuuming or sweeping. Apply Transpoxy Tankguard immediately after the steel has been blasted and the quality of preparation has been approved.

Recommended paint system.

A typical system is shown below.

Transpoxy Tankguard 4.71	2 x 200 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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