



# Product Data Sheet

## Transpoxy Guard 4.64

### Product description.

A high build polyamine cured epoxy coating for steel and concrete. Transpoxy Guard has good resistance against abrasion and excellent resistance against corrosion. Suitable for immersion in seawater, fresh water and potable water.

### Physical properties.

Colour / Texture                      White / Gloss  
 Volume Solids                         98%  
 Specific gravity                        1.6 g/ml  
 VOC                                        22 g/litre  
 Flashpoint                               >80°C

	Dry film thickness per coat (µm)	Wet film thickness per coat (µm)	Theoretical spreading rate (m <sup>2</sup> /l)
Range	150 – 500	155 – 510	6.5 – 1.9

### Application data.

Mixing ratio                              By Weight, base to hardener:    67 to 33.

Pot-life                                    10°C: 2 hours,    23°C: 1 hour.                      30°C: 30 minutes

Guiding data - Airless spray    Heavy duty single feed airless equipment is advised. Compression 60 : 1.  
 Pressure at nozzle: 180 – 250 bar. Nozzle size: 0.53 - 0.58 mm.  
 Spray angle: 40 - 80 degrees.  
 Volume of thinner: 0 - 3%.

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

Thinner / 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: 5°C, max: 40°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 (1).

Substrate temperature	Touch dry	Dry to handle	Full cure	Dry to recoat	
				Minimum	Maximum
10 °C	24 hours	48 hours	7 days	36 hours	10 days
23 °C	16 hours	24 hours	5 days	24 hours	4 days
30 °C	8 hours	16 hours	3 days	16 hours	2 days

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

