

TRANSCOAT 3850

Multi Purpose Epoxy

Product Description	Multi purpose high build polyamide cured epoxy.	
Recommended Use	High performance primer or built coat for durable systems with wide range of protective topcoats.	
Characteristics	<ul style="list-style-type: none"> • Rust inhibitive epoxy primer. • Compatible with compromised surface preparation. • Excellent shopprimer for corrosive service. • Easy application. • Excellent adhesion to bare steel and inorganic zinc silicate. • Suitable for immersion in salt solution and water at temperature up to 60°C. • Tank lining for alkaline, salt solution, petroleum fuels and sewage waste. • Can be applied over concrete, aluminium, stainless steel and galvanizing. 	
Physical Data	<p>Colour Available On Request</p> <p>Gloss Level Flat</p> <p>Volume Solid Approx. 70%</p> <p>Dry Film Thickness 100 - 150 microns per coat</p> <p>Number of Coat 1 or 2</p> <p>Theoretical Coverage 7.00 sq.m/ltr for 100 microns</p> <p>Temperature Resistance Continuous : 93°C (dry) 60°C (wet) Intermittent : 120°C (dry) 80°C (wet)</p> <p>VOC 276 g/ltr</p> <p>Flash Point Base : 53°C Hardener : 48°C</p> <p>Shelf Life At least 12 months</p> <p>Pack Size</p> <p style="padding-left: 20px;">10 liters unit Base : 5 liters , Hardener : 5 liters</p> <p style="padding-left: 20px;">20 liters unit Base : 10 liters , Hardener : 10 liters</p>	
Surface Preparation	<p>Steel</p> <p>Dry abrasive blast in accordance with ISO - Sa 2.5 or SSPC - SP 10 "Near White". Blast to achieve an anchor profile of 25 - 50 microns as determined with a Keane Tator Surface Profile Comparator.</p> <p>Remove abrasive residue or dust from surface.</p> <p>Concrete</p> <p>Abrasive blast to ASTM D 4259. Surface must be free of moisture, grease and other contaminants.</p> <p>Aluminium and Galvanizing</p> <p>Remove oil, grease with neutral detergent, or blast lightly with fine abrasive, priming or etching with Trans Etch.</p>	

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Aged Coating

Free of all loose paint, chalky residue. Roughened or clean by pressure water blast (minimum 1000 psi), cleaned and dry.

Application Data

Application Methods

Airless Spray

Nozzle Tip 0.46 - 0.56 mm (0.018 - 0.023 inch)

Nozzle Pressure 10 MPa (approx. 1400 psi)

Conventional Spray

Nozzle Tip 1.8 - 2.0 mm (0.071 - 0.079 inch)

Nozzle Pressure 0.3 MPa (approx. 43 psi)

Mixing Ratio By Volume Base : Hardener = 1 : 1

Thinner Thinner Trans 650

Cleaner Thinner Trans 120

Surface Temperature Should be 10°C - 49°C, at least 3°C above the dew point to prevent condensation

Drying Time

Touch Dry 2 hours at 25°C, 1 hour at 32°C

Through Dry 14 hours at 25°C, 8 hours at 32°C

To Topcoat

Minimum 7 hours at 25°C, 4 hours at 32°C

Maximum 1 month (roughened, clean and dry)

Full Cure 7 days

Pot Life 3 hours at 25°C, 1.5 hours at 32°C

Systems Compatibility

Primer

- Transcoat 95 / Transcoat 95 FT
- Transcoat 685 A
- Transcoat 710 ZP
- Transcoat SP 2005

Topcoat

- Transcoat 4502 GL
- Transcoat 662 GL
- Transcoat 3252 / Transcoat 782 HB
- Transcoat 992

For other suitable primers or topcoats, please consult Transcoat Protective Coating.

Safety Precaution

Keep away from heat, spark and open flames. Avoid breathing of vapour on skin and eye contact. Keep container closed and store in cool, ventilated area when not in use.

Proper ventilation and protective measures must be provided during mixing, application and drying, to keep vapour concentration within safe limits and to protect against toxic hazard.

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Necessary safety equipment must be used and ventilation requirements carefully observed, especially in confined or enclosed spaces, such as tank interior and building.

Disclaimer

The information in this product data sheet is given to the best of our knowledge based on laboratory testing and practical experience. If the product is used under condition beyond our control, we cannot guarantee anything but the quality of the products it self. The information in this product data sheet is liable for modification from time to time in the light of experience and our policy of continuous product development, and without further notice.
