

TRANSCOAT 4000 AL

Aluminium Polyamide Epoxy

Product Description	High solid aluminium polyamide cured epoxy coating.	
Recommended Use	High performance surface tolerant epoxy aluminium for general maintenance coating which can be applied to new or old steel and resists to splash / spillage of a wide range of chemicals.	
Characteristics	<ul style="list-style-type: none"> • Surface tolerant coating for lower grade of steel surface preparation. • High performance self-priming topcoats. • Can be over coated with wide range of topcoats. • Compatible with various aged coatings. • Can be applied over most existing coatings • Excellent corrosion resistance and good flexibility. • Good resistance to splash / spillage of acids, alkalies, solvents, fresh and saltwater. • Resists of high humidity and moisture. • Not recommended to immersion in acids and alkalies. 	
Physical Data	Colour	Aluminium
	Gloss Level	Semi Gloss
	Volume Solid	Approx. 90%
	Dry Film Thickness	100 - 200 microns per coat
	Number of Coat	1 or 2
	Theoretical Coverage	6.00 sq.m/ltr for 150 microns
	Temperature Resistance	Continuous : 93 ^o C (dry) 22 ^o C (wet) Intermittent : 175 ^o C (dry) 22 ^o C (wet)
	VOC	168 g/ltr
	Flash Point	Base : 55 ^o C Hardener : 29 ^o C
	Shelf Life	At least 12 months
	Pack Size	
	10 litres unit	Base : 5 litres , Hardener : 5 litres
	20 litres unit	Base : 10 litres , Hardener : 10 litres

Surface Preparation	Steel <ul style="list-style-type: none"> • Dry abrasive blast in accordance with ISO - Sa 2 or SSPC - SP 6 "Commercial". • Blast to achieve an anchor profile of 25 microns as determined with a Keane Tator Surface Profile Comparator. • Remove abrasive residue or dust from surface. • However when this is impossible or impractical, can be applied over mechanically cleaned surface, hand tool or power tool to St 2 or St 3. • Old coating system, sufficiently roughened, cleaned and dry. 	
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Aluminium and Galvanizing

- Light abrasive blast

Concrete

- Abrasive blast to ASTM D 4259

Application Data

Application Methods

Airless Spray

Nozzle Tip	0.46 - 0.58 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 80

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	8 hours at 25°C, 4 hours at 32°C
Through Dry	18 hours at 25°C, 9 hours at 32°C
Overcoating	
Minimum	14 hours at 25°C, 8 hours at 32°C
Maximum	3 months (roughened and dry)
Full Cure	8 days
Pot Life	4 hours at 25°C, 2 hours at 32°C

System Compatibility

Primer

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

Topcoat

- Transcoat 662 GL
- Transcoat 4502 GL
- 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.

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

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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.

