# TRANSCOAT 4000 GF

## High Solids Glassflake Epoxy Coating

**Product Description**

Transcoat 4000 GF is high solids glassflake epoxy coating, and with low solvent level.

**Recommended Use**

Used in both new constructions or areas where blasting is impractical or impossible. As a maintenance coating, Transcoat 4000 GF protects steel structures in industrial facilities, bridges, tank exteriors, marine weathering, splash zone, offshore, decks, oil tanks, piping, roofs, water towers and other exposures. Transcoat 4000 GF has good chemical resistance to splash / spillage and fumes.

Transcoat 4000 GF is available in a variety of colours, and therefore does not require a topcoat. For extended weatherability or special uses a topcoat may be desired.

**Characteristics**

- High-build glassflake coating.
- High-performance epoxy glassflake coating for new or old steel.
- Can be overcoated with wide range of topcoats.
- Compatible with prepared damp surfaces.
- Compatible with adherent rust remaining on prepared surfaces.
- Cures through wide temperature range.
- Up to 20 mils in a single coat.
- Resists high humidity and moisture.
- Low solvent level reduces the chances for film pinholing and solvent entrapment at the substrate-coating interface, often a major cause of coating failure with conventional epoxies and lower solids system.

**Physical Data**

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| **Colour** | Available On Request |
| **Gloss level** | Flat |
| **Volume Solid** | 84% $\pm$ 3 |
| **Dry Film Thickness** | 200 – 500 microns per coat |
| **Number of Coat** | 1 |
| **Theoretical Coverage** | 33.0 sq.m/ltr for 25 microns |
| | 4.10 sq.m/ltr for 200 microns |
| | 1.60 sq.m/ltr for 500 microns |
| **Temperature Resistance** | Continuous : $93^0$C (dry) |
| **Flash Point** | Base : $37^0$C |
| | Hardener : $57^0$C |
| **Shelf Life** | At least 12 months |
| **Pack Size** | |
| 20 litres unit | Base : 10 ltrs , Hardener : 10 ltrs |

**SURFACE PREPARATION**

**Abrasive or water blast, mechanical cleaning**

Coating performance is proportional to the degree of surface preparation. Abrasive blasting is usually the most effective and economical method. When there is impossible or impractical, Transcoat 4000 GF can be applied over mechanically – cleaned surfaces.

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**APPLICATION DATA**

**Applied Over**

**Steel** - Remove all loose rust, dirt, moisture, grease or other contaminants. Power-tool clean, SSPC–SP3 other hand-tool clean, SSPC–SP2. For more severe environments, dry abrasive blast, SSPC-SP7 or higher. Water blasting is also acceptable.

**Concrete** - Acid etch (ASTM D4260) or abrasive blast (ASTM D4259) new concrete.

**Galvanizing** - Remove oil or soap film with detergent or emulsion cleaner, Galvaprep, or blast lightly with fine sand.

**Application Equipments**

**Airless Spray** - Standard equipment such as Graco Bulldog 30:1 (when temperature above 27$^0$C) or Graco 45:1; with surge tank filters removed. Graco Hydra-Mastic gun 207-300 and tip 0.035 inch or larger, with a 3/8- to 1/2- inch spray hose.

**Conventional Spray** - Industrial equipment such as Binks 18 spray gun with a 69SS nozzle and 54-1209 needle. Pump 4:1 or 6:1 ratio with clearance chamber and a Fluidall hose 1/2 inch ID up to 50 feet.

**Power Mixer** - Jiffy mixer powdered with an air or explosion – proof motor.

**Application Procedures**

- Flush all equipments with Thinner Trans 120 before use.
- Stir part A to disperse pigments.
- Add part B to part A. Mix thoroughly until uniformly blended to a workable consistency.
- Do not mix more material than can be used within the expected pot life. Transcoat 4000 GF is sprayable when thinned as recommended. It is possible that mixture will appear fluid beyond this time period, but spraying and film build characteristics may be impaired.
- For optimum application, material should be from 10 to 32$^0$C. Above 43$^0$C sagging may occur.
- Use only Transcoat recommended thinners. Above 29$^0$C use Thinner Trans 80; at lower temperatures use Thinner Trans 650.
  A small amount of thinner greatly reduces viscosity. Excessive thinning will cause running or sagging. Thin cautiously as follows:
  - Airless – no more than 30 ml/L of Thinner Trans 80 to 650.
  - Conventional – no more than 60 ml/L of Thinner Trans 80 or 650
- Apply in even, parallel passes; overlap 50% to avoid holidays, bare areas, and pinholes. If required, cross spray at right angles.
- Ventilate confined spaces with clean air between coats and while curing the final coat.
- Repair any damage by brush or spray.
- Clean equipment with Thinner Trans 120 immediately after use.
- If a second coat of Transcoat 4000 GF is required, observe the following time limits between coats.
  Minimum - 8 hours at 32$^0$C, 16 hours at 21$^0$C, 30 hours at 10$^0$C
  Maximum - 2 months at 32$^0$C, 3 months at 21$^0$C, 3 months at 10$^0$C

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**Environmental Conditions**

During application, drying and curing, maintain air and surface temperature between 0 to 50$^0$C.

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| **Mixing Ratio By Volume** | Base : Hardener = 1 : 1 |
| **Thinner** | Thinner Trans 80 or 650 |
| **Cleaner** | Thinner Trans 120 |
| **Surface Temperature** | Must be at least 3$^0$C above the dew point to prevent condensation |
| **Drying Time** | |
| Touch Dry | 2.5 hours at 32$^0$C, 3 hours at 21$^0$C |
| Through Dry | 11 hours at 32$^0$C, 16 hours at 21$^0$C |
| **Pot Life** | 1 hour at 32$^0$C, 2 hours at 21$^0$C |

**System Compatibility**

**Topcoat**

- Transcoat 782 HB
- Transcoat 3252
- Transcoat 4502 GL

For other suitable 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.

**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.