

**TRANSCOAT 95 FT**  
Inorganic Zinc - Rich Silicate

<b>Product Description</b>	Two component moisture curing zinc rich ethyl silicate primer.	
<b>Recommended Use</b>	As a primer with recommended topcoats to provide excellent protection to steel substrates, for use with a wide range of high performance systems in offshore and onshore environments including structural steelwork, chemical exposure, tank exterior, piping and marine exposure above the saltwater splash zone.	
<b>Characteristics</b>	<ul style="list-style-type: none"> <li>• Fast drying properties permit quick handling and fast top coating.</li> <li>• Tolerate surface temperature up to 400°C.</li> <li>• Suitable for general industrial priming in corrosive atmospheric pressure.</li> <li>• Not recommended for immersion service in acid or alkaline solution.</li> <li>• Good abrasion resistance and minimum burn-back during welding.</li> </ul>	
<b>Physical Data</b>	<b>Colour</b>	Grey
	<b>Gloss Level</b>	Flat
	<b>Volume Solid</b>	Approx. 62%
	<b>Dry Film Thickness</b>	65 microns per coat
	<b>Number of Coat</b>	1
	<b>Theoretical Coverage</b>	9.60 sq.m/ltr for 65 microns
	<b>Temperature Resistance</b>	400°C
	<b>VOC</b>	464 g/ltr
	<b>Flash Point</b>	Liquid : 15°C Powder : 65°C
	<b>Shelf Life</b>	Liquid at least 9 months Powder at least 12 months
	<b>Pack Size</b>	
	5 litre units	Liquid : 4.15 ltrs in 5-ltr plastic jerrycan Powder : 0.85 ltrs in 2.5-ltr can (approx. 6.0 kgs)
<b>Surface Preparation</b>	Dry abrasive blast in accordance with ISO - Sa 2.5 or SSPC - SP 10 "Near White". Blast to achieve a 25 - 50 microns anchor profile as indicate with a Keane Tator Surface Profile Comparator. Remove abrasive residue or dust from surface.	
<b>Application Data</b>	<b>Application Methods</b>	
	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)
	Use pressure pot and agitator	

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Mixing Ratio By Volume	Liquid : Powder = 4.15 ltrs : 6.0 kgs <ul style="list-style-type: none"><li>• Add the powder gradually to the container with base, using a mechanical mixer.</li><li>• Continue stirring until powder is well dispersed.</li><li>• Strain through a 30 - 60 mesh screen.</li><li>• Thin only for workability, do not use more than 10%.</li><li>• Continue slow stirring during application to maintain uniformity of mixed product.</li><li>• Do not keep mixed product, which will not be used before the end of the pot life in tightly closed containers as gassing can create enough pressure to cause containers to burst.</li></ul>
Thinner	Cover containers loosely Thinner Trans 1010
Cleaner	Thinner Trans 120
Surface Temperature	Should be 10°C - 50°C, at least 3°C above the dew point to prevent condensation
Drying Time	
Touch Dry	10 minutes at 25°C, 5 minutes at 32°C
Through Dry	20 minutes at 25°C, 10 minutes at 32°C
To Topcoat	4 hours at 25°C, 2.5 hours at 32°C
Pot Life	24 hours at 25°C, 12 hours at 32°C
Limitation	<ul style="list-style-type: none"><li>• Normal recommended dry film thickness 65 microns, allowable thickness range is 50 - 80 microns, assuming the surface profile is within the recommended range. Greater thickness may occur mud cracking.</li><li>• Zinc rich primers can form zinc salts on the surfaces, before over coating visible surface contamination must be removed by high pressure water cleaning, sweep blasting or mechanical cleaning.</li></ul>

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### System Compatibility

Before over coating with recommended topcoats ensure the Transcoat 95 FT is fully cured and if weathering has occurred all zinc salt should be removed from the surface by fresh water washing, and if necessary scrubbing with bristle brushes.

Typical topcoats and intermediates are:

- Transcoat 3850
- Transcoat 3831 HS
- Transcoat 4000
- Transcoat 662 GL

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In some cases it may be necessary to apply a mist coat of suitable viscosity to minimise bubbling. This will depend upon the age of the Transcoat 95 FT surface roughness and ambient conditions during curing and application.  
For other suitable intermediates or topcoats, please consult Transcoat Protective Coating.

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**Safety Precaution**

**Transcoat 95 FT Liquid**

Flammable, keep away from heat, sparks and open flame. Liquid irritating to eyes and may cause skin irritation. Avoid breathing of vapour or spray mist.

**Transcoat 95 FT Powder**

Will support combustion. Contains zinc dust, dust can be harmful. Mixtures have hazardous of both components. Use only with adequate ventilation during mixing, application and drying. Do not leave mixed product in sealed container beyond the expected pot life as gassing may cause container to burst.

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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.

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