Protective & Marine Coatings

TRANSGARD™ TG115
HI-BUILD EPOXY

Revised 08/2016 Issue 14

PRODUCT INFORMATION

PRODUCT DESCRIPTION

High-build aluminium epoxy maintenance primer for abraded surfaces.

RECOMMENDED USE

For brush application onto hand or mechanically prepared surfaces giving excellent wetting and adhesion characteristics.
Suitable for atmospherically exposed surfaces but not recommended for exposure to severe chemical environments.
May be spray applied to blast cleaned surfaces.
Recommended curing temperature above 10°C. Extended drying times will be observed at lower temperatures. Macropoxy M902 is recommended alternative for low temperature application and curing.

ENDORSEMENTS

Highways Agency Item No.115.

RECOMMENDED APPLICATION METHODS

Brush
May be airless spray applied onto blast cleaned surfaces

Recommended Cleanser Thinner: No. 5 (for thinning)
No. 9 or No. 13 (for cleaning)

PRODUCT CHARACTERISTICS

Flash Point:	Base : 47°C	Additive : 30°C
% Solids by Volume:	75 ± 3% (ASTM-D2697-91)	
Pot Life:	3 hours at 15°C	2 hours at 23°C
Colour Availability:	Aluminium.	

VOC
217 gms/litre determined practically in accordance with UK Regulations PG6/23
249 gms/litre calculated from formulation to satisfy EC Solvent Emissions Directive
194 gms/kilo content by weight from formulation, to satisfy EC Solvent Emissions Directive

RECOMMENDED THICKNESS

Dry film thickness	Wet film thickness	Theoretical coverage
100 microns	133 microns	7.5 m2/ltr*

** This figure makes no allowance for surface profile, uneven application, overspray or losses in containers and equipment. Film thickness will vary depending on actual use and specification.*

PRACTICAL APPLICATION RATES - MICRONS PER COAT

	Brush	Airless Spray
Dry	100*	100
Wet	133	133

** Maximum sag tolerance with overlap typically 300µm dry by airless spray and 140µm by brush.*

AVERAGE DRYING TIMES

	@ 15°C	@ 23°C
To touch:	6 hours	3 hour
To recoat:	16 hours	8 hours
To handle:	24 hours	16 hours

These figures are given as a guide only. Factors such as air movement and humidity must also be considered.

RECOMMENDED UNDERCOATS

Transgard TG116

RECOMMENDED TOPCOATS

For overcoating with epoxy products (including self overcoating), the maximum recommended interval is 28 days at 23°C. For overcoating outside this interval, consult Sherwin-Williams.

PACKAGE

A two component material supplied in separate containers to be mixed prior to use.

Pack Size:	20 litre and 5 litre units when mixed.
Mixing Ratio:	7 parts base to 1 part additive by volume
Weight:	1.29 kg/litre
Shelf Life:	2 years from date of manufacture or 'Use By' date where specified.

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SURFACE PREPARATION

Blast clean to Sa2½ BS EN ISO8501-1:2007. Average surface profile in the range 50-75 microns.
Manually prepared surfaces should be prepared to a minimum standard of ST3 BS EN ISO8501-1:2007 at the time of coating. Ensure surface to be coated are clean, dry and free from all surface contamination.

APPLICATION EQUIPMENT

Airless Spray

Nozzle Size	: 0.38mm (15 thou)
Fan Angle	: 40°
Operating Pressure	: 155kg/cm² (2200 psi)

The airless spray details given above are intended as a guide only. Details such as fluid hose length and diameter, paint temperature and job shape and size all have an effect on the spray tip and operating pressure chosen. However, the operating pressure should be the lowest possible consistent with satisfactory atomisation. As conditions will vary from job to job, it is the applicators' responsibility to ensure that the equipment in use has been set up to give the best results. If in doubt Sherwin-Williams should be consulted.

Brush :
The material is suitable for brush application.

APPLICATION CONDITIONS AND OVERCOATING

Epoxy paints should preferably be applied at temperatures in excess of 10ºC. Relative humidity should not exceed 90% and in these conditions good ventilation is essential. Substrate temperature should be at least 3ºC above the dew point and always above 0°C. Application at ambient air temperatures below 5°C is not recommended.
In order to achieve optimum water and chemical resistance, temperature needs to be maintained above 10ºC during curing.

If it is desired to overcoat outside the times stated on the data sheet, please seek advice of Sherwin-Williams.

ADDITIONAL NOTES

Drying times, curing times and pot life should be considered as a guide only.

The curing reaction of epoxies commences immediately the two components are mixed, and since the reaction is dependent on temperature, the curing time and pot life will be approximately halved by a 10°C increase in temperature and doubled by a 10°C decrease in temperature.

Compatibility - This product is fully compatible with Epigrip M902 (Item 115 low temperature curing grade) and the two products may be interchanged within any specification requiring the use of Item 115, depending upon the application conditions.

Epoxy Coatings - Colour Stability:
Variable colour stability is a feature of epoxy materials which tend to yellow and darken with age whether used on internal or external areas. Therefore any areas touched-up and repaired with the same colour at a later date may be obvious due to this colour change.

When epoxy materials are exposed to ultra-violet light a surface chalking effect will develop. This phenomenon results in loss of gloss and a fine powder coating at the surface which may give rise to colour variation depending on the aspect of the steelwork. This effect in no way detracts from the performance of the system.

Epoxy Coatings - Tropical Use
Epoxy paints at the time of mixing should not exceed a temperature of 35°C. At this temperature the pot life will be approximately halved. Use of these products outside of the pot life may result in inferior adhesion properties even if the materials appear fit for application. Thinning the mixed product will not alleviate this problem.

The maximum air and substrate temperature for application is 50°C providing conditions allow satisfactory application and film formation. If the air and substrate temperatures exceed 50°C and epoxy coatings are applied under these conditions, paint film defects such as dry spray, bubbling and pinholing etc. can occur within the coating.

Numerical values quoted for physical data may vary slightly from batch to batch.

HEALTH AND SAFETY

Consult Product Health and Safety Data Sheet for information on safe storage, handling and application of this product.

WARRANTY

Any person or company using the product without first making further enquiries as to the suitability of the product for the intended purpose does so at their own risk, and Sherwin-Williams can accept no liability for the performance of the product, or for any loss or damage arising out of such use.

The information detailed in this Data Sheet is liable to modification from time to time in the light of experience and of normal product development, and before using, customers are advised to check with Sherwin-Williams, quoting the reference number, to ensure that they possess the latest issue.