



Protective & Marine Coatings

TRANSGARD™ TG110 ZINC PHOSPHATE PRIMER

Revised 03/2016 Issue 9

PRODUCT INFORMATION

PRODUCT DESCRIPTION

A zinc phosphate pigmented 2-pack epoxy temporary protective primer

RECOMMENDED USE

Temporary protective for steel surfaces prepared by abrasive blast cleaning.
Suitable for use in conjunction with cathodically protected steel.
Suitable for fabrication and for overcoating with most paints in common use except high content metallic zinc products

ENDORSEMENTS

Highways Agency Item No. 110.

RECOMMENDED APPLICATION METHODS

Airless Spray
Conventional Spray
Brush (for small areas and touch up only)
Roller

Recommended Cleanser Thinner: No 5

PRODUCT CHARACTERISTICS

Flash Point:	Base : 9°C	Additive : 12°C
% Solids by Volume:	36± 2% (ASTM-D2697-91)	
Pot Life:	10 hours at 15°C	8 hours at 23°C
Colour Availability:	Cinnamon	

VOC

584 gms/litre determined practically in accordance with UK Regulations PG6/23

584 gms/litre calculated from formulation to satisfy EC Solvent Emissions Directive

423 gms/kilo content by weight from formulation, to satisfy EC Solvent Emissions Directive

RECOMMENDED THICKNESS

Dry film thickness	Wet film thickness	Theoretical coverage
25 microns	70 microns	14.4 m ² /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

	Airless Spray	Conventional Spray	Roller
Dry	25	25	25
Wet	70	70	70

AVERAGE DRYING TIMES

	@ 15°C	@ 23°C
To touch:	30 minutes	20 minutes
To recoat:	6 hours	4 hours
To handle:	3 hours	2 hours

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

RECOMMENDED TOPCOATS

Indefinitely overcoatable with epoxy systems provided the surfaces to be coated have been suitably cleaned.

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:	4 parts base to 1 part additive by volume.
Weight:	1.38 kg/litre
Shelf Life:	12 months from date of manufacture or 'Use By' date where specified



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SURFACE PREPARATION

For optimum performance use round steel shot and blast clean to Sa2½ BSEN ISO 8501-1:2007). Average surface profile in the range 30-50 microns. Ensure surfaces to be coated are clean, dry and free from all surface contamination.

APPLICATION EQUIPMENT

Airless Spray

Nozzle Size	:	0.46-0.53mm (18-21 thou)
Fan Angle	:	80°
Operating Pressure	:	155kg/cm ² (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.

Conventional Spray

Nozzle Size	:	1.27mm (50 thou)
Atomising Pressure	:	3.5kg/cm ² (50 psi)
Fluid Pressure	:	1.0kg/cm ² (15 psi)

The details of atomising pressure, fluid pressure and nozzle size are given as a guide. It may be found that slight variations of pressure will provide optimum atomisation in some circumstances according to the set up in use. Atomising air pressure depends on the air cap in use and the fluid pressure depends on the length of line and direction of feed i.e. horizontal or vertical.

Brush

The material is suitable for brush application to small areas and for touch up purposes. To achieve normal dry film thicknesses by brush more than one coat will be necessary.

Roller

The material is suitable for roller application.

Preparation and Build Up:

The applied dry film thickness of prefabrication primers is normally below 30 microns. At this level of dry film thickness factors such as blast profile, unevenness of application and severity of exposure conditions may significantly affect the performance.

APPLICATION CONDITIONS AND OVERCOATING

Epoxy paints should preferably be applied at temperatures in excess of 10°C. In conditions of high relative humidity, ie 80-85% good ventilation conditions are essential. Substrate temperature shall be at least 3°C above the dew point and always above 0°C.

At application temperatures below 10°C, drying and curing times will be significantly extended, and spraying characteristics may be impaired.

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 10°C 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.

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.