Transpoxy Masterbond BT

Product code:
TO 4.68

Transpoxy Masterbond BT is an high solids primer/coating with excellent anticorrosive properties under severe corrosive conditions.
The product has an increased tolerance to damp substrates and can be used at temperatures down to 0°C.
Transpoxy Masterbond BT offers good adhesion to blast cleaned steel, weathered (shop) primers as well as a variety of aged coatings. In maintenance conditions it tolerates a lower degree of surface preparation and can be used in combination with mechanical power tooling or high pressure water jetting as surface preparation. Due to its phenolic functional epoxy-amine crosslinking, the products offers good chemical resistance against various fuels and hydrocarbons.
The product carries various (system) approvals from oil companies and is an approved coating according to IMO-PSPC for usage in Crude Oil - and Ballast tanks.

Physical properties:

Colour	Grey, Redbrown, Aluminium, selected other colours
Gloss / Appearance	Semi-gloss
Volume Solids	Approx. 78 %
Specific gravity	Approx. 1.4 g/ml
VOC	Approx. 220 g/liter
Flashpoint	Base >25 °C Hardener >40 °C

Usage data:

Mixing ratio 75:25 [3:1]

Film thickness	Dry film thickness per coat (µm)	Wet film thickness per coat (µm)	Theoretical spreading rate (m²/l)
Range	100 - 300	130 - 385	7.8 - 2.6
Recommended	150	190	5.3

Curing Times	Substrate temperature			
	10°C	23°C	30°C	40°C
Touch dry	4 Hours	2 Hours	1 Hour	45 Minute
Dry to handle	12 Hours	8 Hours	4 Hours	2 Hours
Full cure	8 Days	5 Days	3 Days	1 Days
Potlife	4 Hours	2 Hours	1 Hour	30 Minutes

Drying and curing times are determined under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product and should be considered as guidelines only.
The actual drying time may be shorter or longer, depending on film thickness, temperature, ventilation, humidity, preceding paint system etc.

Recoating intervals - see application section

	Substrate temperature							
	10°C		23°C		30°C		40°C	
Recoated with	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.
Single pack products	24 Hours	7 Days	18 Hours	4 Days	12 Hours	2.5 Days	3 Hours	18 Hours
2-pack products	16 Hours		12 Hours		8 Hours		4 Hours	

Recoating information is for guidance only and varies with local climate and environmental conditions. For specific recommendations, consult your local Transocean representative.
Best intercoat adhesion is achieved when the subsequent coat is applied before the preceding coat has fully cured.
Extended recoating intervals apply only to ambient atmospheric exposure. After prolonged exposure, roughen the surface to ensure intercoat adhesion.

Surface Preparation:

Steel - Blast cleaning
All surfaces should be clean, dry and free from contamination. Surfaces should be treated in accordance with ISO 8504:2000.
All edges shall be ground to a minimum radius of 2 mm. Remove weld spatter and smooth weld seams by using disc grinders, chipping hammers or other suitable power tools. Sharp edges, weld seams, corners and other areas that are likely to receive less dry film thickness than specified, should be stripe coated. The surfaces shall be blast-cleaned to min. Sa 2½ (ISO 8501-1:2007). The surface profile and the anchor pattern shall be between 40 µm and 70 µm. The abrasives shall be free from oil, grease, moisture, chloride contamination etc.

Minor repair / Touch-up
All surfaces should be clean, dry and free from contamination. Surfaces should be treated in accordance with ISO 8504-1:2001. Any corroded areas should be prepared by power-tool cleaning or water jetting.
Power-tool cleaning to min. St 2, preferably St 3 (ISO 8501-1:2007). Care shall be taken to ensure that power-tool cleaning does not polish the steel surface. If the surface being prepared lies adjacent to a coated surface, the power tool cleaning shall overlap the coated surface by at least 25 mm and the coated surface shall be feathered.
Water jetting in accordance to ISO 8501-4: 2006 to a cleanliness of Wa 2 or better for atmospheric exposure. Acceptable flash rust degree is M (medium) but degree L (light) is preferred. A water pressure of at least of 1000 bar (approx. 15.000 psi) is recommended.

Major repair/ Refurbishment
All surfaces should be clean, dry and free from contamination. Surfaces should be treated in accordance with ISO 8504-1:2001. Corroded areas to be prepared by blast cleaning or water jetting.
Blast Cleaning: The surfaces shall be blast-cleaned to min. Sa 2½ (ISO 8501-1:2007). The abrasives shall be free from oil, grease, moisture, chloride contamination etc.
Water jetting: Water jetting in accordance to ISO 8501-4: 2006 to a cleanliness of Wa 2,5. Acceptable flash rust degree is M (medium) but degree L (light) is preferred. A water pressure of at least of 1000 bar (approx. 15.000 psi) is recommended.
Alternatively a suitable priming system can be used. When recoating zinc primed products, ensure the primer has been fully cured. Zinc salts products shall be removed by high pressure fresh water cleaning. Contact your local Transocean office for more information.

Steel - Power-tool Cleaning
All surfaces should be clean, dry and free from contamination. Surfaces should be treated in accordance with ISO 8504:2000. Power-tool cleaning to St 3 (ISO 8501-1:2007). Care shall be taken to ensure that power-tool cleaning does not polish the steel surface. If the surface being prepared lies adjacent to a coated surface, the power tool cleaning shall overlap the coated surface by at least 25 mm and the coated surface shall be feathered.
Water jetting
Surfaces should be treated in accordance with ISO 8504-1:2001. All surfaces should be clean, dry and free from contamination. Water jetting in accordance to ISO 8501-4: 2021 to a cleanliness of Wa 2 or better for atmospheric exposure and Wa 2,5 for immersion. Acceptable flash rust degree is M (medium) but degree L (light) is preferred. A water pressure of at least of 1000 bar (approx. 15.000 psi) is recommended.

Coated substrates
All surfaces should be clean, dry and free from contamination. Surfaces should be treated in accordance with ISO 8504. Ensure compatibility of the coated substrates with the selected paint system. If the remaining part of the existing coating system needs to be sweep-blasted, fine abrasive shall be used to avoid damage to the coating system. When recoating aged coated substrates, damaged areas must be removed back to a firm edge. Light abrade or sweep-blast the surface in order to provide a physical key for adhesion.
When recoating zinc primed products, ensure the primer has been fully cured. Zinc salts products shall be removed by high pressure fresh water cleaning. Contact your local Transocean office for more information.

Application:

Mixing:

Conditions:

The relative humidity should be <90% during application and curing, unless otherwise specified in the product documentation. The substrate temperature should be ≥5°C and ≥3°C above the dew point of the air. Air temperature and relative humidity should be measured at substrate.
Generally, the maximum recommended surface temperature is 40°C. Higher substrate temperatures are acceptable provided dryspray is avoided by proper spray application and extra thinning if required. In extreme cases it may be necessary to reduce film thickness in order to avoid sagging.

Methods:

Guiding data Airless spray	Pressure at nozzle	180 - 250 bar
		0.41 - 0.58 mm (0.016 - 0.023 in.)
	Spray angle	40 - 80 degrees
	Volume of thinner	0 - 5%
Guiding data Airspray	Pressure	Not applicable
	Nozzle size	-
	Volume of thinner	-
Brush / Roller	Suitable. Multicoats may be needed to achieve the specified dry film thickness. Volume of thinner: 0 - 5%.	
Thinner	Transocean Epoxy Thinner 6.03 If thinning is necessary, this should be added after mixing of the two components. The recommended level of thinner is dependent on thickness and conditions. In certain circumstances, it may be required to exceed the stated level of thinner. However, as a general rule do avoid excessive thinning as it will result in lower sag resistance and slower cure. In addition it may cause solvent entrapment, possibly risking blistering, pinholing and/or other coating defects.	
Cleaner	Transocean Epoxy Thinner 6.03	

Film thickness.

The paint must be applied as a continuous layer and as close to the specified wet film thickness as possible. Use a wet film thickness gauge to verify that the correct wet film thickness is applied. Over application, excessive thinning, wrong application techniques etc. may lead to runs and sagging of the paint. When the paint is still wet, such effects can be rectified by brushing out the defected areas. When the defect is noticed after curing of the paint, repair the affected areas by disc sanding to an even smooth surface and apply an additional coat of paint.

Stripe Coating.

Stripe coating may be required to achieve the specified film thickness on specific areas such as edges, corners, weld seams etc. Use a round brush and ensure proper wetting of all areas. Avoid excessive application as it will lead to brush marks and may also result in air entrapment, which is detrimental to the paint's performance.

Additional Product information:

Storage and shelf life

Storage: Store the product in compliance with national regulations in a dry, cool, well-ventilated area, away from heat and ignition sources. Keep materials in tightly closed original containers until use. Securely re-seal partially used containers and store as recommended. (See Section 7 of the relevant SDS.)

Shelf life: The stated value is a minimum; refer to “Guidance to Transocean Coatings Product Datasheets” for details.
Shelflife Component A (base): 12 Months
Shelflife Component B (hardener): 24 Months

Health and safety

Observe the safety warnings on the container label. A Safety Data Sheet (SDS) is available upon request.Comply with all applicable national and local safety regulations.
For professional use only. Wear appropriate PPE (overalls, gloves, goggles, respiratory protection, etc.) to avoid skin and eye contact.
Spraying should be carried out under well-ventilated conditions. If the product is flammable (see label/SDS), keep away from sparks, open flames, and heat sources. No smoking in the work area.
Avoid inhaling vapors and particulates. Maintain airborne concentrations below Occupational Exposure Limits (OEL) through adequate natural ventilation during application and drying.
In enclosed areas with insufficient ventilation, use local exhaust ventilation. If this is not feasible, wear a suitable respirator. Users must be trained in its proper use and limitations.

Disclaimer

The information in this Product Data Sheet is provided in good faith and based on our current knowledge. However, Transocean Coatings cannot control substrate quality, surface preparation, application conditions, or environmental factors that may affect product application and performance. Accordingly, we accept no liability for the performance of this product or for any loss, damage, or injury arising from its use, whether direct, indirect, or consequential. Should any conflict arise between translations, the English version of this Product Data Sheet is authoritative and binding.

This Data Sheet supersedes all previous versions and must be communicated to all users. Users must:
- Conduct their own trials to verify the product’s suitability for their specific application and intended purpose.
- Confirm compatibility with intended substrates and conditions, which are beyond our control.
- Implement appropriate quality control procedures during application.
- Verify suitability for circumstances not covered in this Data Sheet.

Transocean Coatings maintains a policy of continuous product development. Technical data may be revised as new information or experience becomes available. For further information, contact our Technical Department.

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