Transpoxy Primer

Product code:
TO 1.16

A two pack polyamide cured epoxy primer for the protection of steel structures against corrosion in industrial and marine environments.
Suitable to be used as holding primer for refurbishment of large steel areas such as ship's hulls, cargo holds and decks.
Transpoxy Primer can also be applied as a tiecoat on inorganic zinc silicates, providing an excellent base for further system build-up. It can be recoated with a wide range of Transocean products.

Physical properties:

Colour	Red, Grey, selected other colours
Gloss / Appearance	Flat
Volume Solids	Approx. 45 %
Specific gravity	Approx. 1.3 g/ml
VOC	Approx. 464 g/liter
Flashpoint	Base >14°C Hardener >25°C

Usage data:

Mixing ratio 80:20 [4:1]

Film thickness	Dry film thickness per coat (µm)	Wet film thickness per coat (µm)	Theoretical spreading rate (m²/l)
Range	30 - 60	65 - 135	15 - 7.5
Recommended	50	100	9.0

Curing Times	Substrate temperature			
	10°C	23°C	30°C	
Touch dry	90 Minutes	30 Minutes	20 Minutes	
Dry to handle	8 Hours	4 Hours	3 Hours	
Full cure	10 Days	7 Days	5 Days	
Potlife	12 Hours	8 Hours	5 Hours	

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			
Recoated with	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.
Single pack products								
2-pack products	24 Hours	Indefinite	8 Hours	Indefinite	6 Hours	Indefinite		

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.

Galvanized steel
All surfaces should be clean, dry and free from contamination. Surfaces should be treated in accordance with ISO 8504:2000. So called 'white' zinc corrosion products should be removed by high pressure fresh water cleaning or blast cleaning. Blast cleaning shall be carried out by smooth sweep blasting, using a fine non-iron containing abrasive (e.g. aluminium oxide). The abrasives shall be free from oil, grease, moisture, chloride contamination etc. Surface roughness shall be in the range of 20 µm to 30 µm.

Ensure the zinc layer shall not be damaged; a smooth uniform surface roughness shall be achieved. No defects such as break through or crisping of the zinc layer shall occur.

Stainless Steel
All surfaces should be clean, dry and free from contamination. Surfaces should be treated in accordance with ISO 8504:2000. Blast cleaning shall be carried out by smooth sweep blasting, using a fine non-iron containing abrasive (e.g. aluminium oxide). The abrasives shall be free from oil, grease, moisture, chloride contamination etc. Surface roughness shall be in the range of 20 µm to 30 µm.

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	120 - 150 bar
		0.38 - 0.53 mm (0.015 - 0.021 in.)
	Spray angle	40 - 80 degrees
	Volume of thinner	0 - 3%
Guiding data Airspray	Pressure	3 - 5 bar
	Nozzle size	1.2 - 2.0 mm
	Volume of thinner	0 - 10%
Brush / Roller	Suitable for stripe coats and touch-up work only. 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	

Additional usage instructions
Recoating inorganic zinc silicates.

Ensure the zinc silicate should be fully cured prior to recoating. This can be checked by executing the MEK rub test according to ASTM 4752. After 50 double rubs with a cloth soaked in MEK, the zinc silicate coating should not dissolve.
In case MEK is not available, Transocean Thinner 6.07 or Thinner 6.08 may be used alternatively.

Un weathered zinc silicate films are porous and the porosity may vary according to the weather condition during application and the application technique. When recoating, the air in the pores will escape through the new coat of paint and may cause blisters or pinholes ("popping") in the coat just after application. To avoid this a mist coat/full coat technique is recommended.
First apply a thin coat of thinned Transpoxy Primer (use 10-30 % Transocean Thinner 6.03) to fill the pores in the zinc silicate film. The amount of thinner required depends on various conditions such as level of porosity in the zinc silicate as well as local conditions.
Apply a few minutes later a coat of Transpoxy Primer, which has been not thinned or thinned according the specifications in this datasheet, to full specified film thickness.

Additional Product information:

Application guideline

For this type of coating it is advised to use a heavy duty single feed airless. Compression 45 : 1, but preferably 60 : 1

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: 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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