



Product Data Sheet

Transobox

Epoxy Ester Primer 81.85

Product description.

A quick drying, single pack primer based on durable epoxy ester resins having an excellent resistance to moisture and salt spray. The product is free from toxic chromate- and lead pigments. Designed to be overcoated by Transobox Epoxy ester Finish 83.85.

Physical properties.

Colour/Texture Cinnamon/Matt
 Volume Solids 32%
 Specific gravity 1.2 gr/ml
 VOC 591 gr/litre
 Flashpoint >25°C

	Dry film thickness per coat (μ)	Wet film thickness per coat (μ)	Theoretical spreading rate (m ² /l)
Range	30 – 50	95 –155	10.7 – 6.4
Recommended	40	125	8.5

Application data.

Guiding data Airless spray Pressure at nozzle: 120 –150 bar. Nozzle size: 0.38 - 0.53 mm.
 Spray angle: 40 - 80 degrees.
 Volume of thinner: 0 – 3%.

Guiding data Airspray Pressure. 3 – 4 bar. Nozzle size: 1.2 - 2.0 mm.
 Volume of thinner: 0 – 5%.

Brush/Roller Suitable. Multicoats may e needed to achieve the required dry film thickness.
 Volume of thinner: not more than 10%.

Thinner/Cleaner Transocean Special Thinner 6.01.
 Avoid excessive thinning as it will result in lower sag resistance and slower cure.

Drying and recoating times (1).

Substrate temperature	Touch dry	Dry to handle	Full cure	Dry to recoat	
				Minimum	Maximum (2)
10 °C	2 hours	8 hours	2 days	8 hours	Indefinite
23 °C	1 hour	4 hours	1 day	4 hours	Indefinite
30 °C	30 minutes	2 hours	1 day	2 hours	Indefinite

(1) The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, preceding paint system etc

(2) The surface should be dry and free from contaminants prior to overcoating. After prolonged exposure times it may be necessary to roughen the surface to ensure intercoat adhesion.
 When in doubt, consult your nearest Transocean office.

Surface preparation.

Steel	Oil and grease should be removed by solvent cleaning according to SSPC-SP1. Remove weld spatter and smooth weld seams and sharp edges as applicable. Abrasive blasting: min. Sa 2,5 – ISO 8501:1. Apply Transobox Epoxy Ester Primer 81.85 immediately after the steel has been blasted and the quality of preparation has been approved.
Repair	Corroded areas should be power tool cleaned to ISO-St 3 or blast cleaned to ISO-Sa 2 or better. Existing systems should be dry and free from loose paint, salt, grease and other contaminants prior to overcoating.

Recommended paint system.

A typical system for the exteriors of containers is shown below. This system is particularly recommended for open-top containers since the use of thermoplastic coatings may cause in sticking of the plastic covers to these coatings.

Transobox Epoxy Ester Primer 81.85	1 x 40 µ dft.
Transobox Epoxy Ester Finish 83.85	1 x 60 µ dft.

Application conditions.

The temperature of the substrate should be at least 3°C above the dew point of the air. Temperature and relative humidity should be measured in the vicinity of the substrate. The maximum recommended surface temperature is approx. 40°C. Higher steel temperatures are acceptable provided dry-spray 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. When applying the paint in confined spaces, provide adequate ventilation during application and drying. The temperature of the mixed paint should be at least 15°C, otherwise extra solvent may be required to obtain a proper application viscosity.

Storage and shelf life.

The product must be stored in accordance with national regulations. The cans are to be kept in a dry, cool, well ventilated space and away from source of heat and ignition. Cans must be kept tightly closed.

Worldwide availability

The product is part of the common Transocean product range but local availability is subject to confirmation. Although we strive to supply the same product through the world, slight modifications of the product in some cases may be necessary in order to comply with local conditions and/or national regulations. In such cases an alternative datasheet will be issued.

Health and safety.

Observe the precautionary notices on the label of the container. A material safety data sheet is available upon request and national or local safety regulations should be followed. This product is intended for use by professional applicators.

As a general rule, avoid skin- and eye contact by wearing overalls, gloves, goggles, mask, etc. Spraying should be carried out under well-ventilated conditions. This product contains flammable materials and should be kept away from sparks and open flames. Smoking in the area should not be permitted.

Disclaimer

The information in this data sheet is provided to the best of our knowledge. However, we have no control over either quality or condition of the substrate and other factors affecting the use and application of this product. Therefore, we cannot accept any liability whatsoever or howsoever arising from the performance of the product or for any loss or damage arising from the use of this product. We reserve the right to change the product without notice.

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