



# Product Data Sheet

## Transozinc Epoxy Primer ST 1.50

### Product description.

A two pack epoxy primer pigmented with zinc dust for an excellent protection of steel structures against corrosion in industrial and marine environments. The primer is especially recommended when (ultra) high-pressure hydroblasting is utilized as surface preparation. The product also tolerates Sa2- and St3 prepared substrates.

### Physical properties.

Colour / Texture                      Green / Matt  
 Volume Solids                        48%  
 Specific gravity                       2.2 gr/ml  
 VOC                                        438 gr/litre  
 Flashpoint                              >7°C

	Dry film thickness per coat (µ)	Wet film thickness per coat (µ)	Theoretical spreading rate (m <sup>2</sup> /l)
Range	50 – 80	105 –170	9.6 – 6.0
Recommended	50	105	9.6

### Application data.

Mixing ratio                              By volume, base to hardener:    88.4 : 11.6.

Pot-life                                      10°C: 6 hours,    23°C: 4 hours,    30°C: 2 hours.

Induction time                            None.

Guiding data - Airless spray        Pressure at nozzle: 180 -300 bar. Nozzle size: 0.38 - 0.53 mm.  
 Spray angle: 40 - 80 degrees.  
 Volume of thinner: 0 – 3%.

Guiding data - Airspray                Pressure. 4 - 6 bar. Nozzle size: 1.2 - 2.0 mm.  
 Volume of thinner: 0 – 10%.

Brush / Roller                            Suitable but in general recommended for touch-up of small areas. Multiple coats are required to achieve the specified dry film thickness.  
 Volume of thinner: 0 – 5%.

Thinner / Cleaner                        Transocean Epoxy Thinner 6.03  
 If thinning is necessary, this should be added after mixing of the two Components. Avoid excessive thinning as it will result in lower sag resistance and slower cure.

### Drying and recoating times.

Substrate temperature	Touch dry	Dry to handle	Full cure	Dry to recoat	
				Minimum	Maximum (2)
5 °C	60 minutes	18 hours	14 days	24 hours	3 months
10 °C	40 minutes	12 hours	7 days	18 hours	3 months
23 °C	15 minutes	4 hours	5 days	8 hours	3 months

(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. When the maximum recoating time is exceeded 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. Sa2,5 – ISO 8501:1. Hydroblasting: DW-3 according to STG-2222. Water pressure > 1000 bar (or 15000 psi) Apply Transozinc Epoxy Primer ST 1.50 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-St3, blast cleaned to ISO-Sa2 or better or Hydroblasted to DW 2-3. Existing systems should be dry and free from loose paint, salt, grease and other contaminants prior to overcoating.

### Recommended paint system.

Transozinc Epoxy Primer ST 1.50                      1 x 50-80 µ dft.

Subsequent anti-corrosive coating with Transpoxy, Transvinyl or Transoprene products.

### 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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