



Product Data Sheet

Transpoxy ARC 92.24

Product description.

A polyamine cured epoxy coating reinforced with a high content of extremely durable pigments. It combines an excellent abrasion resistance with premium anticorrosive properties and is compatible with properly applied cathodic protection. The product was tested and approved according to the requirements of Norsok M-501 standard.

Physical properties.

Colour/Texture	AS2700 Mid Grey N52/Semi-gloss
Volume Solids	80%
Specific gravity	1.55 gr/ml
VOC	179 gr/liter
Flashpoint	>25 °C

	Dry film thickness per coat (μ)	Wet film thickness per coat (μ)	Theoretical spreading rate (m ² /l)
Range	100 – 400	125 – 500	8.0 – 2.0
Recommended	150	190	5.3

Application data.

Mixing ratio By weight, base to hardener: 91.7 to 27.8
By volume, base to hardener: 3 to 1.

Potlife 10 °C: 2 hours, 20 °C: 90 minutes, 30 °C: 45 minutes

Guiding data Airless spray Pressure at nozzle: 150 -250 bar. Nozzle size: 0.38 - 0.66 mm.
Spray angle: 40 - 80 degrees.
Volume of thinner: 0 – 3%.

Brush/Roller Suitable for touch-up work only.

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 (1).

Substrate temperature	Touch dry	Dry to handle	Full cure	Dry to recoat	
				Minimum	Maximum (2)
10 °C	4 hours	16 hours	7 days	16 hours	5 days
23 °C	2 hours	8 hours	5 days	8 hours	4 days
30 °C	1 hour	4 hours	2 days	4 hours	2 days

(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. Apply Transpoxy ARC immediately after the steel has been blasted and the quality of preparation has been approved. Transpoxy ARC may also be applied on Transpoxy primers such as Transozinc Epoxy Primer ST 1.50. Ensure that primed surfaces are dry and free from salts and other contaminants prior to overcoating.
Repair	Corroded areas should be power tool cleaned to ISO-St3 or blast cleaned to ISO-Sa2 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 immersion conditions is shown below.

Transpoxy ARC 92.24	2 x 125 μ dft.
Transvinynox HS 2.06	1 x 75 μ dft.

Subsequent coating with an appropriate Transocean Antifouling system.

Application conditions.

The temperature of the substrate should be at least 10°C and 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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