



# Product Data Sheet

## Transpoxy HS Primer 91.81

### Product description.

A high solids epoxy coating pigmented with zinc phosphate. Transpoxy HS Primer offers excellent durability and corrosion resistance. The product complies with the UK-Highway Agency coating specifications for bridges. It can be recoated with various Transpoxy or Transurethane systems.

### Physical properties.

Colour / Texture	Light Grey N35, Sand Y44 / Matt
Volume Solids	71%
Specific gravity	1.5 g/ml
VOC	196 g/litre
Flashpoint	Both base and hardener >25°C

	Dry film thickness per coat (µm)	Wet film thickness per coat (µm)	Theoretical spreading rate (m <sup>2</sup> /l)
Range	60 – 220	85 – 310	7.7 – 2.5
Recommended	100	140	7.1

### Application data.

Mixing ratio By volume, base to hardener: 4:1

Pot-life 10°C: 4 hours, 23°C: 2 hours, 30°C: 1 hours.

Guiding data - Airless spray Pressure at nozzle: 180 -250 bar. Nozzle size: 0.38 - 0.53 mm.  
Spray angle: 40 - 80 degrees.  
Volume of thinner: 0 - 5%.

Brush / Roller Suitable. Multiple coats are required to achieve the specified dry film thickness. Volume of thinner: 0 - 10%.

Thinner / Cleaner Transocean Epoxy Thinner 6.03.

Conditions Humidity: below 85% RH.  
Temperature of the paint before application: min: 5°C, max: 30°C.  
Substrate temperature: min: 0°C, max: 35°C.  
The temperature of the substrate should be at least 3°C above the dew point of the air. Air temperatures and relative humidity must be measured in the vicinity of the substrate.

### Drying and recoating times.

Substrate temperature	Touch dry	Dry to handle	Full cure	Dry to recoat	
				Minimum	Maximum (1)
10 °C	2.5 hours	8 hours	14 days	7 hours	3 months
23 °C	1.5 hours	2.5 hours	7 days	3 hours	3 months
30 °C	1 hour	2 hours	4 days	2 hours	3 months

(1) 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 HS Primer 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 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 high performance system for atmospheric conditions is shown below.

Transpoxy HS Primer 91.81	1 x 100 µm dft.
Transpoxy Masterbond 4.67N	1 x 105 µm dft.
Transurethane Finish HB 3.44	1 x 75 µm dft.

## 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. Spillage on the skin should immediately be removed by thorough washing with lukewarm water and soap or a suitable industrial cleaner. Eyes should be flushed with fresh water and medical attention sought immediately.

Spraying should be carried out under well-ventilated conditions. Avoid inhalation of solvent vapours and paint mist by wearing an air mask.

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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