



Product Data Sheet

Transpoxy Intermediate 2.19

Product description.

A polyamide cured epoxy coating suitable for atmospheric and immersion conditions. The product is especially suitable as an intermediate coat between organic and inorganic zinc-rich primers and the final topcoat. Can be recoated with all Transocean Finishing series. The product complies with FDA §175.300 for the carriage of dry foodstuffs.

Physical properties.

Colour / Texture White, other colours on request / Matt
 Volume Solids 48%
 Specific gravity 1.36 gr/ml
 VOC 447 gr/litre
 Flashpoint >16°C

	Dry film thickness per coat (μ)	Wet film thickness per coat (μ)	Theoretical spreading rate (m ² /l)
Range	75 – 150	155 – 315	6.4 – 3.2
Recommended	100	210	4.8

Application data.

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

Pot-life 10°C: 12 hours, 23°C: 8 hours, 30°C: 6 hours.

Guiding data - Airless spray Pressure at nozzle: 120 -180 bar. Nozzle size: 0.48 - 0.66 mm.
 Spray angle: 40 - 80 degrees. Volume of thinner: 0 - 3%.

Guiding data – Air spray Pressure. 3 - 5 bar. Nozzle size: 1.5 - 2.0 mm.
 Volume of thinner: 0 -10%.

Brush / Roller Suitable. Multiple coats may be needed 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)
10 °C	12 hours	36 hours	14 days	16 hours	5 days
23 °C	6 hours	24 hours	7 days	8 hours	3 days
30 °C	4 hours	12 hours	5 days	6 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. The best intercoat adhesion is achieved when the subsequent coat is applied before the preceding coat is fully cured. After prolonged exposure times it may be necessary to roughen the surface to ensure intercoat adhesion. When recoating with single pack products, maximum recoat interval is limited to 16-24 hours. When in doubt, consult your nearest Transocean office.

Surface preparation.

Coated substrates	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. Remove salts and dirt by fresh water washing. Corroded and/or damaged areas should be repaired first with an appropriate primer system.
Inorganic Zinc Silicates	Remove zinc-salts and ensure that the zinc silicate has been fully cured. Apply a mist coat of Transpoxy Intermediate 2.19 first.

Recommended paint system.

A typical system for atmospheric exposure is shown below.

Transozinc Epoxy Primer ST 1.50	1 x 50 μ dft.
Transpoxy Intermediate 2.19	1 x 100 μ dft.
Transurethane Finish 3.43	1 x 40 μ dft.

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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