



Product Data Sheet

Transpoxy HB 4.73

Product description.

A polyamine cured epoxy coating for the protection of steel structures in a marine environment. The coating offers excellent corrosion protection and offers fast curing with a reasonable pot-life. It can be applied to humid substrates and is resistant to early water exposure. Suitable for ballast tanks, cargo holds, hulls, splash zone areas and other sections where a heavy duty coating is required.

Physical properties.

Colour / Texture	White / Semi-gloss
Volume Solids	85%
Specific gravity	1.6 g/ml
VOC	167 g/litre
Flashpoint	Base >25°C / Hardener >25°C

	Dry film thickness per coat (µm)	Wet film thickness per coat (µm)	Theoretical spreading rate (m ² /l)
Range	200 – 500	235 – 600	5.0 – 1.6
Recommended	250	300	3.3

Application data.

Mixing ratio By volume, base to hardener: 80 : 20

Pot-life 5°C: 1,5 hours, 23°C: 1 hour, 35°C: 30 minutes.

Guiding data - Airless spray Heavy duty single feed airless equipment is advised. Compression 60 : 1. Pressure at nozzle: 180 – 250 bar. Nozzle size: 0.53 - 0.58 mm. Spray angle: 40 - 80 degrees. Volume of thinner: 0 - 3%.

Brush Suitable for stripe coats and touch-up work only. Volume of thinner: 0 - 5%.

Thinner / Cleaner Transocean Epoxy Thinner 6.03.

Conditions Humidity: 30 - 100% RH.
Temperature of the paint before application: min: 10°C, max: 30°C.
Substrate temperature: min: 5°C, max: 50°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)
5 °C	12 hours	48 hours	10 days	72 hours	10 days
23 °C	6 hours	12 hours	7 days	24 hours	6 days
30 °C	4 hours	8 hours	4 days	18 hours	3 days

(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.

