

# **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 <sup>2</sup> /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%.

<u>Thinner / Cleaner</u> Transocean Epoxy Thinner 6.03.

<u>Conditions</u> 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	Touch dry	Dry to handle	Full cure	Dry	Dry to recoat	
temperature				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	

<sup>(1)</sup> 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. Roughness profile 70-90 micron. Apply Transpoxy HB immediately after the steel has been blasted and the

quality of preparation has been approved.

Transpoxy HB may also applied on suitable primers such as Transozinc Epoxy Primer ST 1.50. Ensure that primer surfaces are dry and free form salts and

other contaminants.

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 form loose paint,

salt, grease and other contaminants prior to overcoating.

#### Recommended paint system.

A typical system for ballast tanks is shown below.

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1 x 250 µm dft.

Sharp edges, corners and weld seams must be stripe coated in order to achieve the specified dry film thickness.

# 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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