



Product Data Sheet

Transpoxy Masterbond BT 4.68

Product description.

A high solids epoxy primer/coating formulated with Masterbond binder technology. Transpoxy Masterbond has excellent anticorrosive properties and offer good adhesion to St3 prepared steel substrates and shop primers. Transpoxy Masterbond BT has an increased tolerance to damp substrates and can be used at temperatures down to 0°C. The product is exceptionally suitable for use in ballast tanks and is approved by GL according to IMO Resolution MSC.215(82).

Physical properties.

Colour	Grey, Redbrown
Texture	Semi-gloss
Volume Solids	Approx. 82%
Specific gravity	Approx. 1.50 gr/ml
VOC	Approx. 179 gr/liter
Flashpoint	>25°C

	Dry film thickness per coat (µm)	Wet film thickness per coat (µm)	Theoretical spreading rate (m ² /l)
Range	100 - 300	120 - 365	8.2 - 2.7
Recommended	150	185	5.5

Application data.

Mixing ratio	By weight, base to hardener: 82.0 / 18.0 By volume, base to hardener: 75.0 / 25.0
Potlife	10°C: 4 hours, 23°C: 2 hours, 30°C: 1 hour
Guiding data	Pressure at nozzle: 180 - 250 bar. Nozzle size: 0.41 - 0.58 mm.
Airless spray	Spray angle: 40 - 80 degrees. Volume of thinner: 0 - 5%.
Guiding data	Not applicable
Airspray	
Brush	Suitable for touch-up only. Volume of thinner: 0 - 5%.
Roller	Not recommended
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	Dry to recoat (2) Maximum
5°C	6 Hours	24 Hours	10 Days	24 Hours	Indefinite
10°C	4 Hours	12 Hours	8 Days	16 Hours	Indefinite
23°C	2 Hours	8 Hours	5 Days	12 Hours	Indefinite
30°C	1 Hour	4 Hours	3 Days	8 Hours	Indefinite

(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. After prolonged exposure times it may be necessary to roughen the surface to ensure intercoat adhesion. When in doubt, consult your nearest Transocean office.

Surface preparation for 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 this product immediately after the steel has been blasted and the quality of preparation has been approved.

Surface preparation 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.

Typical paint system

A typical high performance system for this product is shown below.

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Recommended: 150µm DFT

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Application conditions

The temperature of the substrate should be 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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