Transpoxy Intermediate

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	White Other colours upon request
Texture	Flat
Volume Solids	Approx. 50%
Specific gravity	Approx. 1.35 gr/ml
VOC	Approx. 447 gr/liter
Flashpoint	>16°C

	Dry film thickness per coat (µm)	Wet film thickness per coat (µm)	Theoretical spreading rate (m^2/l)
Range	75 - 150	150 - 300	6.7 - 3.3
Recommended	100	200	5

Application data.

Mixing ratio	By volume, base to hardener: 80.0 / 20.0
Potlife	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 Airspray	Pressure at nozzle: 3 - 5 bar. Nozzle size: 1.5 - 2.0 mm. Volume of thinner: 0 - 10%.
Brush	Suitable. Multicoats may be needed to achieve the specified dry film thickness. Volume of thinner: 0 - 5%.
Roller	Suitable. Multicoats 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 (1)

Substrate temperature	Touch dry	Dry to handle	Full cure	Dry to recoat Minimum	Dry to recoat Max.(2)
10°C	12 Hours	36 Hours	14 Days	16 Hours	12 Days
23°C	6 Hours	24 Hours	7 Days	8 Hours	6 Days
30°C	4 Hours	12 Hours	5 Days	6 Hours	4 Days

(1)The given data are for guidance only as actual drying times may be shorter or longer, depending on film thickness, ventilation, humidity, preceding paint system etc.

(2)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 in doubt, consult your nearest Transocean office.

Surface Preparation

Coated substrates

All surfaces should be clean, dry and free from contamination. Surfaces should be treated in accordance with ISO 8504:2000.
Ensure compatibility of the coated substrates with the selected paint system. If the remaining part of the existing coating system needs to be sweep-blasted, fine abrasive shall be used to avoid damage to the coating system.
When recoating aged coated substrates, damaged areas must be removed back to a firm edge. Light abrade or sweep-blast the surface in order to provide a physical key for adhesion.
When recoating zinc primed products, ensure the primer has been fully cured. Zinc salts products shall be removed by high pressure fresh water cleaning.
Contact your local Transocean office for more information.

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.

Typical paint system

A typical system for this product is shown below and should be taken for guidance only. A full system specification where all details are taken into consideration can be obtained through your local Transocean representative.

Transozinc Epoxy Primer ST	Recommended:	50µm DFT
Transpoxy Intermediate	Recommended:	100µm DFT
Transurethane Finish	Recommended:	40µm DFT

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

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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 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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