



Product Data Sheet

Transpoxy Masterbond 4.69

Product description.

Transpoxy Masterbond has excellent anticorrosive properties and good impact- and abrasion resistance. Good adhesion to St3 prepared steel substrates and compatible with most aged coatings. Complies with bridge coatings specifications of the UK-Highway Agency.

Physical properties.

Colour/Texture	Redbrown and Grey/Semi-gloss
Volume Solids	84%
Specific gravity	1.41 gr/ml
VOC	147 gr/liter
Flashpoint	>25°C

	Dry film thickness per coat (μ)	Wet film thickness per coat (μ)	Theoretical spreading rate (m ² /l)
Range	100 – 400	120 – 475	8.4 – 2.1
Recommended	150	180	5.6

Application data.

<u>Mixing ratio</u>	By weight, base to hardener: 86 to 14. By volume, base to hardener: 4 to 1.
<u>Potlife</u>	10°C: 3 hours, 23°C: 2 hours, 30°C: 1 hour.
<u>Guiding data Airless spray</u>	Pressure at nozzle: 180 – 250 bar. Nozzle size: 0.41 - 0.58 mm. Spray angle: 40 - 80 degrees. Volume of thinner: 0 - 5%.
<u>Brush</u>	Suitable but airless spray is recommended. Multicoats are required to achieve the specified dry film thickness. Volume of thinner: 0 - 10%.
<u>Thinner/Cleaner</u>	Transocean Epoxy Thinner 6.03.
<u>Conditions</u>	Humidity: below 85% RH. Temperature of the paint before application: min: 10°C, max: 30°C. Substrate temperature: min: 10°C, max: 35°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	Hard Dry	Full cure	Dry to recoat (1)		
				Minimum	Maximum with 1-pack.	Maximum with 2-pack
10 °C	6 hours	24 hours	8 days	18 hours	15 days	Indefinite
23 °C	3 hours	20 hours	5 days	15 hours	10 days	Indefinite
30 °C	1 hour	16 hours	3 days	12 hours	10 days	Indefinite

(1) 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 it may be necessary to roughen the surface to ensure intercoat adhesion. When in doubt, consult your nearest Transocean office.

