



Product Data Sheet

Transpoxy Deep Tanks 4.62

Product description.

A polyamine cured epoxy coating with excellent resistance against organic and inorganic acids, alkalis and various solvents. The product complies with FDA §175.300 for the carriage of dry foodstuffs.

Physical properties.

Colour/Texture	White and Grey/Semi-gloss
Volume Solids	51%
Specific gravity	1.29 gr/ml
VOC	418 gr/liter
Flashpoint	>24°C

	Dry film thickness per coat (μ)	Wet film thickness per coat (μ)	Theoretical spreading rate (m ² /l)
Range	75 – 150	150 – 295	6.8 – 3.4
Recommended	125	245	4.1

Application data.

<u>Mixing ratio</u>	By weight, base to hardener: 83,3 to 16,7. By volume, base to hardener: 77 to 23.
<u>Potlife</u>	10°C: 16 hours, 23°C: 12 hours, 30°C: 6 hours.
<u>Guiding data Airless spray</u>	Pressure at nozzle: 180 – 250 bar. Nozzle size: 0.53 - 0.66 mm. Spray angle: 40 - 80 degrees. Volume of thinner: 0 - 5%.
<u>Brush</u>	Suitable for stripe coats and touch-up work only. 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	Dry to handle	Full cure	Dry to recoat	
				Minimum	Maximum (1)
10 °C	6 hours	24 hours	10 days	18 hours	7 days
23 °C	4 hours	16 hours	7 days	12 hours	5 days
30 °C	2 hours	12 hours	4 days	8 hours	2 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.

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: 50 – 75 micron. Remove all loose dirt and abrasive by vacuuming or sweeping. Apply Transpoxy Deep Tanks immediately after the steel has been blasted and the quality of preparation has been approved.

Additional usage instructions.

1. Preferably mix part A and part B with a mechanical stirrer. Do not mix more material than can be used in 4 hours at 20°C.
2. Corners, edges and weld seams should be stripe-coated prior to a full coat application.
3. Allow ventilation during and after application of the coating system. Temperature of the ventilation air should lie between 20°C and 35°C. Continue ventilation until the system has fully cured.
4. Do not apply the coating when ambient temperature will be less than 10°C for more than 48 hours after application of the coating.
If at any time, a greasy appearing film is observed on the surface of the coating, the surface should be thoroughly wiped with clean rags saturated in Transocean Epoxy Thinner 6.03. Allow evaporation of the solvent before recoating.

Recommended paint system.

A typical system is shown below.

Transpoxy Deep Tanks 4.62 2-3 x 125 µ 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.

Date of issue: February, 05.