



# Product Data Sheet

## Transpoxy Masterbond 4.68

### Product description.

A high solids modified epoxy primer/coating formulated with Masterbond binder technology. Transpoxy Masterbond offers excellent resistance against fresh water and seawater. The coating has very good flexibility and wetting properties enabling adhesion to ISO-St3 prepared steel substrates.

### Physical properties.

Colour/Texture	Whitegrey/Semi-gloss
Volume Solids	80%
Specific gravity	1.91 gr/ml
VOC	181 gr/liter
Flashpoint	>8°C

	Dry film thickness per coat (μ)	Wet film thickness per coat (μ)	Theoretical spreading rate (m <sup>2</sup> /l)
Range	100 – 250	125 – 310	8.0 – 3.2
Recommended	150	190	5.3

### Application data.

Mixing ratio By volume, base to hardener: 80 to 20.

Potlife 10°C: 4 hours, 23°C: 2 hours, 30°C: 1 hour.

Guiding data Airless spray Pressure at nozzle: 180 – 250 bar. Nozzle size: 0.41 - 0.58 mm.  
Spray angle: 40 - 80 degrees.  
Volume of thinner: 0 – 5%.

Brush Suitable but airless spray is recommended. Multicoats are required to achieve the specified dry film thickness.  
Volume of thinner: 0 – 10%.

Thinner/Cleaner Transocean Epoxy Thinner 6.03.

Conditions Humidity: below 85% RH.  
Temperature of the paint before application: min: 10°C, max: 30°C.  
Substrate temperature: min: 8°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	12 hours	24 hours	10 days	18 hours	Indefinite
23 °C	6 hours	16 hours	7 days	12 hours	Indefinite
30 °C	4 hours	12 hours	4 days	8 hours	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. When recoating with single pack products, maximum recoat interval is limited to 24 hours. After prolonged exposure 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 – ISO 8501:1. Power tool cleaning: min. ISO-St3. Please note that better surface preparation always results in longer lifetime expectations. Apply Transpoxy Masterbond immediately after the steel has been blasted and the quality of preparation has been approved.
Repair	Existing systems should be roughened and dry and free from loose paint, salt, grease and other contaminants prior to overcoating. Corroded and/or damaged areas should be power tool cleaned to ISO-St2 or better or blast cleaned to ISO-Sa2.

## Recommended paint system.

A typical system is shown below.

Transpoxy Masterbond 4.68                      2 x 150  $\mu$  dft.

Subsequent coatings can be Transpoxy-, Transurethane-, Transuniprene- or Transunilac Finishes for atmospheric exposure and appropriate Transocean Antifouling systems for immersion services.

## 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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