



Product Data Sheet

Transpoxy Masterbond 4.77

Product description.

High solids epoxy coating formulated with Masterbond binder technology. Transpoxy Masterbond offers excellent anticorrosive properties and has good adhesion to St3 prepared steel substrates. The product is flexible and compatible with most aged coating systems. The product cures down to temperatures of -10°C. Approved for grain carriage by Newcastle Occupational Health Agency.

Physical properties.

Colour/Texture	Redbrown and Grey/Semi-gloss
Volume Solids	81%
Specific gravity	1.35 gr/ml
VOC	166 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 – 250	125 – 310	8.1 – 3.2
Recommended	150	185	5.4

Application data.

<u>Mixing ratio</u>	By weight, base to hardener: 5 to 1. By volume, base to hardener: 7 to 2.
<u>Potlife</u>	-5°C: 8 hours, 10°C: 4 hours, 23°C: 2 hours.
<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/Roller</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: 30°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 (1)		
				Minimum	Maximum with 1-pack.	Maximum with 2-pack
-5 °C	24 hours	48 hours	30 days	48 hours	15 days	Indefinite
5 °C	8 hours	20 hours	21 days	20 hours	10 days	Indefinite
10 °C	6 hours	18 hours	14 days	18 hours	10 days	Indefinite
23 °C	3 hours	12 hours	7 days	12 hours	10 days	Indefinite

(1) The surface should be dry and free from ice, grease and other 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 or when maximum recoating time has exceeded it may be necessary to roughen the surface to ensure intercoat adhesion. When in doubt, consult your nearest Transocean office.

