



Product Data Sheet

Transpoxy Shopprimer 1.80

Product description.

A two-pack polyamide cured shopprimer loaded with non-toxic anti-corrosive pigments for the protection of steel structures against corrosion during construction. The primer cured fast and can be used as a holding primer.

Physical properties.

Colour/Texture	Red/Mat
Volume Solids	22%
Specific gravity	1.16 gr/ml
VOC	643 gr/liter
Flashpoint	>-2°C

	Dry film thickness per coat (μ)	Wet film thickness per coat (μ)	Theoretical spreading rate (m ² /l)
Range	15 – 30	70 – 135	14.6 – 7.3
Recommended	20	90	11.0

Application data.

<u>Mixing ratio</u>	By weight, base to hardener: 74 to 26. By volume, base to hardener: 64 to 36.
<u>Potlife</u>	10°C: 12 hours, 23°C: 8 hours, 30°C: 6 hours.
<u>Guiding data Airless spray</u>	Pressure at nozzle: 120 -150 bar. Nozzle size: 0.38 - 0.53 mm. Spray angle: 40 - 80 degrees. Volume of thinner: Not required.
<u>Guiding data Airspray</u>	Pressure. 3 - 5 bar. Nozzle size: 1.5 - 2.0 mm. Volume of thinner: Not required.
<u>Brush/Roller</u>	Suitable.
<u>Thinner/Cleaner</u>	Transocean Epoxy Thinner 6.03.
<u>Conditions</u>	Humidity: below 90% RH. Temperature of the paint before application: min: 10°C, max: 30°C. Substrate temperature: min: 8°C, max: 40°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	5 minutes	2 hours	1 day	2 hours	Indefinite
23 °C	5 minutes	2 hours	1 day	2 hours	Indefinite
30 °C	4 minutes	1½ hours	1 day	2 hours	Indefinite

(1) The surface should be dry and free from contaminants prior to overcoating. 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.

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. Apply Transpoxy Shopprimer 1.80 immediately after the steel has been blasted and the quality of preparation has been approved.

Repair Corroded areas should be power tool cleaned to ISO-St3 or blast cleaned to ISO-Sa2 or better. Existing systems should be dry and free from loose paint, salt, grease and other contaminants prior to overcoating.

Recommended paint system.

Transpoxy Shopprimer 1.80 1 x 20 µ dft.

Subsequent coating with Transpoxy, Transvinyl, Transogard or Transoprene products.

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. 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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