



Product Data Sheet

Transpoxy EC Primer 1.42

Product description.

A two pack polyamide cured high build recoatable epoxy primer with zincphosphate and auxiliary anti-corrosive pigments for the protection of steel structures against corrosion in industrial and marine environments. The primer can be used as a primer or intermediate coat in Transpoxy systems.

Physical properties.

Colour/Texture Redbrown/mat
 Volume Solids 61 %
 Specific gravity 1.41 gr/ml
 VOC 336 gr/liter
 Flashpoint >25°C

	Dry film thickness per coat (µ)	Wet film thickness per coat (µ)	Theoretical spreading rate (m ² /l)
Range	75 – 150	125 –250	8.1 – 4.1
Recommended	100	170	6.1

Application data.

Mixing ratio By weight, base to hardener: 86 to 14.
 By volume, base to hardener: 78 to 22.

Potlife 15°C: 12 hours, 23°C: 8 hours, 30°C: 5 hours.

Induction time None.

Guiding data Airless spray Pressure at nozzle: 120 -150 bar. Nozzle size: 0.38 - 0.53 mm.
 Spray angle: 40 - 80 degrees.
 Volume of thinner: 0 – 3%.

Guiding data Airspray Pressure. 3 - 5 bar. Nozzle size: 1.2 - 2.0 mm.
 Volume of thinner: 0 – 10%.

Brush/Roller Suitable. Volume of thinner: 0 – 5%.

Thinner/Cleaner Transocean Epoxy Thinner 6.03

Conditions Humidity: below 85% RH
 Temperature of the paint before application: min: 5°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	4 hours	12 hours	6 days	3 days	Indefinite
23 °C	2 hours	6 hours	4 days	20 hours	Indefinite
30 °C	1 minutes	4 hours	3 days	10 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. After prolonged exposure times it may be necessary to roughen the surface to ensure intercoat adhesion. When in doubt, consult your nearest Transocean office.

