



Product Data Sheet

Transpoxy UniPrimer 1.71

Product description.

A two pack epoxy primer for an excellent protection of steel structures against corrosion in industrial and marine environments. This versatile primer can be used on steel and other metal substrates and is compatible with (ultra) high-pressure hydroblasting as surface preparation.

Physical properties.

| | |
|------------------|-----------------------|
| Colour / Texture | Light Grey N35 / Matt |
| Volume Solids | 51% |
| Specific gravity | 1.3 gr/ml |
| VOC | 425 gr/litre |
| Flashpoint | >25 °C |

| | Dry film thickness per coat (μ) | Wet film thickness per coat (μ) | Theoretical spreading rate (m ² /l) |
|-------------|---------------------------------|---------------------------------|--|
| Range | 50 – 100 | 100 –200 | 10.0 – 5.0 |
| Recommended | 50 | 100 | 5.0 |

Application data.

| | |
|-------------------------------------|---|
| <u>Mixing ratio</u> | By volume, base to hardener: 5:1 |
| <u>Pot-life</u> | 10°C: 10 hours, 23°C: 8 hours, 30°C: 4 hours. |
| <u>Induction time</u> | None. |
| <u>Guiding data - Airless spray</u> | Pressure at nozzle: 180 -300 bar. Nozzle size: 0.38 - 0.53 mm. Spray angle: 40 - 80 degrees. Volume of thinner: 0 – 3%. |
| <u>Guiding data – Air spray</u> | Pressure. 4 - 6 bar. Nozzle size: 1.2 - 2.0 mm. Volume of thinner: 0 – 10%. |
| <u>Brush / Roller</u> | Suitable but in general recommended for touch-up of small areas. Multiple coats are required to achieve the specified dry film thickness. Volume of thinner: 0 – 5%. |
| <u>Thinner / Cleaner</u> | Transocean Epoxy Thinner 6.03 If thinning is necessary, this should be added after mixing of the two Components. Avoid excessive thinning as it will result in lower sag resistance and slower cure. |

Drying and recoating times.

| Substrate temperature | Touch dry | Dry to handle | Full cure | Dry to recoat | |
|-----------------------|------------|---------------|-----------|---------------|-------------|
| | | | | Minimum | Maximum (2) |
| 10 °C | 60 minutes | 8 hours | 10 days | 16 hours | 3 months |
| 23 °C | 30 minutes | 4 hours | 5 days | 8 hours | 3 months |
| 30 °C | 15 minutes | 2 hours | 3 days | 6 hours | 3 months |

(1) The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, preceding paint system etc

(2) 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.

