



Product Data Sheet

Transozinc Epoxy Primer 1.55

Level 1 Type

Product description.

A two pack polyamide cured epoxy primer pigmented with a high zinc content for the protection of steel structures against corrosion in industrial and marine environments. The primer is quick drying and can be used as a holding primer.

Physical properties.

Colour / Texture	Grey / Matt
Volume Solids	50%
Specific gravity	2.41 gr/ml
VOC	452 gr/litre
Flashpoint	>22°C

	Dry film thickness per coat (μ)	Wet film thickness per coat (μ)	Theoretical spreading rate (m ² /l)
Range	25 – 75	50 – 150	20 – 6.6
Recommended	50	100	10.0

Application data.

Mixing ratio By volume, base to hardener: 88 : 12.

Pot-life 15°C: 16 hours, 23°C: 8 hours, 30°C: 5 hours.

Induction time 20 minutes.

Guiding data - Airless spray Pressure at nozzle: 140 - 180 bar. Nozzle size: 0.38 - 0.53 mm. Spray angle: 40 - 80 degrees. Volume of thinner: 0 – 3%.

Guiding data – Air spray 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
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	40 minutes	8 hours	10 days	16 hours	Indefinite
23 °C	20 minutes	4 hours	5 days	6 hours	Indefinite
30 °C	15 minutes	2 hours	4 days	4 hours	Indefinite

(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. 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.

