



Product Data Sheet

Transothane Finish 3.63

Product description.

A high gloss polyurethane finish for marine and industrial environments. The product provides excellent durability and offers high gloss and excellent colour retention. Can be applied by airless spray as well as by brush and roller.

Physical properties.

Colour / Texture	White, Jet Black, AS2700 Colours / High gloss
Volume Solids	Dependent on colour shade, approx. 50%
Specific gravity	Dependent on colour shade, approx. 1.25 gr/ml
VOC	Dependent on colour shade, approx. 442 gr/litre
Flashpoint	>24°C (mixed product)

	Dry film thickness per coat (μ)	Wet film thickness per coat (μ)	Theoretical spreading rate (m ² /l)
Range	30 – 50	60 – 100	16.7 – 10.0
Recommended	50	100	10.0

Application data.

<u>Mixing ratio</u>	By volume, base to hardener: 6:1
<u>Pot-life</u>	10°C: 10 hours, 23°C: 6 hours, 30°C: 4 hours.
<u>Guiding data - Airless spray</u>	Pressure at nozzle: 120 - 180 bar. Nozzle size: 0.38 - 0.58 mm. Spray angle: 40 - 80 degrees. Volume of thinner: 0 - 3%.
<u>Guiding data - Air spray</u>	Pressure: 3 - 5 bar. Nozzle size: 1.2 - 1.5 mm. Volume of thinner: 0 - 5%.
<u>Brush / Roller</u>	Suitable. Volume of thinner: 0 - 5%.
<u>Thinner / Cleaner</u>	Transocean PU Thinner 6.04. 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	2 hours	8 hours	10 days	24 hours	Indefinite
23 °C	1 hour	4 hours	7 days	12 hours	Indefinite
30 °C	30 minutes	2 hours	5 days	8 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 it may be necessary to roughen the surface to ensure intercoat adhesion. When in doubt, consult your nearest Transocean office.

Surface preparation.

Coated substrates Existing systems should be dry and free from loose paint, salt, grease and other contaminants prior to overcoating.
Oil and grease should be removed by solvent cleaning according to SSPC-SP1.
Remove salts and dirt by fresh water washing.
Corroded areas should be repaired first with an appropriate primer system.

Application conditions.

The temperature of the substrate should be at least 5°C and at least 3°C above the dew point of the air. Temperature and relative humidity should be measured in the vicinity of the substrate.
The maximum recommended surface temperature is approx. 40°C. Higher steel temperatures are acceptable provided dry-spray is avoided by proper spray application and extra thinning if required. In extreme cases it may be necessary to reduce film thickness in order to avoid sagging.
When applying the paint in confined spaces, provide adequate ventilation during application and drying.
The temperature of the mixed paint should be at least 15°C, otherwise extra solvent may be required to obtain a proper application viscosity.

Storage and shelf life.

The product must be stored in accordance with national regulations. The cans are to be kept in a dry, cool, well ventilated space and away from source of heat and ignition. Cans must be kept tightly closed.

Recommended paint system.

Transothane Finish can be applied on suitable Transpoxy priming systems. A typical system for atmospheric exposure is shown below.

Transozinc Epoxy Primer ST 1.50	1 x 50 µ dft.
Transpoxy Masterbond 4.67N	1 x 125 µ dft.
Transothane Finish 3.63	1-2 x 50 µ dft.

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 be 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. Spraying should be carried out under well-ventilated conditions. 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.

Date of issue: July, 12.