

# **Product Data Sheet**

## **Transpoxy Guard 4.64**

#### Product description.

A high build polyamine cured epoxy coating for steel and concrete. Transpoxy Guard has good resistance against abrasion and excellent resistance against corrosion. Suitable for immersion in seawater, fresh water and potable water.

#### Physical properties.

Colour / Texture

White / Gloss

Volume Solids

98%

Specific gravity VOC

1.6 g/ml

Flashpoint

22 g/litre >80°C

	Dry film thickness per	Wet film thickness per	Theoretical spreading	
	coat (µm)	coat (µm)	rate (m²/l)	
Range	150 – 500	155 – 510	6.5 – 1.9	

#### Application data.

Mixing ratio

By Weight, base to hardener:

67 to 33.

Pot-life

Roller

10°C: 2 hours,

23°C: 1 hour.

30°C: 30 minutes

Guiding data - Airless spray Heavy duty single feed airless equipment is advised. Compression 60: 1.

Pressure at nozzle: 180 – 250 bar. Nozzle size: 0.53 - 0.58 mm.

Spray angle: 40 - 80 degrees.

Volume of thinner: 0 - 3%. Suitable for stripe coats and touch-up work only.

Volume of thinner: 0 - 10%.

Thinner / Cleaner

Transocean Epoxy Thinner 6.03.

Conditions

Humidity: below 85% RH.

Temperature of the paint before application: min: 10°C, max: 30°C.

Substrate temperature: min: 5°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 (1).

Substrate	Touch dry	Dry to handle	Full cure	Dry to recoat	
temperature				Minimum	Maximum
10 °C	24 hours	48 hours	7 days	36 hours	10 days
23 °C	16 hours	24 hours	5 days	24 hours	4 days
30 °C	8 hours	16 hours	3 days	16 hours	2 days

(1) 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.

#### 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. Roughness profile 70-90 micron. Apply Transpoxy Guard immediately after the steel has been blasted and the

quality of preparation has been approved.

Transpoxy Guard may also applied on suitable primers such as Transozinc Epoxy Primer ST 1.50. Ensure that primer surfaces are dry and free form salts

and other contaminants.

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 form loose paint,

salt, grease and other contaminants prior to overcoating.

Concrete Remove porous and less coherent areas by blast-cleaning or by using power

tools such as chipping hammers. Remove all dust and debris prior to painting.

#### Additional usage instructions.

1. Preferably mix part A and part B with a mechanical stirrer. Do not mix more material than can be used in 1 hour at 20°C.

2. Corners, edges and weld seams should be stripe-coated prior to a full coat application.

3. Allow ventilation during and after application of the coating system. Temperature of the ventilation air should lie around 40°C. Continue ventilation until the system has fully cured.

4. Do not apply the coating when ambient temperature will be less than 10°C for more than 48 hours after application of the coating.

5. After application and full cure of the final coat, the tank should be flushed and cleaned once with a 2-3% lemon acid solution in water. Then the tank should be filled and flushed with clean water.

#### Recommended paint system.

A typical system for immersion is shown below.

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 $2 \times 200 \ \mu m \ dft$ .

Sharp edges, corners and weld seams must be stripe coated in order to achieve the specified dry film thickness.

#### 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 paint mist by wearing an air mask. 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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