

## Transpoxy Sealer

**Product code:**  
TO 1.99

Transpoxy Sealer is a two-pack polyamide cured epoxy coating suitable for atmospheric and immersion conditions. The product is typically used as a tiecoat on inorganic zinc silicates and as an intermediate coat in Transpoxy systems.

It is also suitable to prime constructions prepared from glass fibre reinforced polyester (GRP) such as tanks and yachts.

### Physical properties:

Colour	White
Gloss / Appearance	Semi-gloss
Volume Solids	Approx. 50 %
Specific gravity	Approx. 1.4 g/ml
VOC	Approx. 465 g/liter
Flashpoint	Both base and hardener > 25°C

### Usage data:

**Mixing ratio** By volume, base to hardener: 75:25 [3:1]

<b>Film thickness</b>	Dry film thickness per coat (µm)	Wet film thickness per coat (µm)	Theoretical spreading rate (m <sup>2</sup> /l)
Range	50 - 100	100-200	10 - 5
Recommended	75	150	6.7

### Curing Times

	Substrate temperature		
	10°C	23°C	30°C
Touch dry	4 Hours	2 Hours	1 Hour
Dry to handle	24 Hours	16 Hours	12 Hours
Full cure	10 Days	5 Days	3 Days
Potlife	12 Hours	8 Hours	6 Hours

Drying and curing times are determined under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product and should be considered as guidelines only.

The actual drying time may be shorter or longer, depending on film thickness, temperature, ventilation, humidity, preceding paint system etc.

### Recoating intervals - see application section

see application section		Substrate temperature							
		10°C		23°C		30°C			
Recoated with		Min	Max	Min	Max	Min	Max	Min	Max
Single pack products									
2-pack products		22 Hours	Indefinite	16 Hours	Indefinite	12 Hours	Indefinite		

Recoating information is given for guidance only and is subject to local climate and environmental conditions. Consult your local Transocean representative for specific recommendations.

As a general rule, the best intercoat adhesion is achieved when the subsequent coat is applied before the preceding coat has been fully cured. Extended recoating times should not be considered for other than ambient atmospheric exposure. After prolonged exposure times it may be necessary to roughen the surface to ensure intercoat adhesion.



## Surface Preparation:

### Coated substrates

All surfaces should be clean, dry and free from contamination. Surfaces should be treated in accordance with ISO 8504:2000.

Ensure compatibility of the coated substrates with the selected paint system. If the remaining part of the existing coating system needs to be sweep-blasted, fine abrasive shall be used to avoid damage to the coating system.

When recoating aged coated substrates, damaged areas must be removed back to a firm edge. Light abrade or sweep-blast the surface in order to provide a physical key for adhesion.

When recoating zinc primed products, ensure the primer has been fully cured. Zinc salts products shall be removed by high pressure fresh water cleaning. Contact your local Transocean office for more information.



## Application:

### Mixing:

The product is supplied in 2 containers as a unit. Always mix a complete unit in the proportions supplied. Do not mix more material than can be used within the specified pot life.

Stir the base (Part A) with a clean mechanical mixer. Then add the entire contents of Curing Agent (Part B) and mix thoroughly. Avoid too vigorous mixing as it leads to air inclusion, which may result in poor application results.

If thinner is required, only add after mixing of the two components.

Irrespective of the substrate temperature, the advised minimum temperature of the mixed paint is 15 °C. At lower temperatures, more thinner may be required to obtain a proper application viscosity, which may result in lower sag resistance and slower curing.

### Conditions:

Unless mentioned separately, the relative humidity should be below 90% during application and curing. The temperature of the substrate should be min. 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.

### Methods:

<b>Guiding data Airless spray</b>	Pressure at nozzle	120 - 180 bar
	Nozzle size	0.38 - 0.53 mm (0.015 - 0.021 in.)
	Spray angle	40 - 80 degrees
	Volume of thinner	0 - 3%

<b>Guiding data Airspray</b>	Pressure	3 - 5 bar
	Nozzle size	1.5 - 2.0 mm
	Volume of thinner	0 - 10%

**Brush / Roller** Suitable for stripe coats and touch-up work only. Volume of thinner: 0 - 5%.

**Thinner** Transocean Epoxy Thinner 6.03  
If thinning is necessary, this should be added after mixing of the two components. The recommended level of thinner is dependent on thickness and conditions. In certain circumstances, it may be required to exceed the stated level of thinner. However, as a general rule do avoid excessive thinning as it will result in lower sag resistance and slower cure. In addition it may cause solvent entrapment, possibly risking blistering, pinholing and/or other coating defects.

**Cleaner** Transocean Epoxy Thinner 6.03

### Additional usage instructions

Recoating inorganic zinc silicates.

Ensure the zinc silicate should be fully cured prior to recoating. This can be checked by executing the MEK rub test according to ASTM 4752. After 50 double rubs with a cloth soaked in MEK, the zinc silicate coating should not dissolve.

In case MEK is not available, Transocean Thinner 6.07 or Thinner 6.08 may be used alternatively.

Unweathered zinc silicate films are porous and the porosity may vary according to the weather condition during application and the application technique. When recoating, the air in the pores will escape through the new coat of paint and may cause blisters or pinholes ("popping") in the coat just after application. To avoid this a mist coat/full coat technique is recommended.

First apply a thin coat of thinned Transpoxy Sealer (use 10-30 % Transocean Thinner 6.03) to fill the pores in the zinc silicate film. The amount of thinner required depends on various conditions such as level of porosity in the zinc silicate as well as local conditions.

Apply a few minutes later a coat of Transpoxy Sealer, which has been not thinned or thinned according the specifications in this datasheet, to full specified film thickness.



## **Additional Product information:**

### **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 and kept in original containers until required for use.

Partly used containers should be re-sealed securely and stored according to the recommended manner. (See section 7 of relevant SDS).

### **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. Avoid the inhalation of vapours and particulates by the provisions of good natural ventilation sufficient to keep air-borne concentrations below the Occupational Exposure Standards during the application and drying of paint films.

In operations where natural ventilation is insufficient to achieve this - e.g. painting work in enclosed areas - exposure should be controlled by the use of local exhaust ventilation. When this is not reasonably practicable, suitable respiratory protective equipment must be worn. For spray application or when OES's are likely to be exceeded, use the respiratory equipment as recommended in for instance BS4275:1974. This specification gives advice on selection, use and maintenance of various types of breathing apparatus. Protect other persons in the area.

### **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. Users should first carry out their own trials to ascertain the suitability of the product for their intended purpose.

This Data Sheet supersedes all previous Data Sheets supplied to you relating to this product. It contains important information which must be communicated to the user. The user must satisfy himself of the suitability of the product for the intended application and surface, as surface and application conditions are beyond our control. The user must also satisfy himself of the suitability of the product in circumstances other than those set out in this data sheet. The user should also maintain appropriate control procedures. Should further information be required, please contact our Technical Department.

Transocean Coatings employ a policy of continuous development and the technical data could be revised as a result of experience or new information becoming available.

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Print Date	1-10-2024
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