



Product Data Sheet

Transpoxy HB MIO KPC-945

Product description.

Transpoxy HB MIO is a high solids high build polyamide cured epoxy. Pigmented with micaceous iron oxide to enhanced anticorrosive properties, good impact and abrasion resistance. It is recommended to used as intermediate coating to provides excellent adhesion directly on Transocean epoxy range of epoxy primer and overcoating with Transocean Epoxy or PU Finishes. The coating system is recommended for new and maintenance construction for mild to aggressive industrial environments. Also suitable for touch up jobs.

Physical properties.

Colour	Silver Grey & Dark Grey
Texture	Matt
Volume Solids	78±2%
Specific gravity	1.89 ± 0.02 gr/ml
Flashpoint	>24°C

	Dry film thickness per coat (μ)	Wet film thickness per coat (μ)	Theoretical spreading rate (m ² /l)
Range	100 – 150	128 – 192	7.8 – 5.2
Recommended	125	160	6.2

Application data.

<u>Mixing ratio</u>	By weight, base to hardener: 85 to 15 By volume, base to hardener: 4 to 1
<u>Potlife</u>	10°C: 8 hours, 23°C: 6 hours, 30°C: 4-5 hours.
<u>Guiding data Airless spray</u>	Pressure at nozzle: 140 – 165 kg/cm ² (2000 - 2400 psi). Nozzle size: 0.53 - 0.63 mm (21-25 thou). Volume of thinner: 0 - 5%.
<u>Brush</u>	Suitable but airless spray is recommended. Multicoats are required to achieve the specified dry film thickness. Volume of thinner: 0 - 10%.
<u>Thinner/Cleaner</u>	Transocean Epoxy Thinner 6.03.
<u>Conditions</u>	Humidity: below 85% RH. Temperature of the paint before application: min: 10°C, max: 30°C. Substrate temperature: min: 10°C, max: 35°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.

Substrate temperature	Touch dry	Dry to handle	Full cure	Dry to recoat (1)		
				Minimum	Maximum with 1-pack.	Maximum with 2-pack
10 °C	4 hours	24 hours	10 days	24 hours	10 days	Indefinite
23 °C	2 hours	16 hours	7 days	16 hours	7 days	Indefinite
30 °C	1 hour	6 hours	3 days	8 hours	4 days	Indefinite

- (1) 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.

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 – ISO 8501:1. Power tool cleaning: min. ISO-St3. Please note that better surface preparation always results in longer lifetime expectations. Apply Transpoxy HB MIO KPC945 immediately after the steel has been blasted and the quality of preparation has been approved.

Repair

Existing systems should be roughened and dry and free from loose paint, salt, grease and other contaminants prior to overcoating. Corroded and/or damaged areas should be power tool cleaned to ISO-St2 or better or blast cleaned to ISO-Sa2.

Recommended paint system.

A typical system for atmospheric exposure is shown below.

Transpoxy HB MIO KPC945 1-2 x @ 100-150µ dft

Product Limitationst

In common with all epoxies, Transpoxy HB MIO KPC945 will chalk and discolour on external exposure and weathering. This phenomenon is not detrimental to the paint's anti-corrosive performance. Transpoxy HB MIO KPC940 is recommended to be overcoated with durable high performance polyurethane finish for better weathering resistance. Maximum film build in a single coat is best achieved by airless spray. For brush and roller applications, multiple coats will be required to achieve the required DFT.

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. Shelf life is min.2 years in unopened condition.

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 solvent vapours and paint mist by wearing an air mask.

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.

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