Product Data Sheet

Transozinc Epoxy Primer ST 1.50

Product description.

A two pack epoxy primer pigmented with zinc dust for an excellent protection of steel structures against corrosion in industrial and marine environments. The primer is especially recommended when (ultra) high-pressure hydroblasting is utilized as surface preparation. The product also tolerates Sa2- and St3 prepared substrates.

Physical properties.

Colour/Texture	Green/Flat
Volume Solids	48%
Specific gravity	2.2 gr/ml
Flashpoint	>7°C

	Dry film thickness per coat (µ)	Wet film thickness per coat (µ)	Theoretical spreading rate (m^2/l)
Range	50 – 80	105 –166	9.6 – 6.0
Recommended	50	105	9.6

Application data.

Mixing ratio	By volume, base to hardener: 88.4 to 11.6.
Potlife	10°C: 6 hours, 23°C: 4 hours, 30°C: 2 hours.
Induction time	None.
Guiding data Airless spray	Pressure at nozzle: 180 -300 bar. Nozzle size: 0.38 - 0.53 mm. Spray angle: 40 - 80 degrees. Volume of thinner: 0 – 3%.
Guiding data Airspray	Pressure. 4 - 6 bar. Nozzle size: 1.2 - 2.0 mm. Volume of thinner: 0 – 10%.
Brush/Roller	Suitable but in general recommended for touch-up of small areas. Multicoats are required to achieve the specified dry film thickness. Volume of thinner: 0 – 5%.
Thinner/Cleaner	Transocean Epoxy Thinner 6.03
Conditions	Humidity: below 90% RH Temperature of the paint before application: min: 5°C, max: 30°C. Substrate temperature: min: 1°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	
				Minimum	Maximum (1)
5 °C	60 minutes	18 hours	14 days	24 hours	3 months
10 °C	40 minutes	12 hours	7 days	18 hours	3 months
23 °C	15 minutes	4 hours	5 days	8 hours	3 months

(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. Hydroblasting: DW-3 according to STG-2222. Waterpressure > 1000 bar (or 15000 psi) Apply Transozinc Epoxy Primer ST 1.50 immediately after the steel has been blasted and the quality of preparation has been approved.
Repair	Corroded areas should be power tool cleaned to ISO-St3, blast cleaned to ISO-Sa2 or better or Hydroblasted to DW 2-3. Existing systems should be dry and free from loose paint, salt, grease and other contaminants prior to overcoating.

Recommended paint system.

Transozinc Epoxy Primer ST 1.50 1 x 50-80 µ dft.

Subsequent anti-corrosive coating with Transpoxy, Transvinyl or Transoprene products.

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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