



# Product Data Sheet

## Transpoxy H.B Intermediate 2.19

### Product description.

A polyamide cured epoxy coating suitable for atmospheric and immersion conditions. The product is designed as an intermediate coat between organic- and inorganic zinc-rich primers and the final topcoat. It can also be used on other epoxy primers.

### Physical properties.

Colour/Texture                      White/Matt  
 Volume Solids                        59%  
 Specific gravity                        1.60gr/ml  
 Flashpoint                              >16°C

	Dry film thickness per coat (μ)	Wet film thickness per coat (μ)	Theoretical spreading rate (m <sup>2</sup> /l)
Range	75 – 150	125– 255	7.9 – 3.9
Recommended	100	170	5.9

### Application data.

Mixing ratio                              By volume, base to hardener:    80 to 20.

Potlife                                        10°C: 12 hours,    23°C: 8 hours,    30°C: 6 hours.

Guiding data Airless spray            Pressure at nozzle: 120 -180 bar. Nozzle size: 0.48 - 0.66 mm.  
 Spray angle: 40 - 80 degrees.  
 Volume of thinner: 0 - 3%.

Guiding data Airspray                    Pressure. 3 - 5 bar. Nozzle size: 1.5 - 2.0 mm.  
 Volume of thinner: 0 -10%.

Brush/Roller                                Suitable. Multicoats may be needed 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: 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	
				Minimum	Maximum (1)
10 °C	12 hours	36 hours	14 days	16 hours	5 days
23 °C	6 hours	24 hours	7 days	8 hours	3 days
30 °C	4 hours	12 hours	5 days	6 hours	2 days

(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 times it may be necessary to roughen the surface to ensure intercoat adhesion. When recoating with single pack products, maximum recoat interval is limited to 16-24 hours. When in doubt, consult your nearest Transocean office.

## Surface preparation.

Coated substrates	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. Remove salts and dirt by fresh water washing. Corroded and/or damaged areas should be repaired first with an appropriate primer system.
Inorganic Zinc Silicates	Remove zinc-salts and ensure that the zinc silicate has been fully cured. Apply a mist coat of Transpoxy H.B Intermediate 2.19 first.

## Recommended paint system.

A typical system for atmospheric exposure is shown below.

Transozinc Epoxy Primer ST 1.50	1 x 50 $\mu$ dft.
Transpoxy H.B Intermediate 2.19	1 x 100 $\mu$ dft.
Transurethane Finish 3.43	1 x 40 $\mu$ dft.

## 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.*

Date of issue: May 03.