



TRANSOCEAN

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/glossy
 Volume Solids 98%
 Specific gravity 1.6 gr/ml
 Flashpoint >80°C

	Dry film thickness per coat (μ)	Wet film thickness per coat (μ)	Theoretical spreading rate (m ² /l)
Range	150 – 500	155 – 510	6.5 – 1.9

Application data.

Mixing ratio By Weight, base to hardener: 67 to 33.

Potlife 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%.

Roller 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 temperature	Touch dry	Dry to handle	Full cure	Dry to recoat	
				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 from 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 from loose paint, salt, grease and other contaminants prior to overcoating.
Concrete	Remove porous and less coherent areas by blastcleaning or by using power tools such as chipping hammers. Remove all dust and debris prior to painting.

Recommended paint system.

A typical system for immersion is shown below.

Transpoxy Guard 4.64 2 x 200 µ dft.

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

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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