



Product Data Sheet

Transpoxy H.B.Zinc

Phosphate 10.06

Product description.

A two-pack high build epoxy primer pigmented with zinc phosphate. The product offers good resistance against corrosion in severe industrial and marine environment. With its excellent rust inhibiting properties, it forms a good paint system when overcoated with epoxies, polyurethanes, chlorinated rubber etc.

Physical properties.

Colour/Texture Grey/Matt
 Volume Solids 53 ± 2%
 Specific gravity 1.4 gr/ml
 Flashpoint >25°C

	Dry film thickness per coat (µ)	Wet film thickness per coat (µ)	Theoretical spreading rate (m ² /l)
Range	75 – 100	142 – 190	7.0 – 5.3
Recommended	75	142	7.0

Application data.

Mixing ratio

By volume, base to hardener: 80 to 20.

Potlife

5°C: 12 hours, 23°C: 8 hours, 30°C: 6 hours.

Guiding data Airless spray

Pressure at nozzle: 140 -180 bar. Nozzle size: 0.38 - 0.53 mm.
 Spray angle: 40 - 80 degrees.
 Volume of thinner: 0 - 5%.

Guiding data Airspray

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

Brush/Roller

Suitable. 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 85% RH.
 Temperature of the paint before application: min: 5°C, max: 30°C.
 Substrate temperature: min: 5°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	24 hours	14 days	24 hours	7 days
23 °C	6 hours	12 hours	7 days	12 hours	5 days
30 °C	4 hours	10 hours	4 days	8 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. Apply Transpoxy HB Zinc Phosphate 10.06 immediately after the steel has been blasted and the quality of preparation has been approved. Transpoxy HB Zinc Phosphate 10.06 may also be applied on suitable primer such as Transozinc or Transpoxy primers. Ensure that primed 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.

Recommended paint system.

A typical high performance system for atmospheric conditions is shown below.

Transpoxy H.B.Zinc Phosphate 10.06	1 x 75 μ dft.
Transpoxy MIO HB 10.21	1 x 100 μ dft.
Transothane Finish 9.46	1 x 40 μ 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.

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