Product Data Sheet

Transpoxy Masterbond BT 4.68

Product description.

A high solids epoxy primer/coating formulated with Masterbond binder technology. Transpoxy Masterbond has excellent anticorrosive properties and offer good adhesion to St3 prepared steel substrates and shop primers. Transpoxy Masterbond BT has an increased tolerance to damp substrates and can be used at temperatures down to 0°C. The product is exceptionally suitable for use in ballast tanks and is approved by GL according to IMO Resolution MSC.215(82).

Physical properties.

Colour/Texture	Redbrown and Grey/Semi-gloss
Volume Solids	80%
Specific gravity	1.4 gr/ml
VOC	179 gr/liter
Flashpoint	>25°C

	Dry film thickness per coat (µ)	Wet film thickness per coat (µ)	Theoretical spreading rate (m^2/l)
Range	100 – 300	125 – 375	8.0 – 2.6
Recommended	150	190	5.3

Application data.

Mixing ratio	By weight, base to hardener: 82.2 to 17.8 By volume, base to hardener: 3 to 1
Potlife	10°C: 4 hours, 23°C: 2 hours, 30°C: 1 hour.
Guiding data Airless spray	Pressure at nozzle: 180 – 250 bar. Nozzle size: 0.41 - 0.58 mm. Spray angle: 40 - 80 degrees. Volume of thinner: 0 - 5%.
Brush	Suitable for touch-up only. Volume of thinner: 0 - 5%.
Thinner/Cleaner	Transocean Epoxy Thinner 6.03. If thinning is necessary, this should be added after mixing of the two Components. Avoid excessive thinning as it will result in lower sag resistance and slower cure.

Drying and recoating times (1).

Substrate temperature	Touch dry	Dry to handle	Full cure	Dry to recoat (2)	
				Minimum	Maximum
5 °C	6 hours	24 hours	10 days	24 hours	Indefinite
10 °C	4 hours	12 hours	8 days	16 hours	Indefinite
23 °C	2 hours	8 hours	5 days	12 hours	Indefinite
30 °C	1 hour	4 hours	3 days	8 hours	Indefinite

(1) The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, preceding paint system etc

(2) 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.

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 – ISO 8501:1. Power tool cleaning: min. ISO-St3. Please note that better surface preparation always results in longer lifetime expectations. Apply Transpoxy Masterbond 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.
Aluminum	Solvent cleaning according to SSPC-SP1 followed by light blast cleaning with a fine grade non-metallic abrasive or by chemical etching.
Galvanized/Zinc Primed Steel Repair	Removed zinc salts by power or hand tool cleaning, solvent cleaning to SSPC-SP-1. Light blast cleaning with a fine grade abrasive is recommended.

Recommended paint system.

Steel, Aluminum & Galvanized Substrates suitable for exposure under C5M environment.

Transpoxy Masterbond BT 4.68	1 x 100~150 µ dft.
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Transurethane Finish 3.43	1 x 40~50 µ dft.

Ballast Tank

Transpoxy Masterbond BT 4.68	1 x 125~150 µ dft.
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Steel Substrates - Underwater:

Transpoxy Masterbond BT 4.68	1~2 x 100~150 µ dft.
Transvinypox 2.06	1 x 100~125 µ dft.
Transocean Self-Polishing Antifouling	2 x 100~150 µ 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.

Worldwide availability

The product is part of the common Transocean product range but local availability is subject to confirmation. Although we strive to supply the same product through the world, slight modifications of the product in some cases may be necessary in order to comply with local conditions and/or national regulations. In such cases an alternative datasheet will be issued.

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. Spraying should be carried out under well-ventilated conditions. 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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