

Modified Epoxy

PRODUCT DESCRIPTION A two component, low VOC, high solids self smoothing coating.

INTENDED USES Designed for a wide range of floors with various levels of mechanical and chemical exposure. Recommended for car parks, parking bays, pedestrian walk ways, industrial floors, drive ways, ramps and traffic deck systems.

PRACTICAL INFORMATION FOR INTERBUILD 1094

Colour	Limited colour range available			
Gloss Level	Gloss			
Volume Solids	85% ± 3% (depends on colour)			
Typical Thickness	250-500 microns (10-20 mils) dry equivalent to 294-588 microns (11.8-23.5 mils) wet			
Theoretical Coverage	1.70 m ² /litre at 500 microns d.f.t and stated volume solids 68 sq.ft/US gallon at 20 mils d.f.t and stated volume solids			
Practical Coverage	Allow appropriate loss factors			
Method of Application	Airless Spray, Air Spray, Brush, Roller			
Drying Time	Overcoating Interval with recommended topcoats			
Temperature	Touch Dry	Hard Dry	<i>Minimum</i>	<i>Maximum</i>
5°C (41°F)	21 hours	40 hours	40 hours	14 days
10°C (50°F)	14 hours	16 hours	16 hours	10 days
25°C (77°F)	3.5 hours	5.5 hours	5.5 hours	7 days
40°C (104°F)	90 minutes	3 hours	3 hours	5 days

REGULATORY DATA	Flash Point (Typical)	Part A 37°C (99°F); Part B 37°C (99°F); Mixed 37°C (99°F)		
	Product Weight	1.62 kg/l (13.5 lb/gal)		
	VOC	1.87 lb/gal (225 g/l)	EPA Method 24	
		151 g/kg	EU Solvent Emissions Directive (Council Directive 2010/75/EU)	

See Product Characteristics section for further details

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SURFACE PREPARATION

Concrete, Pre-Cast Blockwork etc

Concrete should be cured for a minimum of 28 days prior to coating. The moisture content of the concrete should be below 6%. All surfaces should be clean, dry and free from curing compounds, release agents, trowelling compounds, surface hardeners, efflorescence, grease, oil, dirt, old coatings and loose or disintegrating concrete. All poured and precast concrete must also be sweep blasted (preferred) or acid etched to remove laitence.

Plaster, Cement Render, Concrete etc.

Surface should be clean, dry and free from contamination. Remove old, loose or flaking paint. Fill and sand minor defects.
Damp patches, oil staining, bitumen bleed, nicotine deposits, efflorescence and rust discolouration must either be treated at source, or better, the cause of such stains/defects removed. Existing mould, algae and other growth must be killed before commencing work. Domestic strength bleach diluted 1:4 with water or a proprietary fungicide solution should be used. Two treatments may be necessary, after which the area must be washed down and scrubbed to remove residues. Ideally, to prevent future infestations the conditions which support growth should be identified and cure sought.

APPLICATION

Mixing	Material is supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. Once the unit has been mixed it must be used within the working pot life specified.			
	(1) Agitate Binder (Part A) with a power agitator.			
	(2) Combine entire contents of Powder (Part B) with Binder (Part A) and mix thoroughly with a power agitator.			
Mix Ratio	4 part(s) : 1 part(s) by volume			
Working Pot Life	10°C (50°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
	2 hours	60 minutes	45 minutes	20 minutes
Airless Spray	Recommended	Tip Range 0.53-0.66 mm (21-26 thou) Total output fluid pressure at spray tip not less than 176 kg/cm ² (2503 p.s.i.)		
Air Spray (Pressure Pot)	Recommended	Gun	DeVilbiss MBC or JGA	
		Air Cap	62	
		Fluid Tip	AC	
Brush	Suitable	Typically 100-150 microns (4.0-6.0 mils) can be achieved		
Roller	Suitable	Typically 75-125 microns (3.0-5.0 mils) can be achieved		
Thinner	International GTA007 Maximum recommended thinning 5%	See page 3 and the Application Guidelines for further information.		
Cleaner	International GTA822 (or GTA415)	Choice of cleaner maybe subject to local legislation. Please consult your local representative for specific advice.		
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA822. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units.			
Clean Up	Clean all equipment immediately after use with International GTA822. It is good working practice to periodically clean equipment during the course of the working day. Frequency of cleaning will depend upon amount used, temperature and elapsed time, including any delays.			
	All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.			

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PRODUCT CHARACTERISTICS

The detailed Interbuild 1094 Application Guidelines should be consulted prior to use.

Level of sheen and surface finish are dependent on application method. Avoid using a mixture of application methods whenever possible.

For brush and roller application, and in some colours, two coats of Interbuild 1094 may be required to give uniform coverage, especially when applying Interbuild 1094 over dark undercoats, and when using certain lead free bright colours such as yellows and oranges. Best practice is to use a colour compatible intermediate or anticorrosive coating under the Interbuild 1094.

When overcoating after weathering or ageing, ensure the coating is fully cleaned to remove all surface contamination such as oil, grease, salt crystals and traffic fumes, before application of a further coat of Interbuild 1094.

Absolute measured adhesion of topcoats to aged Interbuild 1094 is less than that to fresh material, however, it is adequate for the specified end use.

This product must only be thinned using the recommended International thinners.

When applying Interbuild 1094 in confined spaces ensure adequate ventilation.

Surface temperature must always be a minimum of 3°C (5°F) above dew point. Throughout application and curing, ensure adequate ventilation and air flow are present, in order to prevent 'dead spots'; especially when application is in confined spaces. In special cases where overcoating is required and curing has been at low temperature and high relative humidity, ensure no amine bloom is present prior to application of subsequent topcoats.

Condensation occurring during or immediately after application may result in a matt finish and an inferior film.

Premature exposure to ponding water will cause colour change, especially in dark colours and at low temperatures.

Note: VOC values are typical and are provided for guidance purpose only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

Low molecular weight reactive additives, which will form part of the film during normal ambient cure conditions, will also affect VOC values determined using EPA Method 24.

SYSTEMS COMPATIBILITY

Interbuild 1094 will normally be applied to correctly prepared concrete substrates. However, it can be used over suitably primed surfaces. Suitable primers are:

- Interbuild 1002
- Interbuild 1003
- Interbuild 1004
- Interbuild 1072
- Interbuild 1073
- Interbuild 1094

For other suitable primers/topcoats consult International Protective Coatings.

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ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at www.international-pc.com:

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage

Individual copies of these information sections are available upon request.

SAFETY PRECAUTIONS

This product is intended for use only by professional applicators in industrial situations in accordance with the advice given on this sheet, the Safety Data Sheet and the container(s), and should not be used without reference to the Safety Data Sheet (SDS).

All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety & Environmental standards and regulations.

In the event welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

If in doubt regarding the suitability of use of this product, consult AkzoNobel for further advice.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 litre	16 litre	20 litre	4 litre	5 litre

For availability of other pack sizes, contact AkzoNobel.

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
	20 litre	30.4 kg	4.6 kg

STORAGE	Shelf Life
	12 months minimum at 25°C (77°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Important Note

The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local representative that this data sheet is current prior to using the product.

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