

## Epoxy

### PRODUCT DESCRIPTION

A low VOC, high solids, high build, two component epoxy coating. Available with conventional pigmentation, or alternatively can be pigmented with micaceous iron oxide to provide enhanced overcoating properties.

### INTENDED USES

For use as a high build epoxy coating to improve barrier protection for a range of anti-corrosive coating systems in a wide range of environments including offshore structures, petrochemical plants, pulp and paper mills and bridges.

Suitable for use in both maintenance and new construction situations as part of an anti-corrosive coating system.

The micaceous iron oxide variant improves long term overcoating properties, better facilitating application in the fabrication shop, prior to shipping, with final overcoating on site.

### PRACTICAL INFORMATION FOR INTERDUR 8840

<b>Colour</b>	A selected range of colours
<b>Gloss Level</b>	Matt
<b>Volume Solids</b>	80%
<b>Typical Thickness</b>	100-200 microns (4-8 mils) dry equivalent to 125-250 microns (5-10 mils) wet
<b>Theoretical Coverage</b>	6.40 m <sup>2</sup> /litre at 125 microns d.f.t and stated volume solids 257 sq.ft/US gallon at 5 mils d.f.t and stated volume solids
<b>Practical Coverage</b>	Allow appropriate loss factors
<b>Method of Application</b>	Airless Spray, Air Spray, Brush, Roller
<b>Drying Time</b>	

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
-5°C (23°F)	150 minutes	48 hours	48 hours	Extended <sup>1</sup>
5°C (41°F)	90 minutes	16 hours	16 hours	Extended <sup>1</sup>
10°C (50°F)	80 minutes	14 hours	13 hours	Extended <sup>1</sup>
15°C (59°F)	75 minutes	10 hours	10 hours	Extended <sup>1</sup>
25°C (77°F)	60 minutes	5 hours	5 hours	Extended <sup>1</sup>

<sup>1</sup> See International Protective Coatings Definitions and Abbreviations

Maximum overcoating intervals are shorter when using polysiloxane topcoats. Consult International Protective Coatings for further details.

For curing at elevated temperatures an alternative curing agent is available. See Product Characteristics for details.

### REGULATORY DATA

<b>Flash Point (Typical)</b>	Part A 34°C (93°F); Part B 31°C (88°F); Mixed 33°C (91°F)		
<b>Product Weight</b>	2.1 kg/l (17.5 lb/gal)		
<b>VOC</b>	1.72 lb/gal (207 g/l) 92 g/kg	EPA Method 24 EU Solvent Emissions Directive (Council Directive 2010/75/EU)	Chinese National Standard GB23985
	159 g/l		

See Product Characteristics section for further details

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### SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with GB18839-2002.

#### Primed Surfaces

Interdur 8840 should always be applied over a recommended anti-corrosive scheme. The primer should be dry and free from contamination and Interdur 8840 must be applied within the overcoating interval specified (consult the relevant product datasheet). Areas of breakdown, damage etc., should be prepared to the specified standard (e.g. Sa2.5(GB 8923-1 : 1988), Abrasive Blasting, or SSPC-SP11, Power Tool Cleaning) and patch primed prior to the application of Interdur 8840.

#### Metallic Zinc Primed Surfaces

Ensure that the surface of the primer is clean, dry and free from contamination and zinc salts before application of Interdur 8840. Ensure zinc primers are fully cured before overcoating.

### APPLICATION

<b>Mixing</b>	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 Base (Part A) with a power agitator. (2) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.			
<b>Mix Ratio</b>	3 part(s) :1 part(s) by volume			
<b>Working Pot Life</b>	-5°C (23°F) 3 hours	5°C (41°F) 3 hours	15°C (59°F) 2.5 hours	25°C (77°F) 2 hours
<b>Airless Spray</b>	Recommended	Tip Range 0.53-0.63 mm (21-25 thou) Total output fluid pressure at spray tip not less than 190 kg/cm <sup>2</sup> (2702 p.s.i.)		
<b>Air Spray (Pressure Pot)</b>	Recommended	Gun Air Cap Fluid Tip E	DeVilbiss MBC or JGA-502 704 or 777	
<b>Brush</b>	Suitable	Typically 75 microns (3.0 mils) can be achieved		
<b>Roller</b>	Suitable	Typically 75 microns (3.0 mils) can be achieved		
<b>Thinner</b>	International GTA007	Thinning is not normally required. Consult the local representative for advice during application in extreme conditions. Do not thin more than allowed by local environmental legislation.		
<b>Work Stoppages</b>	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.			
<b>Clean Up</b>	Clean all equipment immediately after use with International GTA822. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, 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

Interdur 8840 is primarily designed for use as a high build barrier coat to impart barrier protection to a coating system. It is recommended that it should be overcoated with a durable finish from the Interfine or Interthane range when appearance is important.

Maximum film build in one coat is best attained by airless spray. When applying by methods other than airless spray, the required film build is unlikely to be achieved. Application by air spray may require a multiple cross spray pattern to attain maximum film build. Low or high temperatures may require specific application techniques to achieve maximum film build.

When applying Interdur 8840 by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

Surface temperature must always be a minimum of 3°C above dew point. When applying Interdur 8840 in confined spaces ensure adequate ventilation. Exposure to unacceptably low temperatures and/or high humidities during or immediately after application may result in incomplete cure and surface contamination that could jeopardise subsequent intercoat adhesion.

### Elevated Temperature Curing

An alternative curing agent is available for applications at temperatures greater than 25°C (77°F).

<u>Temperature</u> <u>Maximum</u>	<u>Touch Dry</u>	<u>Hard Dry</u>	<u>Overcoating Interval with recommended topcoats</u>	
			<u>Minimum</u>	
25°C (77°F)	90 minutes	6 hours	6 hours	Extended *
40°C (104°F)	60 minutes	2 hours	2 hours	Extended *

\* See International Protective Coatings Definitions and Abbreviations

Interchanging standard and elevated temperature curing agents during application to a specific structure will give rise to an observable colour change due to the difference in the yellowing/discolouration process common to all epoxies on exposure to UV light.

Interdur 8840 is not designed for continuous water immersion. The micaceous iron oxide variant of this product is frequently used as a 'travel coat' prior to final overcoating on site. To ensure best extended overcoating properties ensure over-application does not occur and that the surface is fully cleaned of any contamination which may be present in the surface texture due to the coarse nature of the micaceous iron oxide pigmentation.

When applying Interdur 8840 at temperatures less than 15°C (59°F) or wet film thicknesses of 150 microns (6 mils) or less, addition of around 5% International GTA007 thinners will improve film appearance, sprayability and aid film thickness control.

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

Interdur 8840 is designed for use over correctly primed steel.

Interdur 8801	Interdur 8807
Interdur 8803	Interdur 8808
Interdur 8804	Interdur 8809
Interdur 8805	Interdur 8810
Interdur 8806	Interdur 8815

Suitable topcoats are:

Interdur 8860
Interdur 8862
Interdur 8863

For alternative primers and finishes, consult International Protective Coatings.

See relevant product data sheet for details.