

Epoxy

PRODUCT DESCRIPTION

A low VOC, two component high build, high solids surface tolerant epoxy maintenance coating.
 Pigmented with aluminium to provide additional anti-corrosive barrier protection.

INTENDED USES

For application to a wide variety of substrates including hand prepared rusty steel, abrasive blast cleaned and hydroblasted steel, and a wide range of intact, aged coatings.
 Interplus 56 can be overcoated with a range of finishes as part of a high performance coating system.

PRACTICAL INFORMATION FOR INTERPLUS 56

Colour	Aluminium
Gloss Level	Eggshell
Volume Solids	71% ± 1%
Typical Thickness	100-150 microns (4-6 mils) dry equivalent to 141-211 microns (5.6-8.4 mils) wet
Theoretical Coverage	5.92 m ² /litre at 120 microns d.f.t and stated volume solids 237 sq.ft/US gallon at 4.8 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

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
10°C (50°F)	6 hours	48 hours	48 hours	9 days
15°C (59°F)	4 hours	32 hours	32 hours	6 days
25°C (77°F)	3 hours	16 hours	16 hours	48 hours
40°C (104°F)	2 hours	12 hours	12 hours	36 hours

REGULATORY DATA

Flash Point (Typical)	Part A 24°C (75°F); Part B 18°C (64°F); Mixed 23°C (73°F)		
Product Weight	1.4 kg/l (11.7 lb/gal)		
VOC	246 g/l	Calculated	

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 Petrobras Standard N-5.

Abrasive Blast Cleaning

Abrasive grit blast clean to Sa2½ (ISO 8501:2007) (Near-White Metal) or Petrobras Standard N-9.

Where necessary, remove weld spatter and where required smooth weld seams and sharp edges.

Hand or Power Tool Preparation

Hand or power tool clean to a minimum of St2 (ISO 8501-1:2007) or SSPC-SP2.

Note, all scale must be removed and areas which cannot be prepared adequately by chipping or needle gun should be spot blasted to a minimum standard of Sa2 (ISO 8501-1:2007) or SSPC-SP6. Typically this would apply to C or D grade rusting in this standard.

Ultra High Pressure Hydroblasting / Abrasive Wet Blasting

May be applied to surfaces prepared to Sa2 (ISO 8501-1:2007) or SSPC-SP6 which have flash rusted to no worse than Grade HB2M (refer to International Hydroblasting Standards). Further information is available from International Protective Coatings.

Aged Coatings

Interplus 56 is suitable for overcoating a limited range of intact, tightly adherent aged coatings. Loose or flaking coatings should be removed back to a firm edge. Glossy finishes may require light abrasion to provide a physical 'key'. See Product Characteristics section for further information.

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 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.			
	Manual agitation may be used for up to 18 litres of material.			
Mix Ratio	3.5 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)
	6 hours	5 hours	4 hours	3 hours
Airless Spray	Recommended	Tip Range 0.46-0.58 mm (18-23 thou) Total output fluid pressure at spray tip not less than 176 kg/cm ² (2503 p.s.i.)		
Air Spray (Conventional)	Recommended	Use suitable proprietary equipment		
Brush	Suitable	Multiple coats may be required to achieve specified film thickness.		
Roller	Suitable	Multiple coats may be required to achieve specified film thickness.		
Thinner	Not recommended	Use International Solvent GTA220 only in exceptional circumstances up to 5%. DO NOT dilute more than allowed by local legislation.		
Cleaner	International GTA822			
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

In order to achieve optimum performance on hand prepared steel, Interplus 56 should be applied as a primer coat by brush to ensure thorough wetting out of the substrate.

Interplus 56 is suitable for overcoating intact, aged alkyd, epoxy and polyurethane systems. However, this product is not recommended where thermoplastic coatings such as chlorinated rubbers and vinyls have previously been used. Please consult International Protective Coatings for alternative recommendations.

In some circumstances Interplus 56 can be applied over damp surfaces but cannot be applied by spray application over pools or continuous films of water. Stripe coating using a brush is recommended on seams and welded areas.

In common with all epoxies Interplus 56 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

Interplus 56 is suitable for protection of steel operating at continuous dry temperatures of up to 150° C (302°F), with intermittent surges up to 200°C (392°F).

Interplus 56 is not designed for continuous water immersion.

This product has the following specification approvals:

- Petrobras Standard N-2288

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.

SYSTEMS COMPATIBILITY

The following topcoats and intermediates can be applied to Interplus 56:

Interlac 665
Interlac 84
Interseal 653
Interthane 582

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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 Material Safety Data Sheet and the container(s), and should not be used without reference to the Material Safety Data Sheet (MSDS) which International Protective Coatings has provided to its customers.

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 International Protective Coatings for further advice.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 litre	15.5 litre	20 litre	4.5 litre	5 litre
	3.6 litre	2.8 litre	3.6 litre	0.8 litre	1.5 litre
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	20 litre	24.7 kg		4.8 kg	
	3.6 litre	4.6 kg		0.9 kg	
STORAGE	Shelf Life	24 months (Part A) & 12 months (Part B) 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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