Interbond® 998PB

Epoxy

PRODUCT DESCRIPTION

A solvent free, two component, high build, surface tolerant epoxy coating capable of being applied as a single or multi-coat system over abrasive blasted, hydroblasted or mechanically prepared steel surfaces.

It also has a degree of tolerance to application over damp surfaces.

INTENDED USES

This product is specifically designed for use on Petrobras projects only.

As a high performance anti-corrosive coating for use in a wide range of offshore and onshore applications such as ballast tanks, cofferdams, void spaces, wet spaces, bilges, crude oil tanks, topsides, superstructure, structural steel and underwater areas.

Suitable for new building, maintenance and refurbishment projects.

PRACTICAL INFORMATION FOR INTERBOND 998PB

Colour	Off White, Haze Grey, Aluminium Red; other colours available upon request, consult International Paint.
Gloss Level	Gloss
Volume Solids	100% (Theoretical – See Product Characteristics Section)
Typical Thickness	100-150 microns (4-6 mils) dry equivalent to 111-167 microns (4.4-6.7 mils) wet See Product Characteristics
Theoretical Coverage	6 m²/litre at 150 microns d.f.t and 90% volume solids 241 sq.ft/US gallon at 6 mils d.f.t and 90% volume solids See Product Characteristics
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Brush, Roller

Drying Time

			Overcoating interval with self	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
10°C (50°F)	17 hours	35 hours	24 hours	28 days[1]
15°C (59°F)	12 hours	18 hours	18 hours	28 days[1]
25°C (77°F)	6 hours	9 hours	9 hours	14 days[1]
40°C (104°F)	3 hours	4 hours	4 hours	5 days[1]

[1] Maximum overcoating intervals are shorter when using other topcoats (see Product Characteristics and Systems Compatibility sections for further information).

REGULATORY DATA

Flash Point (Typical)	Part A 82°C (180°F); Part B 54°C (129°F); Mixed 60°C (140°F)	
Product Weight	1.35 kg/l (11.3 lb/gal)	
VOC	0.92 lb/gal (111 g/lt)	EPA Method 24

See Product Characteristics section for further details

Epoxy

SURFACE PREPARATION

The performance of this product will depend upon the degree of surface preparation. The surface to be coated must be clean and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2000.

Accumulated dirt and soluble salts must be removed. Dry bristle brushing will normally be adequate for accumulated dirt. Soluble salts should be removed by fresh water washing. Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Abrasive Blast Cleaning
Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP10. If oxidation has occurred between blasting and application of Interbond 998PB , the surface should be reblasted to the specified visual standard. Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner.

Interbond 998PB is suitable for application to blast cleaned surfaces which were initially to the above standard but have been allowed to deteriorate under good shop conditions for up to 7-10 days. The surface may deteriorate to Sa2 standard but must be free from loose powdery deposits.

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/H (refer to International Hydroblasting Standards) or Grade SB2M/H (refer to International Slurry Blasting Standards). It is also possible to apply to damp surfaces in some circumstances. See Product Characteristics for further details.

Hand or Power Tool Preparation
Hand or power tool clean to a minimum St3 (ISO 8501-1:2007) or SSPC-SP3.
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 Sa2½ (ISO 8501-1:2007) or SSPC-SP6. Typically this would apply to C or D grade rusting in this standard.

Aged Coatings
Interbond 998PB 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.

Mix Ratio

3 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)
3 hours	3 hours	3 hours	1 hour

Airless Spray	Recommended	Tip Range 0.38-0.63 mm (15-25 thou) Total output fluid pressure at spray tip not less than 190 kg/cm² (2702 p.s.i.)
Air Spray (Pressure Pot)	Not recommended	
Brush	Suitable	For small areas or repair areas only.
Roller	Suitable	For small areas or repair areas only.

Thinner

- **DO NOT THIN**

Cleaner

International GTA822 (or GTA415)

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.

PRODUCT CHARACTERISTICS

The quoted theoretical volume solids for Interbond 998PB is 100% as per the definition and requirements in the Petrobras standard N-2680 – Surface Tolerant Solvent Free Epoxy Paint for Wet Surfaces. For the purposes of determining theoretical coverage and required wet film thickness, a practical value of 90% (as determined by ISO 3233) has been used.

Apply by airless spray only. Application by other methods, e.g. brush, roller, may require more than one coat and should only be used for small areas or touch-up work.

Do not apply at steel temperatures below 10°C (50°F) or in excess of 50°C (122°F). This product will not cure adequately below 10°C (50°F)

For use on steel surfaces in enclosed areas and / or continuous or intermittent immersed areas, Interbond 998PB must be specified with the aluminium red primer as the first coat. For atmospheric, non-immersed areas, alternative colours may be used as the first coat.

There are no restrictions regarding dew point temperatures and relative humidity during application and cure. Interbond 998PB can be applied over damp surfaces but cannot be applied by spray application over pools or continuous films of water.

Over-application of Interbond 998PB will extend both the minimum overcoating periods and handling times, and may be detrimental to long term overcoating properties.

Where a durable cosmetic finish with good gloss and colour retention is required overcoat with recommended topcoats. See table below for overcoating intervals.

			Overcoating Interval with recommended topcoats	
Temperature	Touch Dry	Hard Dry	*Minimum*	*Maximum*
10°C (50°F)	17 hours	35 hours	24 hours	10 days
15°C (59°F)	12 hours	18 hours	18 hours	7 days
25°C (77°F)	6 hours	9 hours	9 hours	7 days
40°C (104°F)	3 hours	4 hours	4 hours	2 days

Interbond 998PB is suitable for overcoating intact epoxy 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.

This product has the following specification approvals:

- Petrobras Specification I-ET-3010.00-1300-140-PPC-002 Rev A "Surface Tolerant Solvent Free Epoxy for Wet Surfaces". Registered under Petrobras CRCC-003720-Rev00 No. 98.000.877.
- Petrobras Standard N-2680 (immersed and non-immersed conditions)

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

Interbond 998PB is normally overcoated with itself, however, where a cosmetically acceptable topcoat is required the following products are recommended:

Intergard 740
Interthane 582
Interthane 990

For other suitable topcoats, consult International Protective Coatings.

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 litre	20 litre	5 litre	5 litre
3.6 litre	2.7 litre	3.6 litre	0.9 litre	0.9 litre

For availability of other pack sizes, contact International Protective Coatings.

SHIPPING WEIGHT (TYPICAL)

Unit Size	Part A	Part B
20 litre	22.57 kg	5.17 kg
3.6 litre	4.15 kg	0.98 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

www.international-pc.com