

Epoxy

PRODUCT DESCRIPTION

A two component, low VOC, high solids epoxy, pigmented with aluminium to provide enhanced corrosion resistance.

INTENDED USES

As a corrosion resistant, high build, self priming intermediate or finish coating for the protection of steel in aggressive environments.

Interseal 738 is easy to apply, provides excellent resistance to transit and handling damage, and is suitable for application to hand prepared steel.

PRACTICAL INFORMATION FOR INTERSEAL 738

Colour	Aluminium and a limited range of other colours.
Gloss Level	Not applicable
Volume Solids	80%
Typical Thickness	250 microns (10 mils) dry equivalent to 313 microns (12.5 mils) wet
Theoretical Coverage	3.20 m ² /litre at 250 microns d.f.t and stated volume solids 128 sq.ft/US gallon at 10 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Brush

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
10°C (50°F)	16 hours	72 hours	96 hours	14 days
15°C (59°F)	12 hours	48 hours	48 hours	10 days
25°C (77°F)	6 hours	24 hours	24 hours	7 days
40°C (104°F)	3 hours	16 hours	16 hours	3 days

REGULATORY DATA

Flash Point (Typical)	Part A 23°C (73°F); Part B 101°C (214°F); Mixed 23°C (73°F)	
Product Weight	1.40 kg/l (11.7 lb/gal)	
VOC	260 g/l	UK - PG6/23(04), Appendix 3

Protective Coatings

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SURFACE PREPARATION

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

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 ISO 8504:2000.

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

Abrasive Blast Cleaning

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of Interseal 738, 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.

Interseal 738 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.

Hand Prepared Surfaces

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.

Shop Primed Surfaces

Weld seams and damaged areas should be blast cleaned to Sa2½ (ISO 8501-1:2007) or SSPC-SP6.

If the shop primer shows extensive or widely scattered breakdown overall sweep blasting may be necessary.

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	6.40 part(s) : 1.00 part(s) by volume			
Working Pot Life	10°C (50°F) 8 hours	15°C (59°F) 6 hours	25°C (77°F) 4 hours	40°C (104°F) 2 hours
Airless Spray	Recommended	Tip Range 0.53-0.65 mm (21-26 thou) Total output fluid pressure at spray tip not less than 197 kg/cm ² (2801 p.s.i.)		
Air Spray (Pressure Pot)	Not recommended			
Brush	Suitable - Touch up and small areas only	Typically 100-125 microns (4.0-5.0 mils) can be achieved		
Roller	Not recommended			
Thinner	International GTA220	Do not thin more than allowed by local environmental 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 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

In order to achieve optimum performance on hand prepared steel, Interseal 738 should be applied as a primer coat by brush to ensure thorough wetting out of the substrate.

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.

Surface temperature must always be a minimum of 3°C (5°F) above dew point.

This product will not cure adequately below 5°C (41°F). For maximum performance ambient curing temperatures should be above 10°C (50°F).

Interseal 738 is not designed for continuous water immersion.

In common with all epoxies Interseal 738 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

When overcoating zinc silicate primers with Interseal 738 a mist coat may be required in some instances to prevent pinholing. If necessary, thin with GTA220.

Performance on steel prepared to St2 may not be as good as that achieved on steel prepared to Sa2½.

SYSTEMS COMPATIBILITY

Interseal 738 will normally be applied to correctly prepared steel substrates.

Suitable topcoats are:

Intergard 410
Intergard 740
Interseal 738
Interthane 990

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 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	17.3 litre	20 litre	2.7 litre	5 litre
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
		27.7 kg		3.05 kg	
STORAGE	Shelf Life	24 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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