

Epoxy

PRODUCT DESCRIPTION

A low VOC, two component high build, high solids, epoxy coating. Designed to give long term protection in a single coat for atmospheric service. Good resistance to both solvent and chemical splash and spill.

INTENDED USES

An extremely tough and damage resistant coating that can be applied up to 500 microns DFT in a single coat. Interplus 1180HB may replace traditional two coat epoxy systems for heavy duty use.

PRACTICAL INFORMATION FOR INTERPLUS 1180HB

Colour Range of colours via the Chromascan system, selected MIO colours.

Gloss Level Gloss

Volume Solids 84% ± 2%

Typical Thickness 250-500 microns (10-20 mils) dry equivalent to 298-595 microns (11.9-23.8 mils) wet

Theoretical Coverage 1.68 m²/litre at 500 microns d.f.t and stated volume solids
67 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

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
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	6 hours	5.5 hours	7 days
40°C (104°F)	90 minutes	2.5 hours	3 hours	5 days

REGULATORY DATA

Flash Point (Typical) Part A 26°C (79°F); Part B 34°C (93°F); Mixed 30°C (85°F)

Product Weight 1.6 kg/l (13.4 lb/gal)

VOC 1.87 lb/gal (225 g/l) 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.

Abrasive Blast: Best performance will be achieved when Interplus 1180HB is applied to surfaces prepared to Sa2½ (ISO 8501-1:2007) or SSPC-SP10; a minimum of Sa2 (ISO8501-1:2007) or SSPC-SP6 must be achieved. Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner.

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. It is also possible to apply to damp surfaces in some circumstances. Further information is available from International Protective Coatings.

Primed Steelwork: Interplus 1180HB may be applied to surfaces which have been suitably prepared and primed using approved primers; see Systems Compatibility for further details.

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	4 part(s):1 part(s) by volume			
Working Pot Life	5°C (41°F) 2.5 hours	10°C (50°F) 75 minutes	25°C (77°F) 60 minutes	40°C (104°F) 25 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)	Suitable	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 62 AC	
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 Cleaner	International GTA007	Maximum recommended thinning 10%		
Work Stoppages	International GTA007	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA007. 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 GTA007. 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.			

Epoxy

PRODUCT CHARACTERISTICS

Maximum film build in one coat is best attained by airless spray. 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 required film build.

Surface temperature must always be a minimum of 3°C (5°F) above dew point. Do not apply at steel temperatures below 4°C (39°F). 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 temperatures and high relative humidities, ensure no amine bloom is present prior to application of subsequent topcoats.

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

In common with all epoxies, Interplus 1180HB will chalk and discolour on exterior exposure.

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

Interplus 1180HB is normally applied directly to blast cleaned steel; however, it can be applied over the following primers when required:

Intercure 200	Intergard 251
Intergard 251HS	Intergard 269
Interplus 356	Interzinc 52
Interzinc 5285	

The following topcoats are approved for use with Interplus 1180HB

Interfine 878	Interfine 979
Intergard 740	Interthane 870
Interthane 990	

Epoxy

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 International Protective Coatings 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 International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	20 litre	29.9 kg		7.4 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.

This Technical Data Sheet is available on our website at www.international-marine.com or www.international-pc.com, and should be the same as this document. Should there be any discrepancies between this document and the version of the Technical Data Sheet that appears on the website, then the version on the website will take precedence.

Copyright © AkzoNobel, 23/04/2018.

All trademarks mentioned in this publication are owned by, or licensed to, the AkzoNobel group of companies.

www.international-pc.com