

Surface Tolerant Epoxy

PRODUCT DESCRIPTION A low VOC, two component, high solids, internally flexibilised, surface tolerant epoxy primer/intermediate.

INTENDED USES As a versatile, high performance maintenance coating to upgrade tightly adhering existing coatings to longer life durable systems.

May be applied to steel surfaces where it is not possible to abrasive blast and is suitable for use in conjunction with ultra high pressure hydroblasting.

Suitable for use in a wide range of industrial and coastal environments including pulp and paper plants, refineries, chemical plants, offshore structures, bridges and a range of industrial structures.

PRACTICAL INFORMATION FOR INTERPLUS 770

Colour Wide range via the Chromascan system, Light Grey MIO

Gloss Level Eggshell

Volume Solids 80% ± 3% (depends on colour)

Typical Thickness 75-200 microns (3-8 mils) dry equivalent to 94-250 microns (3.8-10 mils) wet

Theoretical Coverage 6.40 m²/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

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)	16 hours	72 hours	24 hours	Extended ¹
15°C (59°F)	12 hours	48 hours	20 hours	Extended ¹
25°C (77°F)	8 hours	24 hours	14 hours	Extended ¹
40°C (104°F)	5 hours	8 hours	8 hours	Extended ¹

¹ See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical) Part A 31°C (88°F); Part B 101°C (214°F); Mixed 33°C (91°F)

Product Weight 1.44 kg/l (12.0 lb/gal)

VOC 1.97 lb/gal (237 g/lit) EPA Method 24
162 g/kg EU Solvent Emissions Directive (Council Directive 1999/13/EC)

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SURFACE PREPARATION

The performance of this product will depend upon the degree of surface preparation. The surface to be coated must be clean, dry 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

Interplus 770 may be applied to a surface abrasive blast cleaned to a minimum Sa1 (ISO 8501-1:2007) C or D grade rusting, or SSPC SP7.

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 Sa2½ (ISO 8501-1:2007) or SSPC-SP6 which have flash rusted to no worse than Grade HB2½M (refer to International Hydroblasting Standards). It is also possible to apply to damp surfaces in some circumstances. Further information is available from International Protective Coatings.

Aged Coatings

Interplus 770 is suitable for overcoating aged coatings which show good adhesion. Loose or flaking coatings should be removed back to a firm edge. Existing epoxy or polyurethane systems which are glossy may require abrasion to ensure good intercoat adhesion.

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.			
	<ol style="list-style-type: none"> (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 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	3 hours	90 minutes
Airless Spray	Recommended	Tip Range 0.48-0.58 mm (19-23 thou) Total output fluid pressure at spray tip not less than 141 kg/cm ² (2005 p.s.i.)		
Air Spray (Pressure Pot)	Recommended	Gun DeVilbiss MBC or JGA Air Cap 704 or 765 Fluid Tip E		
Brush	Recommended	Typically 75-100 microns (3.0-4.0 mils) can be achieved		
Roller	Recommended	Typically 50-75 microns (2.0-3.0 mils) can be achieved		
Thinner	International GTA007	Do not thin more than allowed by local environmental legislation		
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 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

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). Curing below this temperature will severely retard the cure rate and the coating may stay soft for long periods.

In order to ensure good anti-corrosive performance, it is important to achieve a minimum system dry film thickness of 200 microns (8 mils) by application of multi-coats over hand prepared steel. On hand prepared rusty steel and in severe environments, patch prime with Interplus 256 or Interplus 356.

This product is not available in pale and pastel shades due to a tendency to discolour rapidly. Additionally, in common with all epoxies Interplus 770 will chalk on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance. Where a durable cosmetic finish with good gloss and colour retention is required overcoat with recommended topcoats.

Interplus 770 is formulated for maximum compatibility with aged coatings and as such, it does not exhibit the hardness of conventional epoxies.

Interplus 770 is not designed for continuous water immersion.

When applying Interplus 770 in confined spaces ensure adequate ventilation.

Premature exposure to ponding water will cause a colour change, especially in dark colours.

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.

Interplus 770 is suitable for overcoating all sound aged coatings. However, while Interplus 770 is compatible, it is not generally recommended over zinc silicate (e.g. Interzinc 22) or zinc epoxy (e.g. Interzinc 315).

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

Interplus 770 is suitable for use over the following primers:

- Intercure 200
- Intercure 420
- Intergard 251
- Intergard 269
- Intergard 475HS
- Interplus 256
- Interplus 356
- Interseal 670HS

Recommended topcoats are:

- Intercryl 530
- Interfine 629HS
- Intergard 1735
- Intergard 740
- Interplus 770
- Interplus 880
- Interthane 990

Interplus 770 is not suitable for overcoating with conventional alkyd, chlorinated rubber or acrylic finishes.

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	17.14 litre	20 litre	2.86 litre	5 litre
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
		Vol		Pack	
	20 litre	28.4 kg		3.4 kg	
U.N. Shipping No. UN 1263 (Part A) : UN 1760 (Part B)					
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.

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