

Epoxy

PRODUCT DESCRIPTION

A two component iron oxide epoxy shop primer.
 Approved for welding by Newcastle Primary Care Trust (NOHA).
 Approved for welding by Lloyd's Register.

INTENDED USES

As a shop primer for the protection of steel during fabrication and assembly.
 Weathering protection up to 6 months. Compatible with most overcoating systems.

PRACTICAL INFORMATION FOR INTERPLATE 408

Colour Pink, Red
Gloss Level Matt
Volume Solids 24% ± 2%
Typical Thickness 25 microns (1 mils) dry equivalent to 104 microns (4.2 mils) wet
Theoretical Coverage 9.60 m²/litre at 25 microns d.f.t and stated volume solids
 385 sq.ft/US gallon at 1 mils d.f.t and stated volume solids
Practical Coverage Allow appropriate loss factors
Method of Application Airless Spray, Air Spray

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
10°C (50°F)	¹	5 minutes	12 hours	Extended ²
15°C (59°F)	¹	5 minutes	12 hours	Extended ²
25°C (77°F)	¹	5 minutes	6 hours	Extended ²
40°C (104°F)	¹	5 minutes	4 hours	Extended ²

¹ Touch dry times not applicable for this product.

² See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical) Part A -18°C (0°F); Part B 5°C (41°F); Mixed -18°C (0°F)
Product Weight 1.12 kg/l (9.3 lb/gal)
VOC 5.20 lb/gal (624 g/lit) EPA Method 24
 571 g/kg EU Solvent Emissions Directive
 (Council Directive 1999/13/EC)
 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 ISO 8504:2000.

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-SP6. If oxidation has occurred between blasting and application of Interplate 408, 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.

A surface profile of 35-50 microns (1.5-2.0 mils) is recommended with preferably a rounded shape. Blasting with angular shaped abrasive may produce excessive peaks in the profile which may protrude through the primer allowing for corrosion.

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) 16 hours	15°C (59°F) 16 hours	25°C (77°F) 40°C (104°F) 16 hours 16 hours
Airless Spray	Recommended	Tip Range 0.46-0.79 mm (18-31 thou) Total output fluid pressure at spray tip not less than 88 kg/cm ² (1251 p.s.i.)	
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E
Air Spray (Conventional)	Recommended	Use suitable proprietary equipment	
Brush	Suitable - small areas only		
Roller	Suitable - small areas only		
Thinner	International GTA803	Do not thin more than allowed by local environmental legislation	
Cleaner	International GTA803		
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA803. 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 GTA803. 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

Interplate 408 is designed for use in an automatic plant. It can be applied by manual spray but this is not recommended for complex structures.

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

Dry film thicknesses above 30 microns (1.2 mils) and below 20 microns (0.8 mils) may adversely affect appearance and performance.

Above 30 microns (1.2 mils) DFT the level of weld fume and weld porosity will increase.

Drying times will depend on the substrate temperature and ventilation.

Shop primers are not recommended for use as touch-up primers after fabrication.

This product has the following specification approvals:
Approved for welding by Newcastle Primary Care Trust (NOHA)
Approved for welding by Lloyd's Register

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 are recommended for Interplate 408:

Intergard 251
Intergard 269
Intergard 400
Intergard 410
Interprime 198
Interseal 670HS
Interzone 505

For other suitable 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
	5 litre	3.75 litre	5 litre	1.25 litre	2.5 litre
	20 litre	15 litre	20 litre	5 litre	5 litre
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	5 litre	4.9 kg		1.5 kg	
	20 litre	19.6 kg		4.8 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.

Issue date: 05/02/2015

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