

Interbond 2340UPC Application Guidelines

Prepared by: WW M&PC Technical Support

www.international-pc.com

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The Application Guidelines have been produced and revised in line with the Worldwide Protective Coatings Product Range. The purpose of the guidelines is to ensure that the product, as applied, provides the required level of durability.

Successful in-service performance of a coating system depends upon both the correct choice of product(s) and the adoption of the correct guidelines for surface preparation and paint application.

The responsibilities for achieving the specific standards outlined, and for carrying out surface preparation and paint application, rest with the Contracting Company. Under no circumstances do these responsibilities rest with International Paint. We will generally provide for the presence of a Technical Service Representative at key stages during the performance of the contract. The role of the AkzoNobel Technical Service Representative is advisory only unless otherwise specified in the terms and conditions of the contract. The information contained herein presents guidelines for the application of Interbond 2340UPC to correctly prepared surfaces.

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1. INTRODUCTION

Interbond 2340UPC is a high temperature pipe coating which provides corrosion performance in accordance with the ISO12944-9 standard at ambient temperatures. Interbond 2340UPC is based upon alkylated amine epoxy technology allowing for fast cure and application in shop or on site.

2. WHERE TO APPLY INTERBOND 2340UPC

Interbond 2340UPC is suitable for use on carbon and stainless steel process piping (insulated and uninsulated) with service temperatures between -196°C (-321°F) and 205°C (401°F), in environments up to and including CX, as per ISO12944-2.

Note; where regionally available, the supplemental colour range for this product has a maximum continuous service temperature of 175°C (347°F). All versions are suitable for short term excursions to 230°C (446°F).

This document should be read in conjunction with the relevant Product Data sheet.

3. ENVIRONMENTAL CONDITIONS FOR APPLICATION

Steel surface temperature must always be a minimum of 3°C (5°F) above dew point. Ensure adequate ventilation when applying in enclosed areas.

4. SURFACE PREPARATION

At new construction, abrasive blast cleaning to a minimum of Sa2½ (ISO 8501-1:2007), with a surface profile of 50-75µm (2-3 mils), is recommended in order to achieve the optimum corrosion protection along with maximum temperature resistance capability. Assets may operate at a constant service temperature between -196°C and 205°C (-321°F – 401°F) or may cycle between -196°C (-321°F) to ambient, or from ambient to 205°C (401°F). Intermittent surges up to 230°C (446°F) are acceptable.

Stainless steel should be abrasive blasted with a suitable non-metallic abrasive, to achieve a clean and profiled surface of minimum 35µm (1.4 mil).

In on-site maintenance and repair scenarios where the expected maximum constant operating temperature is in the range ambient to 150°C (302°F), Interbond 2340UPC is suitable for application to steel substrates prepared to St2 (ISO 8501-1:2007). Care should be taken not to polish the surface when preparing.

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5. PRIMERS

Product is normally applied direct to metal and is compatible with a limited range of topcoats. These may affect service temperature limits; please contact your local International Protective Coatings representative for further advice.

6. POT LIFE

As advised on the product data sheet; pot life should not be exceeded.

7. APPLICATION

Interbond 2340UPC is recommended for application via standard airless spray methods. Please see the product data sheet for tip sizes and pressure.

Brush and roller should only be used for small areas or touch-up application.

8. STANDARD OF COSMETIC FINISH

Interbond 2340UPC is not intended as a cosmetic finish and in common with all epoxies, will chalk on external exposure. A suitable topcoat should be applied (depending on service temperature) where pipes are not be insulated in service.

9. TOPCOATS

Topcoats may be applied for reasons of identification or to provide protection in situations of high UV exposure with high rainfall. Topcoats available are Intertherm 875, for temperatures up to 205°C (401°F) or Interthane 990 for temperatures up to 120°C (248°F).

Overcoating intervals for Interbond 2340UPC:

Temperature	Minimum	Maximum
10°C (50°F)	10 hours	2 weeks
20°C (68°F)	7 hours	5 days
35°C (95°F)	4 hours	24 hours

10. POSSIBLE FILM DEFECTS

The function of Interbond 2340UPC is to provide corrosion protection to structures operating over a range of temperatures up to 205°C (401°F). As these structures are often large and complex in design, the practicalities of site working make it inevitable that film defects can occur. The manner of application should be such that these are avoided or minimised.

- **“Orange Peel”**

Difficult to avoid but can be minimised by good spray technique.

- **Over-application**

This is the result of excessive film thickness and poor spray technique.

- **Sagging**

Sagging is the result of excessive film thickness and poor spray technique. If the areas are greater than 100mm (4 inches) equivalent diameter, the incorrectly applied material should be removed and re-applied.

11. MEASUREMENT OF DRY FILM THICKNESS

An electronic DFT gauge, capable of storing statistical data, is strongly recommended, to enable a meaningful DFT survey to be conducted. Gauges should be calibrated on smooth plate.

According to both SSPC PA-2 and ISO19840:2004, the following tolerances are recommended: Individual dry film thicknesses of less than 80% of the nominal dry film thickness are not acceptable. Individual values between 80% and 100% of the nominal dry film thickness are acceptable, provided that the overall average (mean) is equal to or greater than the nominal dry film thickness.

Care shall be taken to achieve the nominal dry film thickness and to avoid areas of excessive thickness.

When coating valves, DFT readings should be taken on valve bodies, bonnets and exposed flanges and not on bolt rows, bolt and nut faces and holes, actuators, hand wheels, levers and similar hard to coat areas.

12. INSPECTION AND REPAIR

For new construction application, prepare substrate as per initial surface preparation i.e. spot blast to a minimum of Sa2½ (SSPC-SP10), or prepare by power tooling to SSPC-SP11 for small areas, followed by reinstatement to the required DFT. If in doubt, consult AkzoNobel. Where application is in planned maintenance and repair, see section 4.

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13. HEALTH AND SAFETY

Interbond 2340UPC is intended for use only by professional applicators in industrial situations in accordance with the advice given in this leaflet and on containers and should not be used without reference to the Material Health and Safety Data Sheets (MSDS) which AkzoNobel Protective Coatings has provided to its customers. If for any reason a copy of the relevant Material Health & Safety Data Sheets (MSDS) is not immediately available the user should obtain a copy before using the product.

Minimum safety precautions in dealing with all paints are:

- Take precautions to avoid skin and eye contact (i.e. use overalls, gloves, goggles, face mask, barrier creams etc.).
- Where possible provide adequate ventilation. In confined spaces with poor or no ventilation, use airfed hoods.
- If product comes in contact with the skin, wash thoroughly with lukewarm water and soap or suitable industrial cleaner. Do not wash with solvents. If the eyes are contaminated flush with water (minimum 10 minutes) and obtain medical attention at once.
- These coatings contain flammable materials and should be kept away from sparks and open flames. Smoking should be prohibited in the area.

Observe all precautionary notices on containers.

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