

Epoxy

PRODUCT DESCRIPTION

A high performance, two component epoxy primer with excellent chemical and abrasion resistance. Especially suited for properly prepared concrete substrates. It exhibits good penetration properties to ensure good adhesion on concrete floors.

INTENDED USES

Interbuild 1003 is recommended for application as a concrete sealer, a coloured intermediate/undercoat for high performance durable finishes or alternatively, can act as a finish coating where a high quality, decorative finish is not required.

Designed for a wide range of floors with various levels of mechanical and chemical exposure, for example warehouses, garages, dairies, factories, laboratories, aircraft hangers, food, beverage and plant rooms.

PRACTICAL INFORMATION FOR INTERBUILD 1003

Colour	Surf Grey
Gloss Level	High Gloss
Volume Solids	51%
Typical Thickness	50 microns (2 mils) dry equivalent to 98 microns (3.9 mils) wet
Theoretical Coverage	10.20 m ² /litre at 50 microns d.f.t and stated volume solids 409 sq.ft/US gallon at 2 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)	12 hours	40 hours	40 hours	Extended ¹
15°C (59°F)	8 hours	30 hours	30 hours	Extended ¹
25°C (77°F)	3 hours	16 hours	16 hours	Extended ¹
40°C (104°F)	2 hours	11 hours	11 hours	Extended ¹

¹ See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical)	Part A27°C (81°F);Part B29°C (84°F);Mixed28°C (82°F)		
Product Weight	1.34 kg/l (11.2 lb/gal)		
VOC	3.50 lb/gal (420 g/lit)	EPA Method 24	
	344 g/kg	EU Solvent Emissions Directive (Council Directive 2010/75/EU)	

See Product Characteristics section for further details

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SURFACE PREPARATION

Concrete, Pre-Cast Blockwork etc

Interbuild 1003 is suitable for application to concrete. For the first coat it is recommended that Interbuild 1003 is thinned 10-15% by International Thinners in order to provide good penetration of the concrete substrate and act as a primer / sealer coat.

Concrete should be cured for a minimum of 28 days prior to coating. The moisture content of the concrete should be below 6%. All surfaces should be clean, dry and free from curing compounds, release agents, trowelling compounds, surface hardeners, efflorescence, grease, oil, dirt, old coatings and loose or disintegrating concrete. All poured and precast concrete must also be sweep blasted (preferred) or acid etched to remove laitance.

Plaster, Cement Render, Concrete etc.

Surface should be clean, dry and free from contamination. Remove old, loose or flaking paint. Fill and sand minor defects.

Damp patches, oil staining, bitumen bleed, nicotine deposits, efflorescence and rust discolouration must either be treated at source, or better, the cause of such stains/defects removed. Existing mould, algae and other growth must be killed before commencing work. Domestic strength bleach diluted 1:4 with water or a proprietary fungicide solution should be used. Two treatments may be necessary, after which the area must be washed down and scrubbed to remove residues. Ideally, to prevent future infestations the conditions which support growth should be identified and cure sought.

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 Binder (Part A) with a power agitator.			
	(2) Combine entire contents of Powder (Part B) with Binder (Part A) and mix thoroughly with a power agitator.			
Mix Ratio	4 part(s) : 1 part(s) by volume			
Working Pot Life	10°C (50°F) 11 hours	15°C (59°F) 10 hours	25°C (77°F) 8 hours	40°C (104°F) 2 hours
Airless Spray	Recommended	Tip Range 0.38-0.53 mm (15-21 thou) Total output fluid pressure at spray tip not less than 176 kg/cm ² (2503 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	Recommended	Typically 40 microns (1.6 mils) can be achieved		
Roller	Recommended	Typically 40 microns (1.6 mils) can be achieved		
Thinner	International GTA220 (or International GTA415)	Do not thin more than allowed by local environmental legislation		
Cleaner	International GTA822 (or International GTA415)	Choice of cleaner maybe subject to local legislation. Please consult your local representative for specific advice.		
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 clean equipment during the course of the working day. Frequency of cleaning will depend upon amount used, 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

When applying Interbuild 1003 by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

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

In common with all epoxy coatings Interbuild 1003 may chalk or discolour on exterior exposure. Rate of chalking will depend upon climatic conditions, will have no adverse effect on chemical resistance properties and will be limited to a thin surface layer.

Condensation occurring during or immediately after application may result in a matt finish and an inferior film.

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

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

Over-application of Interbuild 1003 will extend both the minimum overcoating periods and handling times, and may be detrimental to long term overcoating properties.

For brush and roller application, and in some colours, two coats of Interbuild 1003 may be required to give uniform coverage.

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

Interbuild 1003 will normally be applied to correctly prepared concrete substrates. It is suitable for application as a primer for the following topcoats:

- Interbuild 1002
- Interbuild 1071
- Interbuild 1072
- Interbuild 1091
- Interbuild 1094

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 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 AkzoNobel 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 AkzoNobel.

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
	20 litre	24.8 kg	4.2 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.

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