

## Surface Tolerant Epoxy

### PRODUCT DESCRIPTION

A surface tolerant epoxy primer finish that combines high build capability with surface tolerance. Available with conventional pigmentation, or alternatively can be pigmented with Aluminum for additional surface tolerance to hand prepared and hydroblasted steel surfaces.

### INTENDED USES

For use as a primer finish that is especially suited to maintenance and repair situations where the steel surface is less prepared.

Suitable for use on a wide variety of structures in the onshore oil and gas, chemical and petrochemical, mining and power industries as well as bridges and infrastructure.

### PRACTICAL INFORMATION FOR EIGHTY8HUNDRED 8845

|                              |   |
|------------------------------|---|
| <b>Colour</b>                | Limited Range, Aluminium  |
| <b>Gloss Level</b>           | Semi Gloss  |
| <b>Volume Solids</b>         | 82%   |
| <b>Typical Thickness</b>     | 100-200 microns dft equivalent to 122-244 microns wft                 |
| <b>Theoretical Coverage</b>  | 8.2 m <sup>2</sup> /litre at 100 microns dft and stated volume solids |
| <b>Practical Coverage</b>    | Allow appropriate loss factors  |
| <b>Method of Application</b> | Airless spray, Brush, Roller  |

| Temperature | Touch Dry | Hard Dry | Overcoating Interval with recommended topcoats |          |
|-------------|-----------|----------|--|----------|
|             |           |          | Min  | Max      |
| 25°C        | 4 hrs     | 16 hrs   | 16 hrs   | 6 months |
| 40°C        | 2 hrs     | 8 hrs    | 8 hrs  | 3 months |

### REGULATORY DATA

**Flash Point (Typical)** Part A 36°C Part B 31°C Mixed 35°C  
**Product Weight** 1.4 kg/litre  
**VOC** 180 g/lit EPA Method 24  
 See Product Characteristics section for further details.

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### SURFACE PREPARATION

The performance of this product will depend upon the degree of surface preparation. The surface 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.

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 Cleaning

Abrasive blast clean to a minimum of Sa2½ (ISO 8501-1:2007) or SSPC-SP6. Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner. A surface profile of 50-75 microns (2-3 mils) is recommended.

#### 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 HB2½L (refer to International Hydroblasting Standards).

#### 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.

#### Aged Coatings

Eighty8Hundred 8845 is suitable for overcoating a limited range of intact, tightly adherent aged coatings. Loose or flaking coatings should be removed back to a firm edge. Glossy finishes may require light abrasion to provide a physical 'key'. See Product Characteristics section for further information.

### APPLICATION

|                         |  |
|-------------------------|--|
| <b>Mixing</b>           | 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.<br>(1) Agitate Base (Part A) with a power agitator.<br>(2) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.   |
| period after            | It is recommended that Eighty8Hundred 8845 is allowed a 10 minute induction mixing, prior to commencing application.   |
| <b>Mix Ratio</b>        | 4 part(s) : 1 part(s) by volume  |
| <b>Working Pot Life</b> | 25°C                      40°C<br>1½ hours                1 hour   |
| <b>Airless Spray</b>    | Recommended    Tip Range 0.45-0.58 mm (18-23 thou)<br>Total output fluid pressure at spray tip not less than 176 kg/cm <sup>2</sup> (2503 p.s.i.)  |
| <b>Brush</b>            | Recommended    Typically 75-125 microns (3.0-5.0 mils) can be achieved   |
| <b>Roller</b>           | Recommended    Typically 75-125 microns (3.0-5.0 mils) can be achieved   |
| <b>Thinner</b>          | International GTA220   |
| <b>Cleaner</b>          | International GTA822 (or International GTA415)   |
| <b>Work Stoppages</b>   | Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA220. 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.  |
| <b>Clean Up</b>         | 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.<br><br>All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation. |

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### PRODUCT CHARACTERISTICS

In order to achieve optimum performance on hand prepared steel, the aluminium pigmented version should be applied as a primer coat by brush to ensure thorough wetting out of the substrate by Eighty8Hundred 8845.

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. Low or high temperatures may require specific application techniques to achieve maximum film build. Over-application of Eighty8Hundred 8845 will extend both the minimum overcoating periods and handling times.

Eighty8Hundred 8845 is suitable for overcoating intact, aged epoxy and polyurethane systems. However, this product is not recommended where thermoplastic coatings such as chlorinated rubbers and vinyls have previously been used. Please consult International Protective Coatings for alternative recommendations.

Apply in good climatic conditions. The temperature of the surface to be coated must be at least 3°C above the dew point. In common with all epoxies Eighty8Hundred 8845 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance. 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.

An alternative curing agent for non-aggressive service conditions is available, which can improve productivity; please consult International Protective Coatings for advice on availability for your country.

| Temperature     | Touch Dry | Hard Dry | Overcoating Interval with recommended topcoats |          |
|-----------------|-----------|----------|--|----------|
|                 |           |          | Min  | Max      |
| 15°C            | 6 hrs     | 12 hrs   | 12 hrs   | 6 months |
| 25°C            | 3 hrs     | 6 hrs    | 6 hrs  | 6 months |
| <b>Pot Life</b> | 15°C      | 25°C     |  |          |
|                 | 2 hours   | 1½ hours |  |          |

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

The following topcoats are approved for use with Eighty8Hundred 8845:

- Eighty8Hundred 8860
- Eighty8Hundred 8862

Eighty8Hundred 8845 should only be used in schemes with other Eighty8Hundred products.

See relevant product data sheet for details.

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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](http://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  | 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  | 29.2 kg | 4.16 kg |

| STORAGE | Shelf Life   |
|---------|--|
|         | 12 months minimum at 25°C. Subject to re-inspection thereafter.<br>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](http://www.international-marine.com) or [www.international-pc.com](http://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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