

Epoxy

PRODUCT DESCRIPTION

A two component, surface tolerant, high solids, clear epoxy sealer.

INTENDED USES

A sealer coat for use on corroded steel surfaces. For use during maintenance and repair.

Interbond 600 can be applied to areas where thorough surface preparation may not be possible.

PRACTICAL INFORMATION FOR INTERBOND 600

Colour	Clear
Gloss Level	Gloss
Volume Solids	85%
Typical Thickness	45 microns (1.8 mils) dry equivalent to 53 microns (2.1 mils) wet
Theoretical Coverage	18.90 m ² /litre at 45 microns d.f.t and stated volume solids 757 sq.ft/US gallon at 1.8 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)	10 hours	29 hours	48 hours	30 days
15°C (59°F)	8 hours	20 hours	28 hours	30 days
25°C (77°F)	6.5 hours	12 hours	22 hours	30 days
40°C (104°F)	2 hours	3 hours	15 hours	30 days

REGULATORY DATA

Flash Point (Typical) Part A 93°C (200°F); Part B 93°C (200°F); Mixed 93°C (200°F)

Product Weight 1.08 kg/l (9.0 lb/gal)

VOC 1.15 lb/gal (138 g/lit) EPA Method 24

See Product Characteristics section for further details

Protective Coatings

Epoxy

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 oil and grease contamination. High pressure fresh water wash or fresh water wash as appropriate and remove all oil, grease, soluble contaminants and other foreign matter in accordance with SSPC-SP1 solvent cleaning.

Abrasive Blast Cleaning

For enhanced performance, Interbond 600 may be applied to a surface abrasive blast cleaned in accordance with Sa2½ (ISO 8501-1:2007) or SSPC-SP6.

Hand or Power Tool Preparation

Hand prepare exposed steel to a minimum St2 (ISO 8501-1:2007) or SSPC-SP2, or power tool clean to St3 (ISO 8501-1:2007) or SSPC-SP3. Optimum performance will be achieved by abrasive blasting to Sa2½ (ISO 8501-1:2007) or SSPC-SP6.

Interbond 600 may be applied to surfaces prepared to International Paint Hydroblasting Standard HB2 which have flash rusted to no worse than HB2M or SSPC-VIS 4 / NACE VIS 7 for waterjetting, designation WJ-3M.

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	1.22 part(s) : 1 part(s) by volume			
Working Pot Life	10°C (50°F) 120 minutes	15°C (59°F) 90 minutes	25°C (77°F) 60 minutes	40°C (104°F) 30 minutes
Airless Spray	Recommended	Tip Range 0.33-0.48 mm (13-19 thou) Total output fluid pressure at spray tip not less than 176 kg/cm² (2503 p.s.i.)		
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E	
Brush	Recommended	Typically 25-38 microns (1.0-1.5 mils) can be achieved		
Roller	Recommended	Typically 25-38 microns (1.0-1.5 mils) can be achieved		
Thinner	Not normally required. If necessary, use International GTA220			
Cleaner	International GTA220			
Work Stoppages	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.			
Clean Up	Clean all equipment immediately after use with International GTA220. 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.			

Epoxy

PRODUCT CHARACTERISTICS

Apply in good weather, when air and surface temperatures are above 10°C (50°F).

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

Unmixed material (in closed containers) should be maintained in protected storage in accordance with information given in the Storage section of this datasheet.

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

Interbond 600 is normally applied to rusted substrates as a sealer coat.

Interbond 600 can be overcoated with a wide range of primers.

Epoxy

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
	0.5 US gal	0.27 US gal	1 US gal	0.22 US gal	0.25 US gal
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B		
	0.5 US gal	3.5 lb	2.5 lb		
	U.N. Shipping No. Non Hazardous				
STORAGE	Shelf Life	24 months minimum at 4-38°C (40-100°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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