

High Build Epoxy Primer

PRODUCT DESCRIPTION A two pack epoxy primer suitable for use above and below the water.

INTENDED USES An epoxy primer suitable for use directly onto GRP, Steel and Aluminium or as an undercoat over suitable primer above and below water.

PRODUCT INFORMATION

Colour	YPA828-White, YPA829-Grey
Finish/Sheen	Matt
Part B (Curing Agent)	YPA824
Volume Solids	47% ±2% (ISO 3233:1998)
Mix Ratio	3 volume(s) Part A to 1 volume(s) Part B
Typical Film Thickness	125 microns dry (266 microns wet)
Theoretical Coverage	3.76 m ² /litre at 125 microns dry and 47% volume solids, allow appropriate loss factors
Method of Application	Airless Spray, Brush, Conventional Spray, Roller
Flash Point (Typical)	Part A 27°C; Part B 29°C; Mixed 28°C

Drying Information	10°C	15°C	25°C	35°C
Touch Dry [ISO 9117/3:2010]	12 hrs	9 hrs	6 hrs	5 hrs
Hard Dry [ISO 9117-1:2009]	36 hrs	16 hrs	8 hrs	6 hrs
Pot Life	12 hrs	6 hrs	4 hrs	3 hrs

Overcoating Data - see limitations	Substrate Temperature							
	10°C		15°C		25°C		35°C	
	Min	Max	Min	Max	Min	Max	Min	Max
Interfill 830	48 hrs	3 mths	36 hrs	3 mths	24 hrs	3 mths	24 hrs	3 mths
Interfill 833 Fast Cure	48 hrs	3 mths	36 hrs	3 mths	24 hrs	3 mths	24 hrs	3 mths
Interfill 835	48 hrs	3 mths	36 hrs	3 mths	24 hrs	3 mths	24 hrs	3 mths
Intergard 740	36 hrs	6 mths	16 hrs	6 mths	8 hrs	6 mths	6 hrs	3 mths
Interprime 820	36 hrs	6 mths	16 hrs	6 mths	8 hrs	6 mths	6 hrs	3 mths
Intersmooth 360 SPC	36 hrs	6 days	16 hrs	5 days	12 hrs	3 days	6 hrs	2 days
Interthane 863	36 hrs	6 days	16 hrs	5 days	8 hrs	3 days	6 hrs	2 days
Interthane 864	36 hrs	6 days	16 hrs	5 days	8 hrs	3 days	6 hrs	2 days
Interthane 987	36 hrs	6 days	16 hrs	5 days	8 hrs	3 days	6 hrs	2 days
Interthane 990	36 hrs	6 days	16 hrs	5 days	8 hrs	3 days	6 hrs	2 days

Note Overcoating intervals stated for Intersmooth 360 SPC are **NOT** to be used for any other antifouling. Other antifoulings require a coat of Intergard 263 over the Interprime 820 as a tie coat. Consult International Paint.

REGULATORY DATA **VOC** 438 g/lit as supplied (EPA Method 24)

Note: VOC values are typical and are provided for guidance purposes only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

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SYSTEMS AND COMPATIBILITY

Consult your International Paint representative for the system best suited for the surfaces to be protected. Do NOT apply over existing Intergard Epoxy Polyester (EN43) Systems.

SURFACE PREPARATIONS

Use in accordance with the standard Worldwide Marine Specifications. All surfaces to be coated should be clean, dry and free from contamination. High pressure fresh water wash or fresh water wash and scrub as appropriate to remove all dust etc from the surface. Grease and Oil etc should be removed by degreasing or solvent wiping to AS1627.1 - 2003 providing a "water breakfree" surface free of contaminates.

NEWBUILDING/MAJOR REFURBISHMENT (Steel)

Interprime 820 should be applied over the recommended primer, or used as a self priming paint system on suitably prepared substrate. The primer should be dry and free from all contamination, and Interprime 820 should be applied within the specified overcoating intervals (consult the relevant product data sheet). If applied directly over steel substrates Interprime 820 should be thinned 15%.

NEWBUILDING/MAJOR REFURBISHMENT (GRP)

Interprime 820 may be applied directly over waxed GRP surfaces. See application notes, "Epoxies over GRP Substrates".

REPAIR/ONBOARD MAINTENANCE (Steel)

Interprime 820 should be applied over the recommended primer, or used as a self priming paint system on suitably prepared substrate. The primer should be dry and free from all contamination, and Interprime 820 should be applied within the specified overcoating intervals (consult the relevant product data sheet).

Areas of breakdown, damage, etc, should be prepared to the Power Tool cleaning standard AS1627.2 class 3 or spot abrasive blasted to standard AS1627.4 class 2.5 feathering the edges back 2-3cm onto sound substrate (ISO 8501-1:2007) and primed with the specified primer prior to application of the Interprime 820.

If applied directly over steel substrates Interprime 820 should be thinned 15%.

Interprime 820 may be applied directly over aged Interprime 820 provided the surface is intact and tightly adhered to the substrate and has been cleaned as specified above. Loose or flaky paint should be removed back to a sound firm edge or an appropriate primer should be applied and be used to repair the area before the application of a full coat is attempted.

REPAIR/ONBOARD MAINTENANCE (GRP)

Interprime 820 may be applied directly over waxed GRP surfaces. See application notes, "Epoxies over GRP Substrates".

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APPLICATION	Confined Spaces - Forced air ventilation may be required. See relevant Material Safety Data Sheets.
Mixing	Material is supplied in 2 containers as a unit. Always mix a complete unit in the proportions supplied. (1) Agitate Part A with a power agitator, (2) Combine entire contents of Part A and B and mix thoroughly with a power agitator.
Thinner	Not Recommended. Use International YTA910 only in exceptional circumstances (max 5% by volume). DO NOT thin more than allowed by local environmental legislation.
Airless Spray	Recommended Tip Range 0.53-0.66 mm (21-26 thou) Total output fluid pressure at spray tip not less than 190 - 246 kg/cm ² (2700 - 3500 p.s.i.)
Conventional Spray	Use suitable proprietary equipment. Thinning may be required to achieve atomisation. If thinned multiple coats may be required to achieve minimum specified dry film thickness.
Brush	Application by brush is recommended for small areas only. Multiple coats may be required to achieve specified film thickness.
Roller	Not suitable.
Cleaner	International GTA822 Or International YTA910
Work Stoppages and Cleanup	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 all equipment immediately after use with International GTA822. Spray equipment requires flushing with this solvent. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency will depend upon factors such as amount sprayed, temperature and elapsed time including work stoppages. Monitor material condition. Do not exceed pot life limitations. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.
Welding	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.

SAFETY **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.**

Prior to use, obtain, consult and follow the Material Safety Data Sheet for this product concerning health and safety information. Read and follow all precautionary notices on the Material Safety Data Sheet and container labels. If you do not fully understand these warnings and instructions or if you can not strictly comply with them, do not use this product. Proper ventilation and protective measures must be provided during application and drying to keep solvent vapour concentrations within safe limits and to protect against toxic or oxygen deficient hazards. Take precautions to avoid skin and eye contact (ie. gloves, goggles, face masks, barrier creams etc.) Actual safety measures are dependant on application methods and work environment.

EMERGENCY CONTACT NUMBERS:

USA/Canada - Medical Advisory Number 1-800-854-6813

Europe - Contact (44) 191 4696111. For advice to Doctors & Hospitals only contact (44) 207 6359191

R.O.W. - Contact Regional Office

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LIMITATIONS

This product will not cure adequately below 5°C. For maximum performance, the ambient temperature should be above 10°C. Thinning 15% is required over metal substrates to aid in wetting out.

In common with all epoxy based coatings Interprime 820 will exhibit chalking of the film on UV exposure.

Forced air ventilation and air movement are required for an even cure of this product.

If thinned for conventional spray do not used in a tank coating situation.

Overcoating information is given for guidance only and is subject to regional variation depending upon local climate and environmental conditions. Consult your local International Paint representative for specific recommendations.

Apply in good weather. Temperature of the surface to be coated must be at least 3°C above the dew point. For optimum application properties bring the material to 21-27°C, unless specifically instructed otherwise, prior to mixing and application. Unmixed material (in closed containers) should be maintained in protected storage in accordance with information given in the STORAGE Section of this data sheet. Technical and application data herein is for the purpose of establishing a general guideline of the coating application procedures. Test performance results were obtained in a controlled laboratory environment and International Paint makes no claim that the exhibited published test results, or any other tests, accurately represent results found in all field environments. As application, environmental and design factors can vary significantly, due care should be exercised in the selection, verification of performance and use of the coating.

UNIT SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 lt	15 lt	20 lt	5 lt	5 lt
	4 lt	3 lt	4 lt	1 lt	1 lt

For availability of other unit sizes consult International Paint

UNIT SHIPPING WEIGHT (TYPICAL)	Unit Size	Unit Weight
	20 lt	29 Kg
	4 lt	5.8 Kg

STORAGE	Shelf Life	12 months minimum at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

WORLDWIDE AVAILABILITY Available in Australia and New Zealand only.

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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