

Epoxy Anticorrosive

PRODUCT DESCRIPTION **LOW TEMPERATURE**
 A two pack epoxy anticorrosive which is surface tolerant, self priming and has low VOC. A temperate version is available for use at temperatures above 10°C (see separate datasheet).

INTENDED USES A universal anticorrosive for use on underwater hulls, above water and internal areas of marine vessels, barges and offshore structures.
 Suitable for use with controlled cathodic protection.
 For use at Newbuilding, Maintenance & Repair or On Board Maintenance.

PRODUCT INFORMATION

Colour	KHA300-Off White, KHA302-Grey, KHA303-Red, KHA304-Black, KHA305- Buff, KHA308-Red Aluminium Special colours, which are not suitable for immersion service, can be matched to meet customer specifications.
Finish/Sheen	Low-Gloss
Part B (Curing Agent)	KHA414
Volume Solids	73% ±2% (ASTM D2697-86)
Mix Ratio	4 volume(s) Part A to 1 volume(s) Part B
Typical Film Thickness	125 microns dry (171 microns wet)
Theoretical Coverage	5.84 m ² /litre at 125 microns dft, allow appropriate loss factors
Method of Application	Airless Spray, Brush, Conventional Spray, Roller
Flash Point (Typical)	Part A 44°C; Part B 40°C; Mixed 40°C
Induction Period	30 minutes at temperatures below 21°C

Drying Information	-5°C	5°C	10°C	25°C
Touch Dry [ASTM D1640 7.5.1]	24 hrs	10 hrs	6 hrs	2 hrs
Hard Dry [ASTM D1640 7.7]	96 hrs	16 hrs	15 hrs	8 hrs
Pot Life	12 hrs	8 hrs	7 hrs	4 hrs

Overcoating Data - see limitations	Substrate Temperature							
	-5°C		5°C		10°C		25°C	
Overcoated By	Min	Max	Min	Max	Min	Max	Min	Max
Intergard 263	-	-	20 hrs	7 days	20 hrs	6 days	20 hrs	5 days
Intergard 267	-	-	-	-	20 hrs	6 days	20 hrs	5 days
Intergard 740	-	-	20 hrs	7 days	20 hrs	6 days	20 hrs	3 days
Interthane 990	-	-	20 hrs	7 days	20 hrs	6 days	20 hrs	5 days
Interthane 990V	-	-	20 hrs	7 days	20 hrs	6 days	20 hrs	5 days
Intertuf 262	58 hrs	3 mths	20 hrs	2 mths	20 hrs	2 mths	20 hrs	28 days

Note Stated drying times are for normal recoat situations with KHA414 converter. For ambient temperature dry time information, see Intertuf 262 temperate product datasheet. Minimum cure temperature overcoating with Intergard 267 is 10°C.

REGULATORY DATA **VOC** 285 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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CERTIFICATION

When used as part of an approved scheme, this material has the following certification:

- Food Contact - Carriage of Grain (NOHH)

Consult your International Paint representative for details.

SYSTEMS AND COMPATIBILITY

Consult your International Paint representative for the system best suited for the surfaces to be protected.

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, as appropriate, and remove all oil or grease, soluble contaminants and other foreign matter in accordance with SSPC-SP1 solvent cleaning.

NEWBUILDING

Where necessary, remove weld spatter and smooth weld seams and sharp edges.

Weld seams and damaged areas should be blast cleaned to Sa2½ (ISO 8501-1:2007) or power tooled to Pt3 (JSRA SPSS:1984)

For PVB and unapproved shop primers, the surface should be blast cleaned to Sa2½ (ISO 8501-1:2007)

For iron oxide epoxy shop primers, ensure the intact primer is clean and dry. Weld seams and damaged areas should be prepared to the specified standard (eg. Sa2½ ISO 8501-1:2001).

For optimum mechanical properties on typical iron oxide epoxy shop primers, grit sweep intact areas to AS2 International Paint Sweep Blast Standards.

For blasted areas, the primer should be applied before oxidation occurs. If oxidation does occur, the entire oxidised area should be reblasted to the specified standard above.

Intertuf 262 can be applied over Intergard 269, when used as a holding primer to protect the blast. The primer surface should be dry and free from all contamination and Intertuf 262 must be applied within the overcoating interval specified (consult the Intergard 269 product data sheet).

MAJOR REFURBISHMENT

Underwater Hull/Boottop/Topsides

Abrasive blast clean to Sa2 (ISO 8501-1:2007). If oxidation has occurred between blasting and application of Intertuf 262, the surface should be reblasted to the specified visual standard.

Surface defects revealed by the blast cleaning process, should be ground, filled, or treated in the appropriate manner.

Intertuf 262 may be applied to surfaces prepared to International Paint Hydroblasting Standard HB2 which have flash rusted to no worse than HB2L for underwater hull/boottop or HB2M for above water areas.

REPAIR

Consult International Paint.

Intertuf 262 can be applied over Intergard 269. The primer surface should be dry and free from all contamination and Intertuf 262 must be applied within the overcoating interval specified (consult the Intergard 269 product data sheet).

Areas of breakdown, damage etc. should be prepared to the specified standard (eg Sa2½ (ISO 8501-1:2007)).

Or - Intertuf 262 may be applied to surfaces prepared to International Paint Hydroblasting Standard HB2 which have flash rusted to no worse than HB2L or HB2M.

Consult your International Paint representative for specific recommendations and procedures.

NOTE:

For use in Marine situations in North America, the following surface preparation standards can be used:

SSPC-SP6 in place of Sa2 (ISO 8501-1:2007)

SSPC-SP10 in place of Sa2½ (ISO 8501-1:2007)

SSPC-SP11 in place of Pt3 (JSRA SPSS:1984)

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APPLICATION	Apply by conventional or airless spray. Application by other methods, brush or roller, may require more than one coat. Strain material through a minimum 60 mesh screen before application. Apply at 170 microns wet which will yield 125 microns dry film thickness. Consult the following equipment recommendations or utilize suitable equal.
Tinting	Range of colours available from Chromascan. Most colours require that containers be slightly short filled to accommodate the addition of colourant. Actual coverage will depend upon amount of colourant added and should be taken into consideration when ordering. A limited number of Intertuf 262 tinted colours may require more than one coat for complete hiding.
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 the power agitator, (3) Allow the coating a 30 minute sweat-in period, at temperatures below 21°C.
Thinner	DO NOT THIN BEYOND YOUR STATE'S COMPLIANCY. Material is supplied at spray viscosity and normally does not need thinning. If thinning is necessary, thin up to a maximum of 8 ounces (237 ml) per gallon with International GTA220 thinner.
Airless Spray	Minimum 30:1 ratio pump; 0.021"- 0.033" (534-838 microns) orifice tip; 3/8" (9.5 mm) ID high pressure material hose; 60 mesh tip filter
Conventional Spray	DeVilbiss MBC-510 gun E tip and 704 air cap; 3/8" (9.5 mm) ID material hose; double regulated pressure tank with oil and moisture separator.
Brush	Use appropriate size China bristle brush.
Roller	Use All Purpose Roller cover with 3/8" (9.5mm) pile smooth to medium nap. Prewash roller cover to remove loose fibers prior to use.
Cleaner	International GTA220/GTA822
Work Stoppages and Cleanup	Clean all equipment immediately after use with International GTA220/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. In North America do so in accordance with instruction in ANSI/ASC Z49.1 "Safety in Welding and Cutting."

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

Apply in good weather when air and surface temperatures are above -5°C. Surface temperatures must be at least 3°C above dew point. For optimum application properties, bring material to 10-16°C temperature range prior to mixing and application.

Unmixed material (in closed containers) should be maintained in protected storage between 4-38°C.

Ultra violet light may cause color variations if Intertuf 262 is used as a finish coat.

For North America: if overcoating Intertuf 262 direct with antifoulings, the first coat of antifouling must be applied while the Intertuf 262 is still tacky.

An ambient temperature version of this product is available, see separate data sheet.

Exposure to unacceptably low temperatures and/or high humidities during, or immediately after application may result in development of a surface 'sweat' which must be washed off with fresh water prior to overcoating, so that subsequent intercoat adhesion is not affected.

Care should be taken at temperatures close to freezing that surfaces are free from ice.

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.

Technical and application data herein is for the purpose of establishing a general guideline of the coating and proper coating application guidelines. 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 actually 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.

TINT BASE AVAILABILITY

KHA011 - Light, KHA044 - Ultra Deep

UNIT SIZE

Unit Size	Part A		Part B	
	Vol	Pack	Vol	Pack
1 US gal	0.8 US gal	1 US gal	0.2 US gal	1 US quart
5 US gal	4 US gal	5 US gal	1 US gal	1 US gal

This product can be made available in other pack sizes. Consult International Paint for details.

UNIT SHIPPING WEIGHT (TYPICAL)

Unit Size	Unit Weight
1 US gal	12.5 lb
5 US gal	61 lb

STORAGE

Shelf Life	24 months minimum from date of manufacture when maintained in protected storage at 4-38°C Subject to reinspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.
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WORLDWIDE AVAILABILITY

Consult International Paint.
Outside of North America choice of colours is restricted.

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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