Interbond 998

Surface Tolerant Epoxy

PRODUCT DESCRIPTION

A tar free, edge retentive, two pack epoxy. Interbond 998 can be applied as a one or two coat system over grit blasted, hydroblasted, mechanically or hand tool cleaned surfaces. It is also tolerant of damp and rusted surfaces (see limitations section).

INTENDED USES

A high performance epoxy coating for use in water ballast tanks, cofferdams, void spaces, wet spaces, bilges and crude oil tanks. Optically Active Pigment (OAP) is present in the off-white (KRA920) to aid in the inspection process during application.

PRODUCT INFORMATION

Colour	KRA920-Off-White, KRA922-Haze Grey, KRA924-Terracotta Red, KRA925-Dark Grey
Finish/Sheen	Gloss
Part B (Curing Agent)	KRA923
Volume Solids	90% ±2% (ASTM D2697-86)
Mix Ratio	2 volume(s) Part A to 1 volume(s) Part B
Typical Film Thickness	350 microns dry (389 microns wet)
Theoretical Coverage	2.57 m²/litre at 350 microns dft, allow appropriate loss factors
Method of Application	Airless Spray, Brush, Roller
Flash Point (Typical)	Part A 82°C; Part B 70°C; Mixed 77°C
Induction Period	Not required

Drying Information	5°C	10°C	25°C	35°C
Touch Dry [ASTM D1640 7.5.1]	14 hrs	12 hrs	4 hrs	2 hrs
Hard Dry [ASTM D1640 7.7]	32 hrs	18 hrs	6 hrs	3 hrs
Before Flooding	7 days	7 days	7 days	7 days
Pot Life	90 mins	75 mins	60 mins	45 mins

Overcoating Data - see limitations

	Substrate Temperature							
	5°C		10°C		25°C		35°C	
Overcoated By	Min	Max	Min	Max	Min	Max	Min	Max
Interbond 998	24 hrs	28 days	18 hrs	28 days	6 hrs	14 days	3 hrs	7 days
Intershield 6GV	24 hrs	14 days	18 hrs	14 days	6 hrs	10 days	3 hrs	7 days
Intershield 7100LWT	-	-	24 hrs	14 days	16 hrs	14 days	4 hrs	7 days

REGULATORY DATA

VOC 98 g/lt (0.82 lb/US Gal) 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.

MIL SPEC MIL-PRF-23236, Type VII, Class 5, 7, 11 & 17 Grade C
MIL-PRF-24667 Types I, II, V, Composition G & L

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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.
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.

MAJOR REFURBISHMENT
Abrasive blast clean to Sa2 (ISO 8501:1:1988) or hydroblast to International Paint hydroblasting standard HB2L/M.
REPAIR/OBM
Prepare area to be repaired to a minimum of St2 (ISO 8501-1:2007).
Higher levels of surface preparation will enhance product performance.
Feather or chip back surrounding area to a sound edge.

Consult your International Paint representative for specific recommendations.

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-SP2 in place of St2 (ISO 8501-1:2007)

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APPLICATION	Apply by airless spray. Application by other methods, brush or roller, may require more than one coat and is suggested for small areas only. Strain material through a minimum 60 mesh screen before application. Apply 390 microns wet which will yield 350 microns dry film thickness. Consult the following equipment recommendations or utilize suitable equal.
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 power agitator. (2) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.
Thinner	Not recommended.
Airless Spray	Minimum 70:1 ratio pump; 0.015"-0.019" (381-483 microns) orifice tip: 3/8" (9.5mm) ID high pressure material hose; 60 mesh tip filter.
Conventional Spray	Not recommended.
Brush	Use appropriate size China bristle brush.
Roller	Use All Purpose Roller cover with 9.5 mm (3/8") 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

LIMITATIONS

This product will not cure adequately below 5°C. Substrate temperature on vertical surfaces should not exceed 40°C. Interbond 998 can be applied over a damp but drying surface - not a wet surface. It cannot be applied over pools of water or water droplets. A simple test for dampness is as follows: With a finger, mark a 'V' on the surface to be coated. If drops of water collect at the bottom of the 'V', then the surface is wet not damp and should not be coated. The surface may be dried however and coated provided that it does not become wet during application.

Interbond 998 series is capable of continuing its cure process once immersed in water. However, early immersion following application will tend to retard coating cure and may result in soft films. See 'Drying Times, before flooding'.

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 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 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.

UNIT SIZE

Unit Size	Part A		Part B	
	Vol	Pack	Vol	Pack
3 US gal	2 US gal	5 US gal	1 US gal	1 US gal

For availability of other unit sizes consult International Paint

UNIT SHIPPING WEIGHT (TYPICAL)

Unit Size	Unit Weight
3 US gal	41.3 lb

STORAGE

Shelf Life	12 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.

WORLDWIDE AVAILABILITY Consult International Paint.

IMPORTANT NOTE

www.international-marine.com