

## Epoxy Primer

### PRODUCT DESCRIPTION

#### TEMPERATE

A low VOC, high solids surface tolerant, two pack epoxy primer offering corrosion protection in one coat. A low temperature version of Interseal 670HS is also available for use down to -5°C.

### INTENDED USES

For use as an anticorrosive primer for cargo holds, decks, deck fittings, topsides, superstructures, boottops, cofferdams, void spaces and wet spaces. Suitable for use with controlled cathodic protection. For use at Maintenance & Repair or On Board Maintenance.

### PRODUCT INFORMATION

<b>Colour</b>	EGA230-Aluminium, EGA231-Off White, EGA236-Grey and a range of colours <b>Alternate codes exist in North America, consult your local representative.</b>
<b>Finish/Sheen</b>	Semi-gloss (Aluminium is eggshell)
<b>Part B (Curing Agent)</b>	EGA247 (temperate)
<b>Volume Solids</b>	82% ±3% (ISO 3233:1998) (depends on colour)
<b>Mix Ratio</b>	5.67 volume(s) Part A to 1 volume(s) Part B
<b>Typical Film Thickness</b>	125 - 250 microns dry (152 - 305 microns wet)
<b>Theoretical Coverage</b>	6.56 m <sup>2</sup> /litre at 125 microns dft, allow appropriate loss factors
<b>Method of Application</b>	Airless Spray, Brush, Roller
<b>Flash Point (Typical)</b>	Part A 30°C; Part B 52°C; Mixed 32°C

<b>Drying Information</b>	10°C	15°C	25°C	35°C
Touch Dry [ISO 9117/3:2010]	8 hrs	6 hrs	5 hrs	3 hrs
Hard Dry [ISO 9117-1:2009]	32 hrs	24 hrs	18 hrs	4 hrs
Pot Life	5 hrs	3 hrs	2 hrs	1.5 hrs

<b>Overcoating Data - see limitations</b>	<b>Substrate Temperature</b>							
	10°C		15°C		25°C		35°C	
<b>Overcoated By</b>	Min	Max	Min	Max	Min	Max	Min	Max
Interfine 691	20 hrs	6 wks	14 hrs	28 days	10 hrs	14 days	7 hrs	7 days
Intergard 263	20 hrs	8 wks	14 hrs	8 wks	10 hrs	28 days	7 hrs	14 days
Intergard 740	20 hrs	12 wks	14 hrs	8 wks	10 hrs	28 days	7 hrs	14 days
Interseal 670HS Immersed Areas	32 hrs	8 wks	26 hrs	28 days	18 hrs	14 days	10 hrs	7 days
Interseal 670HS Non Immersed Areas	32 hrs	ext	26 hrs	ext	18 hrs	ext	10 hrs	ext
Intersheen 579	20 hrs	24 hrs	14 hrs	24 hrs	10 hrs	24 hrs	7 hrs	24 hrs
Interthane 990	20 hrs	8 wks	14 hrs	6 wks	10 hrs	28 days	7 hrs	14 days

### REGULATORY DATA

#### VOC

240 g/lit as supplied (EPA Method 24)  
114 g/kg of liquid paint as supplied. EU Solvent Emissions Directive (Council Directive 1999/13/EC)

**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 local representative for the system best suited for the surfaces to be protected.

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### 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.

### MAJOR REFURBISHMENT

Abrasive blast clean to Sa2 (ISO 8501-1:2007). If oxidation has occurred between blasting and application of Interseal 670HS, 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.

Interseal 670HS may be applied to surfaces prepared to International Paint Hydroblasting Standard HB2 which have flash rusted to no worse than HB2M.

### REPAIR/OBM - Exposed steel and corrosion:

Hand or power tool clean to a minimum St2 (ISO 8501-1:2007).

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). Typically this would apply to C or D grade steel in this standard.

Or

Abrasive blast clean to Sa2 (ISO 8501-1:2007). If oxidation has occurred between blasting and application of Interseal 670HS, 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.

Or

Interseal 670HS may be applied to surfaces prepared to International Paint Hydroblasting Standard HB2 which have flash rusted to no worse than HB2M.

Interseal 670HS is suitable for overlap onto most aged coating systems. Loose or flaking coatings should be removed back to a firm edge and Interseal 670HS should be applied to overlap the existing coating by 2-3 centimetres (one inch). Glossy epoxies and polyurethanes may require abrasion.

### Intact Coatings:

This product may be applied as a full coat over most generic types of paint that have been aged for at least 3 months. It is advisable that a small trial be carried out before applying a full coat over certain generic types. Consult International Paint for acceptable generic types and extent of surface preparation required.

Accurate film thickness control is essential, particularly when overcoating existing systems.

Consult your local 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-SP6 in place of Sa2 (ISO 8501-1:2007)**

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

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### 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. (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.
<b>Thinner</b>	Use International GTA220 only in exceptional circumstances. DO NOT thin more than allowed by local environmental legislation.
<b>Airless Spray</b>	Recommended Tip Range 0.45-0.58 mm (18-23 thou) Total output fluid pressure at spray tip not less than 176 kg/cm <sup>2</sup> (2500 p.s.i.)
<b>Conventional Spray</b>	Application by conventional spray is not recommended.
<b>Brush</b>	Application by brush is recommended for small areas only. Multiple coats may be required to achieve specified film thickness.
<b>Roller</b>	Application by roller is recommended for small areas only. Multiple coats may be required to achieve specified film thickness.
<b>Cleaner</b>	International GTA220/GTA822
<b>Work Stoppages and Cleanup</b>	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA220/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 GTA220/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. Do not exceed pot life limitations. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.
<b>Welding</b>	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

When used in cargo holds, application and curing temperature must be >10°C or the coating will have compromised resistance to mechanical damage.

When spraying large areas, application of a brush coat is recommended over pitted or rough surfaces to ensure full penetration. Stripe coating of complex structures is recommended.

Interseal 670HS is not suitable for use in Ballast Tanks.

Consult your local International Paint representative for availability of Underwater Hull schemes.

Optimum performance is achieved when Interseal 670HS is applied over blasted steel.

If salt water is used in the wet blast process the resulting surface must be thoroughly washed with fresh water before application of Interseal 670HS. With freshly blasted surfaces a slight degree of flash rusting is allowable, and is preferable to the surface being too wet. Puddles, ponding and accumulations of water must be removed.

In common with all epoxy based coatings Interseal 670HS will exhibit chalking of the film on UV exposure.

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.

In the overcoating data section 'ext' = extended overcoating period. Please refer to our Marine Painting Guide - Definitions and Abbreviations available from our website.

UNIT SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 lt	17 lt	20 lt	3 lt	3.7 lt
	5 US gal	4.25 US gal	5 US gal	0.75 US gal	1 US gal

For availability of other unit sizes consult International Paint

UNIT SHIPPING WEIGHT (TYPICAL)	Unit Size	Unit Weight
	20 lt	34.3 Kg
	5 US gal	32.5 lb

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.
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**WORLDWIDE AVAILABILITY** Consult International Paint.

### 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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