

Waterborne Epoxy Preconstruction Primer

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| PRODUCT DESCRIPTION | A two pack waterborne epoxy preconstruction primer. Low Odor. Low VOC. | | | | | | | | |
| INTENDED USES | A preconstruction primer for the protection of steel during fabrication and assembly. Long term weathering protection. Good cutting performance. Satisfactory welding performance. Excellent compatibility with a wide range of generic topcoats. For use at Newbuilding. | | | | | | | | |
| PRODUCT INFORMATION | Colour | NHA209-Red, and a range of colours | | | | | | | |
| | Finish/Sheen | Not applicable | | | | | | | |
| | Part B (Curing Agent) | NHA210 | | | | | | | |
| | Volume Solids | 31% ±2% (ASTM D2697-86) | | | | | | | |
| | Mix Ratio | 4 volume(s) Part A to 1 volume(s) Part B | | | | | | | |
| | Typical Film Thickness | 25 microns dry (81 microns wet), 20 - 30 microns dry practical range equivalent to 65 - 97 microns wet | | | | | | | |
| | Theoretical Coverage | 12.40 m²/litre at 25 microns dft, allow appropriate loss factors | | | | | | | |
| | Method of Application | Airless Spray, Conventional Spray | | | | | | | |
| | Flash Point (Typical) | Not applicable | | | | | | | |
| | Induction Period | 30 minutes at 23°C | | | | | | | |
| Drying Information | | 10°C | | 15°C | | 25°C | | 35°C | |
| Hard Dry [ASTM D1640 7.7] | | 45 mins | | 35 mins | | 25 mins | | 15 mins | |
| Pot Life | | | | | | 8 hrs | | | |
| Overcoating Data - see limitations | | Substrate Temperature | | | | | | | |
| | | 10°C | | 15°C | | 25°C | | 35°C | |
| Overcoated By | | Min | Max | Min | Max | Min | Max | Min | Max |
| Note | | Consult your International Paint representative for overcoating recommendations. Minimum overcoating interval 24 hours with appropriate primer. Consult your International Paint representative for further information. | | | | | | | |
| REGULATORY DATA | VOC | 298 g/ltr (2.49 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. | | | | | | | | | |

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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

Paint only clean, dry surfaces. Remove all grease, oil, soluble contaminants and other foreign matter by "solvent cleaning" (SSPC-SP1).

Steel:

For optimum performance "Near White Blast Cleaning" (SSPC-SP10) is recommended.

If shot is used as the blasting media, it is preferable to add a minimum of 20 percent grit to the abrasive mixture in order to provide some angular profile in the substrate. Remove all dust and abrasive from the surface prior to coating.

Surface profile should be between 38 microns and 63 microns.

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| APPLICATION | <p>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 80 microns wet which will yield 25 microns dry film thickness. Consult the following equipment recommendations or utilize suitable equal.</p> <p>CURING: The curing time will vary depending upon dry film thickness and conditions that exist during the application and throughout curing periods. The rate of cure can be accelerated by force curing the coating for 5 minutes at 66°C.</p> |
| 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 Part B and mix thoroughly with a power agitator. (3) Allow the coating a 30 minute sweat-in period, at temperatures below 23°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, deionized or distilled water is preferred since some tap waters could possibly affect pot life and performance characteristics. Thin only with amount necessary to obtain proper application and/or atomization (break-up) properties. |
| Airless Spray | Minimum 28:1 ratio pump; 0.015" - 0.021" (381-533 microns) orifice tip; 3/8" (9.5mm) 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. |
| Cleaner | Fresh potable water and International GTA138. |
| Work Stoppages and Cleanup | <p>Thoroughly flush all equipment with GTA138. All unused material should be stored in tightly closed containers. Partially filled containers may show a viscosity increase of the material after storage. Material should be filtered prior to use.</p> <p>Clean all equipment immediately after use with International. No metric value exists for Thinners. 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.</p> |
| 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 | <p>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.</p> <p>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.</p> <p>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</p> |

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LIMITATIONS

Apply in good weather when air and surface temperatures are above 10°C. Surface temperature must be at least 3°C above dew point. For optimum application properties, bring material to 21-27°C prior to mixing and application. Keep from freezing and do not apply under freezing conditions. 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.

| UNIT SIZE | Unit Size | Part A | | Part B | |
|--|-----------|----------|----------|----------|----------|
| | | Vol | Pack | Vol | Pack |
| | 5 US gal | 4 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 |
|--------------------------------|-----------|-------------|
| | 5 US gal | 59.8 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. |
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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.

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