

Epoxy Tie Coat

PRODUCT DESCRIPTION A two pack, tar free, epoxy tie coat.

INTENDED USES As a tie coat between anticorrosives and either antifoulings or cosmetic finishes to ensure maximum system adhesion and performance on outside shell vessel areas.
As a sealer coat over Tributyltin (TBT) antifoulings.
For use at Newbuilding, Maintenance & Repair or On Board Maintenance.

PRODUCT INFORMATION

Colour	FJA520-Buff, FJA521-Light Grey (See Systems and Compatibility section)
Finish/Sheen	Matt
Part B (Curing Agent)	FJA529
Volume Solids	54% ±2% (ISO 3233:1998)
Mix Ratio	4 volume(s) Part A to 1 volume(s) Part B
Typical Film Thickness	100 microns dry (185 microns wet)
Theoretical Coverage	5.4 m ² /litre at 100 microns dft, allow appropriate loss factors
Method of Application	Airless Spray, Brush, Roller
Flash Point (Typical)	Part A 45°C; Part B 21°C; Mixed 38°C
Induction Period	Not required

Drying Information	-5°C	5°C	25°C	35°C
Touch Dry [ISO 9117/3:2010]	24 hrs	12 hrs	6 hrs	4 hrs
Hard Dry [ISO 9117-1:2009]	72 hrs	24 hrs	16 hrs	12 hrs
Pot Life	12 hrs	8 hrs	6 hrs	4 hrs

Overcoating Data - see limitations	Substrate Temperature							
	-5°C		5°C		25°C		35°C	
Overcoated By	Min	Max	Min	Max	Min	Max	Min	Max
Intercept 8500 LPP	10 hrs	14 days	6 hrs	8 days	6 hrs	7 days	6 hrs	7 days
Intergard 5263	-	-	36 hrs	42 days	8 hrs	28 days	5 hrs	14 days
Intergard 740	72 hrs	ext	36 hrs	ext	8 hrs	ext	5 hrs	ext
Intersleek 717	-	-	36 hrs	ext	8 hrs	ext	5 hrs	ext
Intersmooth 7465Si SPC	10 hrs	14 days	5 hrs	8 days	3 hrs	5 days	2 hrs	3 days
Intersmooth 7475Si SPC	10 hrs	14 days	5 hrs	8 days	3 hrs	5 days	2 hrs	3 days
Interswift 6900Si	12 hrs	7 days	8 hrs	7 days	4 hrs	7 days	2 hrs	7 days
Interthane 989	24 hrs	ext	12 hrs	ext	6 hrs	ext	4 hrs	ext
Interthane 990	24 hrs	ext	12 hrs	ext	6 hrs	ext	4 hrs	ext

REGULATORY DATA

VOC	445 g/lit as supplied (EPA Method 24) 306 g/kg of liquid paint as supplied. EU Solvent Emissions Directive (Council Directive 1999/13/EC) 379 g/lit as supplied (PG6/23:1997)
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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

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. It is recommended that Intergard 5263 FJA520/FJA521-Buff is used in conjunction with particular lead chrome free cosmetic finishes to ensure a uniform colour on above water areas. Consult International Paint for specific recommendations.

Intergard 5263 should only be applied over epoxy anticorrosive primers. The primer to be used will depend upon vessel area and application locations. Typical primers include:

Intershield 300	Intergard 7500
Intershield 803	Intertuf 262
Intergard 343	Intertuf 362
Intergard 787	

SURFACE PREPARATIONS

Use in accordance with the standard Worldwide Marine Specifications.

All surfaces to be coated must 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.

Intergard 5263 should always be applied over a recommended primer coating system.

Intergard 5263 should be used in accordance with the specification given by International Paint.

The primer surface should be dry and free of all contamination (oil, grease, salt etc.) and overcoated with Intergard 5263 within the overcoating intervals specified. Consult the relevant primer data sheet.

Consult your International Paint representative for specific recommendations.

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APPLICATION

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	International - GTA220 DO NOT thin more than allowed by local environmental legislation.
Airless Spray	Recommended Tip Range 0.46-0.66 mm (18-26 thou) Total output fluid pressure at spray tip not less than 176 kg/cm ² (2500 p.s.i.)
Brush	Application by brush is recommended for small areas only. Multiple coats may be required to achieve specified film thickness.
Roller	Application by roller is recommended for small areas only. Multiple coats may be required to achieve specified film thickness.
Cleaner	International GTA220/GTA822
Work Stoppages and Cleanup	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.
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

Spot Repair - Intertuf 262/Intergard 5263 system may be used for the spot repair of existing epoxy, coal tar epoxy, chlorinated rubber, vinyl tar and tar-free vinyl substrates. Feathered overlap areas must be kept to a minimum. Consult International Paint. The Intertuf 262/Intergard 5263 system is not suitable for repair of bituminous substrates. Upgrade - Intertuf 262/Intergard 5263 may be used for the upgrade of existing epoxy, coal tar epoxy and chlorinated rubber substrates. Consult International Paint.
Substrates not suitable for upgrading: - vinyl tar, tar-free vinyl, bituminous.

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
	15 lt	12 lt	18 lt	3 lt	3 lt

UNIT SHIPPING WEIGHT (TYPICAL)	Unit Size	Unit Weight
	15 lt	22.32 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 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 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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