

Epoxy Primer

PRODUCT DESCRIPTION

ALUMINUM EPOXY PRIMER

A surface tolerant universal pure epoxy primer for use as an anticorrosive touch up coating providing excellent corrosion protection and low temperature capability. Designed as a crew friendly onboard maintenance two pack universal primer (<340 g/l) specifically engineered to equal mix ratio offering simplified mixing and reduced wastage.

INTENDED USES

As an On Board Maintenance universal anticorrosive primer. Suitable for use with controlled cathodic protection.

PRODUCT INFORMATION

Color	IIA121-Aluminum (A separate datasheet is available for Intershield One-2-One Red-IIA122)
Finish/Sheen	Matt
Part B (Curing Agent)	IIA125
Volume Solids	65% ±2% (ISO 3233:1998)
Mix Ratio	1 volume(s) Part A to 1 volume(s) Part B
Typical Film Thickness	3 mils dry (4.6 mils wet)
Theoretical Coverage	348 ft ² /US gal at 3 mils dft, allow appropriate loss factors
Method of Application	Airless Spray, Brush, Roller
Flash Point	Part A 102°F; Part B 81°F; Mixed 88°F
Induction Period	Not applicable

Drying Information	Substrate Temperature							
	23°F		41°F		77°F		95°F	
Touch Dry [ISO 9117/3:2010]	6 hrs		4 hrs		3 hrs		60 mins	
Hard Dry [ISO 9117-1:2009]	28 hrs		17 hrs		4 hrs		2 hrs	
Pot Life	6 hrs		6 hrs		2 hrs		60 mins	

Overcoating Data - see limitations	Substrate Temperature							
	23°F		41°F		77°F		95°F	
Overcoated By	Min	Max	Min	Max	Min	Max	Min	Max
Intergard 740	30 hrs	7 days	18 hrs	7 days	6.5 hrs	7 days	4 hrs	7 days
Intersheen 579	30 hrs	2 days	18 hrs	2 days	6.5 hrs	24 hrs	4 hrs	24 hrs
Intershield One-2-One Immersed Areas	30 hrs	14 days	18 hrs	14 days	6.5 hrs	14 days	4 hrs	14 days
Intershield One-2-One Non Immersed Areas	30 hrs	6 mths	18 hrs	6 mths	6.5 hrs	5.5 mths	4 hrs	3 mths
Interstores	30 hrs	7 days	18 hrs	7 days	6.5 hrs	7 days	4 hrs	3 days
Polyurethane								
Interthane 990	30 hrs	3 days	18 hrs	3 days	6.5 hrs	3 days	4 hrs	3 days

REGULATORY DATA

VOC	318 g/lit (2.65 lb/US gal) as supplied (EPA Method 24) 276 g/kg of liquid paint as supplied. EU Solvent Emissions Directive (Council Directive 1999/13/EC)
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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 color and normal manufacturing tolerances.

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CERTIFICATION

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

- Food Contact - FDA Compliant: Dry Foodstuffs
- Food Contact - Carriage of Grain (NOHH)
- Potable Water - Carriage of Potable Water (NSF-WRc) (BS6920)

Potable Water Certification issued by external bodies is dependent upon formulation and/or manufacturing site. Based on this, products supplied in different territories may not be approved to the standard listed above.

Intershield One-2-One has also been tested to the following standard, however this is dependent upon formulation and/or manufacturing site:

- Water Ballast Tank - IMO PSPC WBT (LR)

Consult your local representative to confirm certification status.

SYSTEMS AND COMPATIBILITY

For Water Ballast Tanks, multiple coats of Intershield One-2-One Aluminum is the recommended scheme.

Consult your local 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.

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.

Intershield One-2-One is suitable for overlap onto most aged coating systems. When overcoating aged or exposed topcoats which have chalked it is recommended that the surface is lightly abraded before application of Interstores primer. Loose or flaking coatings should be removed back to a firm edge, the area to be overlapped should be abraded and Intershield One-2-One should be applied to overlap the existing coating by 2-3 centimetres (one inch). It is advisable that a small trial be carried out before applying a full coat over certain generic types. 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-SP2 in place of St2 (ISO 8501-1:2007)

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APPLICATION

Mixing	Material is supplied in 2 containers as a unit. Once the unit has been mixed it must be used within the working pot life specified. (1) Prepare separate container (2) Agitate Base (Part A) with a power agitator and pour entire contents into separate container. (3) Agitate Curing Agent (Part B) with a power agitator and combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator. (4) Where smaller quantities of material are required, ensure that equivalent volumes of Part A and Part B are mixed in the secondary container.
Thinner	Thinning is not normally required. Consult the local representative for advice during application in extreme conditions. Do not thin more than allowed by local environmental legislation.
Airless Spray	Recommended Tip Range 19-25 thou (0.48-0.64 mm) Total output fluid pressure at spray tip not less than 3000 psi (211 kg/cm ²)
Conventional Spray	Application by conventional spray is not recommended.
Brush	Recommended
Roller	Recommended
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 Thinner. 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 vapor 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

China – Contact (86) 532 83889090

R.O.W. - Contact Regional Office

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LIMITATIONS

Optimum performance is achieved when this coating is applied over St2 (ISO 8501-1:2007) prepared steel. In common with all epoxy based coatings Intershield One-2-One 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 and the relative humidity must not exceed 85%. 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.

UNIT SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	10 lt	5 lt	5 lt	5 lt	5 lt
	2 US gal	1 US gal	1 US gal	1 US gal	1 US gal

For availability of other unit sizes consult International Paint

UNIT SHIPPING WEIGHT	Unit Size	Unit Weight
	10 lt	13.5 Kg
	2 US gal	23 lb

STORAGE	Shelf Life	12 months at 77°F. Subject to re-inspection thereafter. Store in dry, shaded conditions at temperatures 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 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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