

Epoxy Primer/ Tie Coat

PRODUCT DESCRIPTION	A quick drying two pack epoxy holding primer / tie coat which is suitable for overcoating after extended periods of weathering.			
INTENDED USES	For use as a primer for the protection of prepared steel prior to the application of a wide range of products. Can also be used as a tie coat for application to freshly applied zinc primers to prevent zinc salt formation on weathering and to reduce pinholing of subsequent applied coatings. Suitable for use with controlled cathodic protection. For use at Newbuilding, Maintenance & Repair or On Board Maintenance.			
PRODUCT INFORMATION	Colour	EGA088-Red		
	Finish/Sheen	Not applicable		
	Part B (Curing Agent)	EGA089		
	Volume Solids	47% ±2% (ISO 3233:1998)		
	Mix Ratio	4.00 volume(s) Part A to 1 volume(s) Part B		
	Typical Film Thickness	40 microns dry (85 microns wet)		
	Theoretical Coverage	11.75 m ² /litre at 40 microns dft, allow appropriate loss factors		
	Method of Application	Airless Spray, Brush, Conventional Spray, Roller		
	Flash Point (Typical)	Part A 26°C; Part B 25°C; Mixed 26°C		
	Induction Period	Not required		

Drying Information	5°C	10°C	25°C	35°C
Touch Dry [ISO 9117/3:2010]	45 mins	40 mins	30 mins	20 mins
Hard Dry [ISO 9117-1:2009]	24 hrs	16 hrs	8 hrs	2 hrs
Pot Life	20 hrs	17 hrs	8 hrs	3 hrs

Overcoating Data - see limitations	Substrate Temperature							
	5°C		10°C		25°C		35°C	
Overcoated By	Min	Max	Min	Max	Min	Max	Min	Max
Intershield 300	24 hrs	ext	17 hrs	ext	6 hrs	ext	6 hrs	ext
Intershield 300HS	24 hrs	6 mths	17 hrs	6 mths	6 hrs	6 mths	6 hrs	6 mths
Interthane 990	24 hrs	14 days	17 hrs	14 days	6 hrs	14 days	6 hrs	7 days
Intertuf 262	24 hrs	ext	17 hrs	ext	6 hrs	ext	6 hrs	ext
Intertuf 362	24 hrs	ext	17 hrs	ext	6 hrs	ext	6 hrs	ext

Note Overcoating information for all other Intergard, Intertuf, Interbond and Interprime products refer to Intertuf 262 above.

REGULATORY DATA	VOC	450 g/lit as supplied (EPA Method 24) 293 g/kg of liquid paint as supplied. EU Solvent Emissions Directive (Council Directive 1999/13/EC) 420 g/lit Chinese National Standard GB23985
------------------------	------------	---

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.

Epoxy Primer/ Tie Coat

CERTIFICATION

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

- Food Contact - Carriage of Grain (NOHH)
- Fire Resistance - Surface Spread of Flame (Exova Warringtonfire)
- Fire Resistance - Marine Equipment Directive compliant

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.

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.

As a Holding Primer for water ballast tanks

Immersion Service:

Round all welds, sharp edges and prominences to a smooth curve and remove all weld spatter before blast cleaning.

Abrasive blast clean to Sa2½ (ISO 8501-1:2007). If oxidation has occurred between blasting and application of Intergard 269, 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.

Minor areas may be prepared by power tooling to Pt3 (JSRA SPSS:1984)

As a Holding Primer for areas other than ballast tanks

Abrasive blast clean to Sa2 (ISO 8501-1:2007). If oxidation has occurred between blasting and application of Intergard 269, 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.

Intergard 269 may be applied to surfaces prepared to International Paint Hydroblasting Standard HB2 which have flash rusted to no worse than HB2L for underwater hull/boottop or HB2M for above water areas.

Minor areas may be prepared by power tooling to Pt3 (JSRA SPSS:1984)

As a Tie Coat over Zinc Primers

The primer surface should be clean, dry and free from all contamination. Areas of breakdown, damage etc. should be prepared to the specified standard (eg. Sa2½ (ISO 8501-1:2007)). Intergard 269 must be applied within the overcoated intervals specified (consult the relevant product data sheet)

To avoid pinholing over zinc primed surfaces, Intergard 269 should be thinned by 15-25% with International GTA220.

For tank coating projects, consult International Paint for the detailed tank coating procedures that should be followed.

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

SSPC-SP6 in place of Sa2 (ISO 8501-1:2007)

SSPC-SP11 in place of Pt3 (JSRA SPSS:1984)

Epoxy Primer/ Tie Coat

APPLICATION

Mixing	Material is supplied in 2 containers as a unit. Always mix a complete unit in the proportions supplied. (1) Agitate Base (Part A) with a power agitator. (2) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.
Thinner	International GTA220. 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 0.38-0.53 mm (15-21 thou) Total output fluid pressure at spray tip not less than 141 kg/cm ² (2010 p.s.i.)
Conventional Spray	Use suitable proprietary equipment. Thinning may be required.
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 GTA822/GTA220. Choice of cleaner maybe subject to local legislation. Please consult your local representative for specific advice.
Work Stoppages and Cleanup	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA822/GTA220. 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 GTA822/GTA220. 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, relative humidity 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

China – Contact (86) 532 83889090

R.O.W. - Contact Regional Office

Epoxy Primer/ Tie Coat

LIMITATIONS

This product will not cure adequately below 5°C. For maximum performance, the curing temperature should be above 10°C. The history and age of the steel and the method of working can have a significant effect on the paint consumption.

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 on our website.

UNIT SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 lt	16 lt	20 lt	4 lt	5 lt
	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
	20 lt	32.9 Kg
	5 US gal	68.4 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.
---------	------------	---

WORLDWIDE AVAILABILITY EGA042-Light Grey available in Korea only.
 EGA086-White available in Brazil only.
 EGA042 and EGA086 are suitable for use in non immersed areas only. Consult your local representative for guidance regarding certification.

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.

All trademarks mentioned in this publication are owned by, or licensed to, the AkzoNobel group of companies.

© AkzoNobel, 2021

www.international-marine.com