

Epoxy Shop Primer

PRODUCT DESCRIPTION A two pack, iron oxide epoxy shop (pre-construction) primer.

INTENDED USES As a shop (pre-construction) primer for the protection of steel during fabrication and assembly. Suitable for use with controlled cathodic protection. For use at Newbuilding.

PRODUCT INFORMATION

Color	NEA408-Red, NEA407-Pink (NEA407 is not available in North America)
Finish/Sheen	Not applicable
Part B (Curing Agent)	NEA409
Volume Solids	24% ±2% (ISO 3233:1998)
Mix Ratio	3.00 volume(s) Part A to 1 volume(s) Part B
Typical Film Thickness	1 mils dry (4.2 mils wet)
Theoretical Coverage	385 ft ² /US gal at 1 mils dft, allow appropriate loss factors
Method of Application	Airless Spray, Brush, Conventional Spray, Roller
Flash Point	Part A 0°F; Part B 41°F; Mixed 0°F (Product produced and supplied in North America has flash points of Part A 49°F, Part B 49°F and Mixed 49°F respectively due to locally sourced solvents. There is no detrimental effect on product performance.)
Induction Period	30 minutes

Drying Information	41°F	50°F	73°F	95°F
Hard Dry [ISO 9117-1:2009]	5 mins	5 mins	5 mins	5 mins
Pot Life	16 hrs	16 hrs	16 hrs	16 hrs

Overcoating Data - see limitations	Substrate Temperature							
	41°F		50°F		73°F		95°F	
Overcoated By	Min	Max	Min	Max	Min	Max	Min	Max

Note Consult International Paint.

REGULATORY DATA

VOC	624 g/lit (5.21 lb/US gal) as supplied (EPA Method 24) 571 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 material has the following certification:

- Weld Quality - Approval of Prefabrication Primers (LR)

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.

NEWBUILDING

Shop primers should be applied using automatic blasting/spraying equipment.
Abrasive blast clean to Sa2½ (ISO 8501-1:2007). Normally, steel grit or a mixture of steel grit, of particle size 0.6-1.0mm, and steel shot, of particle size 0.6-1.4mm, are used to give a predominantly angular profile.

Consult your International Paint representative for specific recommendations and procedures.

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)**

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APPLICATION

Mixing	Material is supplied in 2 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 a power agitator. (2) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.
Thinner	Not recommended. Use International GTA803 only in exceptional circumstances (max 5% by volume) DO NOT thin more than allowed by local environmental legislation.
Airless Spray	Recommended Tip Range 18-31 thou (0.46-0.79 mm) Total output fluid pressure at spray tip not less than 1250 psi (88 kg/cm ²)
Conventional Spray	Suitable. Use suitable proprietary equipment. Thinning may be required.
Brush	Application by brush is recommended for small areas only.
Roller	Application by roller is recommended for small areas only.
Cleaner	International GTA803
Work Stoppages and Cleanup	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA803. 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 GTA803. 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 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

R.O.W. - Contact Regional Office

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LIMITATIONS

Drying times will depend on substrate temperature and ventilation.
 Not recommended for manual spray application.
 If the product is manually sprayed, it is difficult to control the film thickness applied.
 Shop primers are not recommended for use as touch-up primers after fabrication.

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 5°F above the dew point. For optimum application properties bring the material to 70°F-81°F, 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
	20 lt	15 lt	20 lt	5 lt	5 lt
	4 US gal	3 US gal	5 US gal	1 US gal	1 US gal

For availability of other unit sizes consult International Paint

UNIT SHIPPING WEIGHT	Unit Size	Unit Weight
	20 lt	24.72 Kg
	4 US gal	43 lb

STORAGE	Shelf Life	12 months minimum at 77°F. 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 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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