

Epoxy Primer

PRODUCT DESCRIPTION A high solids epoxy primer. Developed to meet the requirements of MIL-PRF-24667, Types I, II and V, Composition G and L primer system.

INTENDED USES For use at Newbuilding, Maintenance & Repair or On Board Maintenance.
A primer for Intershield 6GV, Intershield 6LV or Intershield 5150LWT non-skid deck coatings.

PRODUCT INFORMATION	Colour	EGA600-Orange, EGA602-Buff		
	Finish/Sheen	Not applicable		
	Part B (Curing Agent)	EGA601		
	Volume Solids	84% ±2% (ASTM D2697-86)		
	Mix Ratio	3 volume(s) Part A to 1 volume(s) Part B		
	Typical Film Thickness	125 microns dry (149 microns wet), 100 - 175 microns dry practical range equivalent to 119 - 208 microns wet		
	Theoretical Coverage	6.72 m ² /litre at 125 microns dft, allow appropriate loss factors		
	Method of Application	Airless Spray, Brush, Roller		
	Flash Point (Typical)	Part A 43°C; Part B 52°C; Mixed 43°C		
	Induction Period	15 minutes at temperatures below 23°C		

Drying Information	10°C	25°C	35°C
Hard Dry [ASTM D1640 7.7]	20 hrs	8 hrs	5 hrs
Pot Life	105 mins	60 mins	30 mins

Overcoating Data - see limitations	Substrate Temperature					
	10°C		25°C		35°C	
Overcoated By	Min	Max	Min	Max	Min	Max
Intershield 456	24 hrs	72 hrs	8 hrs	72 hrs	5 hrs	72 hrs
Intershield 5150LWT	24 hrs	72 hrs	8 hrs	72 hrs	5 hrs	72 hrs
Intershield 6GV	24 hrs	72 hrs	8 hrs	72 hrs	5 hrs	72 hrs
Intershield 6LV	24 hrs	72 hrs	8 hrs	72 hrs	5 hrs	72 hrs
Interthane 990	24 hrs	5 days	8 hrs	5 days	5 hrs	5 days
Interthane 990HS	24 hrs	5 days	8 hrs	5 days	5 hrs	5 days

Note Drying times and pot life will vary with ambient temperature and/or humidity changes.

REGULATORY DATA	VOC	120 g/lit (1.00 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.
	MIL SPEC	MIL-PRF-24667 Type VII, Composition G & L MIL-PRF-24667 Types I, II, V, Composition G & L

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SYSTEMS AND COMPATIBILITY

Consult your International Paint representative for the system best suited for the surfaces to be protected. Refer to International Paint Coating Application Guidelines for additional information.

TYPICAL SYSTEMS:

Intershield 456/Intershield 6GV
Intershield 456/Intershield 6GV/Interthane 990
Intershield 456/Intershield 6GV/Interthane 990HS

Or

Intershield 456/Intershield 6LV
Intershield 456/Intershield 6LV/Interthane 990
Intershield 456/Intershield 6LV/Interthane 990HS

Or

Intershield 456/Intershield 5150LWT
Intershield 456/Intershield 5150LWT/Interthane 990
Intershield 456/Intershield 5150LWT/Interthane 990HS

SURFACE PREPARATIONS

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

Steel:

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

Hydroblasting to International Paint HB2½L (SSPC WJ2), with a light level of flash rust is also acceptable.

A minimum surface profile of 75 microns is required.

If oxidation has occurred between blasting and application of Intershield 456, the surface should be reblasted to the specified standard.

Where abrasive blasting is not possible "Power Tool Clean" (SSPC-SP11).

Aluminium:

For aluminium and light alloys the surface should be solvent cleaned according to SSPC-SP1 and then physically etched by abrasive blasting.

Consult your International Paint representative for specific recommendations.

NOTE:

For use in Marine situations outside North America, the following surface preparation standards can be used:

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

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

St3 (ISO 8501-1:2007) in place of SSPC-SP11

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APPLICATION	Apply by brush, roller or spray. Apply mixed material by brush, roller, or spray in an even coat to the properly prepared surface. Apply at 150 microns wet which will yield 125 microns dry film thickness. The recoat schedule must be adhered to. Surfaces must be abraded prior to applying additional coats if maximum recoat time has been exceeded. Consult the following equipment recommendations:
Mixing	Do not proportion material and do not mix until ready to use. Material is supplied in 2 containers as a unit. Always mix a complete unit in the proportion supplied. (1) Agitate Part A with a power agitator, (2) combine entire contents of Part A and B and mix thoroughly with a power agitator. (3) Allow the coating a 15 minute sweat-in period, at temperatures below 23°C. Do not combine freshly mixed material nearing the end of its pot life.
Thinner	DO NOT THIN
Airless Spray	Minimum 56:1 ratio pump; 0.017"- 0.023" (432-584 microns) orifice tip; 3/8" (9.5 mm) ID high pressure material hose; 60 mesh tip filter
Conventional Spray	Not applicable
Brush	Use appropriate size China bristle brush. Application by brush is recommended for small areas only. Multiple coats may be required to achieve specified film thickness.
Roller	Use All Purpose Roller cover with 3/8" (9.5 mm) smooth to medium nap. Prewash roller cover to remove loose fibres prior to use. Application by roller is recommended for small areas only. Multiple coats may be required to achieve specified film thickness.
Cleaner	International GTA220/GTA415
Work Stoppages and Cleanup	Clean all equipment immediately after use with International GTA220/GTA415. 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
China – Contact (86) 532 83889090
R.O.W. - Contact Regional Office

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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.

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
	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 (TYPICAL)	Unit Size	Unit Weight
	4 US gal	55 lb

STORAGE	Shelf Life	12 months 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.

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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