

Epoxy

PRODUCT DESCRIPTION A light coloured, modified epoxy primer with high volume solids (85%).

INTENDED USES As a one or two coat system which can be applied directly to mechanically prepared shop primer or grit blasted, hydroblasted or mechanically cleaned surfaces.
For use at Newbuilding, Maintenance & Repair or On Board Maintenance.

PRODUCT INFORMATION	Colour	EAB000-White, EAK724-Storm Grey, EAL549-Signal Green, EAY999-Black Range available via the Chromascan System.
	Finish/Sheen	Gloss
	Part B (Curing Agent)	EAA964
	Volume Solids	85% ±2% (ISO 3233:1998)
	Mix Ratio	4 volume(s) Part A to 1 volume(s) Part B
	Typical Film Thickness	175 - 350 microns dry (206 - 412 microns wet)
	Theoretical Coverage	4.85 m ² /litre at 175 microns dft, allow appropriate loss factors
	Method of Application	Airless Spray, Brush, Roller
	Flash Point (Typical)	Part A 30°C; Part B 58°C; Mixed 33°C
	Induction Period	Not required

Drying Information	5°C	15°C	25°C	40°C
Touch Dry [ISO 9117/3:2010]	24 hrs	10 hrs	4 hrs	90 mins
Hard Dry [ISO 9117-1:2009]	48 hrs	18 hrs	8 hrs	3 hrs
Walk-on Time	50 hrs	24 hrs	8 hrs	5 hrs
Before Flooding	3 days	2 days	24 hrs	12 hrs
Pot Life	8 hrs	2 hrs	90 mins	45 mins

Overcoating Data - see limitations	Substrate Temperature							
	5°C		15°C		25°C		40°C	
Overcoated By	Min	Max	Min	Max	Min	Max	Min	Max
Interbond 501	40 hrs	14 days	18 hrs	10 days	8 hrs	7 days	4 hrs	5 days
Interfine 629HS	40 hrs	14 days	18 hrs	10 days	8 hrs	7 days	4 hrs	5 days
Intergard 263	40 hrs	2 mths	18 hrs	2 mths	8 hrs	2 mths	4 hrs	14 days
Intergard 269	40 hrs	2 mths	18 hrs	2 mths	8 hrs	1 mths	4 hrs	14 days
Intershield 851	40 hrs	28 days	18 hrs	28 days	8 hrs	28 days	4 hrs	7 days
Interthane 990	40 hrs	14 days	18 hrs	10 days	8 hrs	7 days	4 hrs	5 days
Interzone 954	40 hrs	14 days	18 hrs	10 days	8 hrs	7 days	4 hrs	5 days

REGULATORY DATA **VOC** 225 g/lit as supplied (EPA Method 24)
151 g/kg of liquid paint as supplied. EU Solvent Emissions Directive (Council Directive 1999/13/EC)
133 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

SYSTEMS AND COMPATIBILITY

Consult your International Paint representative for the system best suited for the surfaces to be protected.

SURFACE PREPARATIONS

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, grease, soluble contaminants and other foreign matter in accordance with SSPC-SP1 : solvent cleaning.

NEWBUILDING

Where necessary, remove weld spatter and smooth weld seams and sharp edges.

Weld seams and areas of shop primer damage or breakdown should be blast cleaned to Sa2½ (ISO 8501-1:2007) or power tooled to Pt3 (JSRA SPSS:1984).

Intact, approved, shop primers must be clean, dry and free from soluble salts and any other surface contaminants.

Unapproved shop primers will require complete removal by blast cleaning to Sa2½ (ISO 8501-1:2007).

MAJOR REFURBISHMENT

Fresh water wash to remove all dirt and contamination.

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Abrasive blast clean to Sa2 (ISO 8501-1:2007) or hydroblast to International Paint hydroblasting standard HB2M/H (If abrasive blasting, the area should be fresh water washed prior to commencement).

REPAIR/OBM

Prepare areas of corrosion by mechanical cleaning to St3 (ISO 8501-1 : 2007) or hydroblast to International Paint Standard HB2M/H. Abrade surrounding intact area and feather the edges.

It is also possible to apply to damp surfaces in some circumstances. Consult your International Paint representative for details.

Interzone 954 should not be used to maintain or overcoat one component coatings.

Epoxy

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. 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 0.45-0.66 mm (18-26 thou) Total output fluid pressure at spray tip not less than 190 - 246 kg/cm ² (2700 - 3500 p.s.i.)
Brush	Application by brush is recommended for small areas only. Multiple coats may be required to achieve specified film thickness. Thinning may be required.
Roller	Application by roller is recommended for small areas only. Multiple coats may be required to achieve specified film thickness. Thinning may be required.
Cleaner	International GTA220
Work Stoppages and Cleanup	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International 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 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 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

Epoxy

LIMITATIONS

This product will not cure adequately below 5°C. Substrate temperature should not exceed 40°C. Interzone 954 can be applied over a damp but drying surface - not a wet surface. It cannot be applied over pools of water or water droplets. A simple test for dampness is as follows: With a finger, mark a 'V' on the surface to be coated. If drops of water collect at the bottom of the 'V', then the surface is wet not damp and should not be coated. The surface may be dried however and coated provided that it does not become wet during application. Interzone 954 series is capable of continuing its cure process once immersed in water. However, early immersion following application will tend to retard coating cure and may result in soft films. See 'Drying Times, Before Flooding'. The curing agent for Interzone 954 has a tendency to go cloudy when stored at temperatures below 5°C. Warming the curing agent above 5°C will restore the clear nature of the product. No adverse effect on performance is observed if the curing agent is cloudy when used. 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. 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
	20 lt	16 lt	20 lt	4 lt	5 lt

UNIT SHIPPING WEIGHT (TYPICAL)	Unit Size	Unit Weight
		20 lt

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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