

## Epoxy Primer

### PRODUCT DESCRIPTION

#### LOW TEMPERATURE

A low VOC, high solids surface tolerant, two pack epoxy primer offering corrosion protection in one coat. A temperate version of Interseal 670HS is also available for use above 10°C.

### INTENDED USES

For use as an anticorrosive primer for decks, deck fittings, topsides, superstructures, boottops, cofferdams, void spaces, underwater hull and wet spaces. Suitable for use with controlled cathodic protection.  
For use at Newbuilding.

### PRODUCT INFORMATION

<b>Colour</b>	EGA230-Aluminium, EGA231-Off White, EGA236-Grey and a range of colours Note: For use in underwater areas EGA230-Aluminium must be used as the first coat.
<b>Finish/Sheen</b>	Semi-gloss (Aluminium is eggshell)
<b>Part B (Curing Agent)</b>	EGA248 (low temperature)
<b>Volume Solids</b>	82% ±3% (depends on colour)
<b>Mix Ratio</b>	5.67 volume(s) Part A to 1 volume(s) Part B
<b>Typical Film Thickness</b>	125 - 250 microns dry (152 - 305 microns wet)
<b>Theoretical Coverage</b>	6.56 m <sup>2</sup> /litre at 125 microns dft, allow appropriate loss factors
<b>Method of Application</b>	Airless Spray, Brush, Roller
<b>Flash Point (Typical)</b>	Part A 30°C; Part B 77°C; Mixed 32°C

Drying Information	-5°C	5°C	15°C	25°C
Touch Dry [ISO 9117/3:2010]	24 hrs	9 hrs	4 hrs	60 mins
Hard Dry [ISO 9117-1:2009]	72 hrs	36 hrs	12 hrs	6 hrs
Pot Life	6 hrs	4 hrs	2 hrs	60 mins

Overcoating Data - see limitations	Substrate Temperature							
	-5°C		5°C		15°C		25°C	
Overcoated By	Min	Max	Min	Max	Min	Max	Min	Max
Interfine 691	72 hrs	10 wks	36 hrs	28 days	10 hrs	14 days	4 hrs	7 days
Intergard 263	72 hrs	12 wks	36 hrs	12 wks	10 hrs	28 days	4 hrs	14 days
Intergard 740	-	-	36 hrs	28 days	10 hrs	14 days	4 hrs	7 days
Interseal 670HS Immersed Areas	72 hrs	12 wks	36 hrs	8 wks	18 hrs	28 days	6 hrs	14 days
Interseal 670HS Non Immersed Areas	72 hrs	12 wks	36 hrs	8 wks	18 hrs	28 days	6 hrs	14 days
Intersheen 579	72 hrs	5 days	36 hrs	3 days	10 hrs	24 hrs	4 hrs	24 hrs
Interthane 990	72 hrs	6 wks	36 hrs	28 days	10 hrs	14 days	4 hrs	7 days

### REGULATORY DATA

<b>VOC</b>	240 g/lit as supplied (EPA Method 24) 114 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 colour and normal manufacturing tolerances.

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### CERTIFICATION

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

- Fire Resistance - Marine Equipment Directive compliant
- Fire Resistance - Smoke & Toxicity (Exova Warringtonfire)
- Fire Resistance - Surface Spread of Flame (Exova Warringtonfire)
- Fire Resistance - Surface Spread of Flame (WFR) - (BS476:Part 7)

Consult your local representative for details.

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### SYSTEMS AND COMPATIBILITY

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

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### SURFACE PREPARATIONS

Use in accordance with the standard Worldwide Marine Specifications.

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 or 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).

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). In some cases sweep blasting to a defined International Paint standard (eg AS2 or AS3) may be acceptable. Consult your International Paint representative for specific recommendations.

Consult your local representative for specific recommendations.

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### APPLICATION

<b>Mixing</b>	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.
<b>Thinner</b>	Use International GTA220 only in exceptional circumstances. DO NOT thin more than allowed by local environmental legislation.
<b>Airless Spray</b>	Recommended Tip Range 0.45-0.58 mm (18-23 thou) Total output fluid pressure at spray tip not less than 176 kg/cm <sup>2</sup> (2500 p.s.i.)
<b>Conventional Spray</b>	Application by conventional spray is not recommended.
<b>Brush</b>	Application by brush is recommended for small areas only. Multiple coats may be required to achieve specified film thickness.
<b>Roller</b>	Application by roller is recommended for small areas only. Multiple coats may be required to achieve specified film thickness.
<b>Cleaner</b>	International GTA220/GTA822
<b>Work Stoppages and Cleanup</b>	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. 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.
<b>Welding</b>	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**

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### LIMITATIONS

When spraying large areas, application of a brush coat is recommended over pitted or rough surfaces to ensure full penetration. Stripe coating of complex structures is recommended.

Optimum performance is achieved when Interseal 670HS is applied over blasted steel.

For use in underwater areas EGA230-Aluminium must be used as the first coat.

If salt water is used in the wet blast process the resulting surface must be thoroughly washed with fresh water before application of Interseal 670HS. With freshly blasted surfaces a slight degree of flash rusting is allowable, and is preferable to the surface being too wet. Puddles, ponding and accumulations of water must be removed.

In common with all epoxy based coatings Interseal 670HS 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. 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	17 lt	20 lt	3 lt	3.7 lt

For availability of other unit sizes consult International Paint

UNIT SHIPPING WEIGHT (TYPICAL)	Unit Size	Unit Weight
	20 lt	34.3 Kg

STORAGE	Shelf Life	12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions at temperatures 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](http://www.international-marine.com) or [www.international-pc.com](http://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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