

PRODUCT DESCRIPTION

Epoxy Interior Coating HS is a two-pack coating based on high-solid epoxy resin for use as a primer/coating on the interior surfaces of steel and aluminium yachts.

PRODUCT INFORMATION

Colour	IPK160-Grey, IPK164-White - Light Grey (approx. RAL 7035). White
Finish	Low Satin
Specific Gravity	1.58
Volume Solids	82%
Mix Ratio	1:1 by volume (as supplied) 51.5 Part A : 48.5 Part B by Weight., Converter/Curing Agent - IPK101
Typical Shelf Life	1 yrs
VOC (As Supplied)	172 g/ltr
Unit Size	20 Lt

DRYING/OVERCOATING INFORMATION

	Drying		
	15°C	23°C	35°C
Hard Dry [ISO]	7days	4days	2days
Touch Dry [ISO]	12hrs	8hrs	4hrs
Pot Life	3.5hrs		

Note: Pot life reduces as temperature and mix volume increases. Pot life refers to the Working Pot Life. It is recommended not to prepare a larger volume than required for immediate use. Drying times quoted in this datasheet were measured without thinners. Drying time will vary according to the application method, and the quantity and type of thinner used.

Overcoated By	Overcoating							
	Substrate Temperature							
	15°C		23°C		35°C			
	Min	Max	Min	Max	Min	Max	Min	Max
Epoxy Interior Coating HS	48hrs	ext	16hrs	ext	16hrs	ext		
Perfection	24hrs	12mths	8hrs	12mths	8hrs	12mths		
Perfection	24hrs	12mths	8hrs	12mths	8hrs	12mths		
UC Gloss	24hrs	12mths	8hrs	12mths	8hrs	12mths		
UC Gloss HS	24hrs	12mths	8hrs	12mths	8hrs	12mths		

Note: All overcoating times are approximate. When being overcoated, the surface must be dry, clean, grease- and dust-free.

APPLICATION AND USE

Preparation

STEEL: Blast to near white metal surface (Sa 2½) in accordance with ISO8501-1. Remove all blast or sanding residue using a clean air line and sweeping with a clean brush or broom. Vacuum clean for best results. If blast cleaning is not possible, all steel has to be re-prepared by rotary wire brushes and/or sanding discs (coarse P24) to a grade St 3. Degrease the surface. Clean off all rust, dust, oil, grease and dirt and ensure surface is dry.

STEEL with a Shop Primer: All untreated weld seams, rusted areas, burn marks and other damage in the shop primer has to be re-prepared with rotary wire brushes and/or sanding discs. Remove sanding residue, rust, dust, oil, grease and dirt and ensure surface is dry. Apply 1 coat of Epoxy GP Coating.

ALUMINIUM: Wash down with International's Super Cleaner, rinse with fresh water and allow to dry.

Hints

Mixing Ensure the correct volume mix ratio is used. Thoroughly stir Part A before use to obtain a homogenous product. Use a mixer for this that is powered by either an air-driven motor or an explosion-proof electric motor. Next add Part B (Curing Agent) while stirring until a homogenous mix is achieved.

Thinner Thinners No.7 or Sikkens Epoxy Thinners.

Thinning If the paint is too thick, e.g. at lower temperatures, add a small amount of thinners to reduce viscosity. The amount of thinner to be added depends on the conditions of application and method of application being used. Add thinner only after thoroughly mixing the components.

Cleaner Sikkens Epoxy Thinners or Degreaser (Oplosser).

Ventilation and Humidity Control Ensure adequate ventilation during use. During application and drying in a confined spaces, continuous ventilation is required to extract solvent vapours for health and safety reasons and to assist the drying process.

Airless Spray Thin 0-10% using Thinner No.7 or Sikkens Epoxy Spray Thinner at 23°C. Pressure: 140-160 bar. Tip Size: 0.38-0.44 mm/15-17 thou.

Conventional Spray Thin 10-20% using Thinner No.7 or Sikkens Epoxy Spray Thinner. Pressure: 3-4 bar. Tip Size: 1.5 mm.

Brush Thin 0-10% using Sikkens Epoxy Brush Thinner at 23°C.

Roller Thin 0-10% using Sikkens Epoxy Brush Thinner at 23°C.

Some Important Points

Ambient temperature should be minimum 15°C/59°F and maximum 35°C/95°F. Substrate temperature should be minimum 15°C/59°F and maximum 35°C/95°F. Product temperature should be no less than 15°C/59°F and maximum 35°C/95°F. The substrate temperature must be at least 3°C above the dewpoint to prevent condensation. It is recommended not to apply the product under adverse weather conditions. Coverage depends on several factors, including shape of the yacht, surface roughness, method of application being used and conditions of application.

Compatibility/Substrates

Steel, with or without shop primer and aluminium.

Number of Coats

1

Coverage

(Theoretical) - 8.00 (m²/lt)

(Practical) - 7.20 (m²/lt) by brush/roller; 6.0 m²/lt spray.

Recommended DFT

100 microns dry / 100 microns dry

Recommended WFT

125 microns wet / 125 microns wet

Application Methods

Airless Spray, Brush, Roller, Conventional Spray

TRANSPORTATION, STORAGE AND SAFETY INFORMATION

Storage

GENERAL INFORMATION:

Exposure to air and extremes of temperature should be avoided. For the full shelf life of Epoxy Interior Coating HS to be realised ensure that between use the container is firmly closed and the temperature is between 10°C/50°F and 35°C/95°F. Keep out of direct sunlight.

TRANSPORTATION:

The product should be kept in securely closed containers during transport and storage.

Safety

GENERAL: Avoid contact with skin and eyes. Epoxy Interior Coating HS can cause dermatitic skin reactions. Always use gloves and goggles and keep skin protected with overalls. Any accidental skin contact should be immediately washed off with soap and water. Do not eat, drink or smoke in mixing or application areas. Wear suitable respiratory protective equipment. Read the label safety section for Health and Safety Information, also available from our Technical Help Line.

DISPOSAL: Do not discard tins or pour paint into water courses, use the facilities provided. It is best to allow paints to harden before disposal.

Remainders of this product cannot be disposed of through the municipal waste route or dumped without permit. Disposal of remainders must be arranged for in consultation with the authorities.

IMPORTANT NOTES

The information given in this sheet is not intended to be exhaustive. Any person using the product without first making further written enquiries as to the suitability of the product for the intended purpose does so at their own risk and we can accept no responsibility for the performance of the product or for any loss or damage (other than death or personal or injury resulting from negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

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Regional Addresses

Head Office
International Paint Ltd
P O Box 20980
Oriol House
16 Connaught Place
London W2 2ZB
United Kingdom
tel: +44 (0) 171 479 6000
fax: +44 (0) 171 479 6500

European Region
International Paint Ltd
Stoneygate Lane
Felling, Gateshead
Tyne & Wear NE10 0JY
United Kingdom
tel: +44 (0) 191 469 6111
fax: +44 (0) 191 438 3977

Asia Region
International Paint Singapore
(Pte) Ltd
449 Tagore Industrial Avenue
01-03 Hong Joo Industrial
Building
Singapore 787820
tel: +65 6453 1981
fax: +65 6453 1778

Australasia Region
International Paint
115 Hyde Road
Yeronga, Brisbane
Queensland 4104
Australia
tel: +61 (0) 7 3892 8866
fax: +61 (0) 7 3892 4287

North America Region
International Paint LLC
2270 Morris Avenue
Union
New Jersey 07083
USA
tel: +1 (0) 908 686 1300
fax: +1 (0) 908 686 8545

South America Region
International Paint
Rod Rap tavares, KM 18.5
Predio Administrativo 11
Butanta CEP 05577-300
Sao Paulo, Brazil
tel: +55 (0) 11 3789 2000
fax: +55 (0) 11 3789 2200



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