

PRODUCT DESCRIPTION

Interprime 850 is a 2-component, high build epoxy sealer primer which is used above the waterline as a primer over the Interfill/Epoxy fairing compounds.

* Sanding resistant formulation protects prepared substrates and fillers from sand through

* Excellent barrier properties for sealing filler compounds

Interprime 850 is an excellent surface primer for use over bare fiberglass and gelcoat surfaces.

PRODUCT INFORMATION

Colour	YPA851-White
Finish	Matt
Specific Gravity	1.32
Volume Solids	60%
Mix Ratio	1:1 by volume (as supplied) , Converter/Curing Agent - YPA853
Typical Shelf Life	2 yrs
VOC (As Supplied)	323 g/lit
Unit Size	1 US Gallon (2 gallons/7.57lt mixed - Part A and Part B)

DRYING/OVERCOATING INFORMATION

	Drying		
	15°C	23°C	35°C
Touch Dry [ISO]	8hrs	3hrs	1.5hrs
Sandable	24hrs	16hrs	12hrs
Pot Life	5hrs	3hrs	1.5hrs

Overcoated By	Overcoating					
	Substrate Temperature					
	15°C		23°C		35°C	
	Min	Max	Min	Max	Min	Max
Interfill 830	24hrs	-	16hrs	-	12hrs	-
Interfill 833	24hrs	-	16hrs	-	12hrs	-
Interprime 820	8hrs	4days	3hrs	3days	1.5hrs	2days
Interprime 850	8hrs	4days	3hrs	3days	1.5hrs	2days
Interprime 880	8hrs	4days	3hrs	3days	1.5hrs	2days

Note:When overcoating with Interfill 830/Interfill 833, the Interprime 850 should be sanded first. Max. two coats Interprime 850 per day.

APPLICATION AND USE

Preparation

PREVIOUSLY PAINTED SURFACES:

In Good Condition: Wipe with Interprep Wipe Down Solvent using "2 rag method". Abrade with 80-180 grade paper and prime.

In Poor Condition: Remove all previous coatings and prime the substrate.

STEEL/ALUMINIUM: Degrease by wiping with a rag soaked in Interprep Wipe Down Solvent. Blast to near white metal surface (Sa 2½). If blasting is not possible, degrease the surface first as above and then disc grind the metal with 24-36 grit abrasive discs to a uniform, clean bright metal with a 50-75 micron/2-3 mils anchor pattern. Apply Interprime 820 within 1hr of metal preparation (see Interprime 820 product datasheet).

BARE GRP/COMPOSITE/EPOXY PRIMERS: Sweep blast or sand with 36-180 grade paper.

EPOXY FILLERS: Sand with 36-180 grade paper.

ALL SUBSTRATES: Remove all blasting/grinding/sanding residues with a clean air line and sweep with a clean brush or broom. (Vacuum clean for best results.)

Method

For primed, painted or gelcoated surfaces, wipe down surface with a clean rag and YTA002 using "2 rag method". Apply required number of coats, detailed in the specification sheets, by

spray, allowing required overcoating interval between applications.

Hints	<p>Mixing Stir contents of each part prior to mixing. Mix base and curing agent thoroughly at 1:1 ratio by volume. Must allow to induct for 30 mins, prior to thinning.</p> <p>Thinner YTA910, YTA925, YTA920, YTA915</p> <p>Thinning Once the mixed Interprime 850 has been inducted for 30 minutes, thin according to application method (10-20% for Conventional Spray, 0-10% for Airless Spray). The choice of thinners will depend on the ambient temperature; YTA910 at 10-21°C, YTA915 at 18-24°C, YTA920 at 24-32°C, YTA925 at 30°C+. (YTA930 should not be used with Interprime 850).</p> <p>Cleaner YTA002</p> <p>Airless Spray Pressure: 165 bar/2400 psi. Tip Size: 0.38-0.63 mm/15-25 thou.</p> <p>Conventional Spray Pressure Pot: 2.75-3.44 bar/40-50 psi - gun pressure; 10-15 psi - pot pressure Tip Size: 1.4-2.2 mm/55-86 thou.</p> <p>Brush Use brush application for touch-ups only.</p> <p>Roller Use roller application for touch-ups only.</p> <p>Other Avoid risk of solvent entrapment by adhering to film build and overcoating recommendations.</p>
Some Important Points	Avoid risk of solvent entrapment by adhering to film build and overcoating recommendations. Do not use if hull or air temperature is below 10°C/50°F. Do not use below the waterline. Do not use unless mixed thoroughly with the curing agent at specified ratio. Ensure, once mixed, it is inducted for 30 mins. Product temperature should be minimum 10°C/50°F and maximum 38°C/100°F. Ambient temperature should be minimum 10°C/50°F and maximum 38°C/100°F. Substrate temperature should be minimum 10°C/50°F and maximum 38°C/100°F.
Compatibility/Substrates	Not suitable for use over 1 part paint products. Where temperatures are below 20°C/70°F, add Interprime Accelerator at a ratio of 250ml per 2 litre mixed Interprime 850 (i.e. 12.5% by volume to the mixed Interprime 850). Note: Accelerator counts toward total percentage of thinning.
Number of Coats	Max. two coats within 24 hours.
Coverage	(Theoretical) - N/A (Practical) - 2.60 (m ² /lt) @ 305µm WFT (183µm DFT)
Recommended DFT	183 microns dry
Recommended WFT	305 microns wet
Application Methods	Brush, Roller, Airless Spray, Conventional Spray, HVLP Spray

TRANSPORTATION, STORAGE AND SAFETY INFORMATION

Storage	<p>GENERAL INFORMATION: Exposure to air and extremes of temperature should be avoided. For the full shelf life of Interprime 850 to be realised ensure that between use the container is firmly closed and the temperature is between 5°C/40°F and 35°C/95°F. Keep out of direct sunlight.</p> <p>TRANSPORTATION: Interprime 850 should be kept in securely closed containers during transport and storage.</p>
Safety	<p>GENERAL: Read the label safety section for Health and Safety Information, also available from our Technical Help Line.</p> <p>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.</p> <p>Remainders of Interprime 850 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.</p>
IMPORTANT NOTES	<p><i>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.</i></p> <p>X and International are registered trademarks of Akzo Nobel.</p>

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