

Epoxy Primer

PRODUCT DESCRIPTION A two pack primer, anticorrosive primer/undercoat pigmented with zinc phosphate.

INTENDED USES For use as an anticorrosive primer or as an undercoat on structures, vehicles or ships above water. Can be overcoated with a wide range of topcoats.

PRODUCT INFORMATION	Colour	KGA902-Red, KGA908-Sand
	Finish/Sheen	Matt
	Part B (Curing Agent)	KGA901
	Volume Solids	63% ±2% (ISO 3233:1998)
	Mix Ratio	4 volume(s) Part A to 1 volume(s) Part B
	Typical Film Thickness	50 - 75 microns dry (79 - 119 microns wet)
	Theoretical Coverage	8.4 m ² /litre at 75 microns dft, allow appropriate loss factors
	Method of Application	Airless Spray, Brush, Conventional Spray, Roller
	Flash Point (Typical)	Part A 24°C; Part B 27°C; Mixed 24°C
	Induction Period	Not required above 25°C (15 minutes below 25°C)

Drying Information	10°C	15°C	25°C	40°C
Touch Dry [ISO 9117/3:2010]	2 hrs	1 hrs	45 mins	30 mins
Hard Dry [ISO 9117-1:2009]	7 hrs	5 hrs	3 hrs	2 hrs
Pot Life	10 hrs	8 hrs	6 hrs	3 hrs

Overcoating Data - see limitations	Substrate Temperature							
	10°C		15°C		25°C		40°C	
	Min	Max	Min	Max	Min	Max	Min	Max
Overcoated By								
Interbond 201	7 hrs	ext	5 hrs	ext	3 hrs	ext	2 hrs	ext
Interbond 501	7 hrs	ext	5 hrs	ext	3 hrs	ext	2 hrs	ext
Intergard 251	7 hrs	ext	5 hrs	ext	3 hrs	ext	2 hrs	ext
Intergard 740	7 hrs	ext	5 hrs	ext	3 hrs	ext	2 hrs	ext
Interseal 670HS	7 hrs	ext	5 hrs	ext	3 hrs	ext	2 hrs	ext
Interthane 987	7 hrs	ext	5 hrs	ext	3 hrs	ext	2 hrs	ext
Interthane 990	7 hrs	ext	5 hrs	ext	3 hrs	ext	2 hrs	ext
Intertuf 262	7 hrs	ext	5 hrs	ext	3 hrs	ext	2 hrs	ext

REGULATORY DATA	VOC	390 g/lit as supplied (EPA Method 24) 282 g/kg of liquid paint as supplied. EU Solvent Emissions Directive (Council Directive 1999/13/EC) 368 g/lit Chinese National Standard GB23985
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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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SYSTEMS AND COMPATIBILITY

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

SURFACE PREPARATIONS

Use in accordance with the specification provided.

All surfaces to be coated should be clean, dry and free of contamination prior to the application of each coat. High pressure fresh water wash or fresh water wash and scrub as appropriate to remove all dust etc from the surface. Grease and Oil etc should be removed by degreasing or solvent wiping to AS1627.1 - 2003 providing a "water breakfree" surface free of contaminates.

NEWBUILDING/MAJOR REFURBISHMENT (Steel)

Intergard 251 should be applied directly to AS1627.4 class 2.5 surface where practical.

If a holding primer is required for progressive work Intergard 269 may be used.

Keep within the specified overcoating intervals (consult the relevant product data sheet).

REPAIR/ONBOARD MAINTENANCE (Steel)

The surface should be degreased to AS1627.1 - 2003 and washed with copious amounts of fresh water to form a "water breakfree" surface. Spot abrasive blast to AS1627.4 class 2.5 or power tool cleaned to AS1627.2 class 3. International Paints Hydroblasting Standard HB2M is also acceptable. All edges should be feathered 2-3cm back to a sound edge.

Recommended Blast Profile of 50-75 microns.

If a holding primer is required for progressive work Intergard 269 may be used.

The surface should be dry and free from all contamination prior to the application of the Intergard 251 and should be applied within the specified overcoating intervals.

Intergard 251 can be applied over aged or re-oxidised (gingered) areas as long as it is not loosely adhered.

Consult your International Paint representative for suitable systems.

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APPLICATION	Confined Spaces - Forced air ventilation may be required. See relevant Material Safety Data Sheets.
Mixing	Material is supplied in 2 containers as a unit. Always mix a complete unit in the proportions supplied. (1) Agitate Base (Part A) with a 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 0.38-0.53 mm (15-21 thou) Total output fluid pressure at spray tip not less than 141 kg/cm ² (2010 p.s.i.)
Conventional Spray	Use suitable proprietary equipment. Thinning may be required. If thinning is required multiple coats may be required to achieve minimum specified dry film thickness.
Brush	Application by brush is recommended for small areas only. Multiple coats may be required to achieve specified film thickness.
Roller	Application by roller is recommended for small areas only. Multiple coats may be required to achieve specified film thickness.
Cleaner	International GTA822 or International GTA220 (USA)
Work Stoppages and Cleanup	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International 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 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.
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.

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:

Australia - Corporate HS&E Dept, Health & Safety advisor 61 (0) 393134555

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

This product will not cure adequately below 5°C. For maximum performance, the ambient temperatures should be above 10°C. The history and age of the steel can have a significant effect on the paint consumption. Over thickness application should be avoided as this will lead to coating delamination. Not for continuous immersion. 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. In the overcoating data section 'ext' = extended overcoating period. Please refer to our Marine Painting Guide - Definitions and Abbreviations available on our website.

UNIT SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 lt	16 lt	20 lt	4 lt	4 lt
	4 lt	3.2 lt	4 lt	0.8 lt	1 lt

For availability of other unit sizes consult International Paint

UNIT SHIPPING WEIGHT (TYPICAL)	Unit Size	Unit Weight
	20 lt	30.3 Kg
	4 lt	6.58 Kg

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.
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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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