

Epoxy Anticorrosive

PRODUCT DESCRIPTION A hard wearing, surface tolerant two pack epoxy primer that is winter workable, down to -5°C.

INTENDED USES A high performance anticorrosive coating for use from Keel to Rail.
Suitable for use with controlled cathodic protection.
For use at Newbuilding, Maintenance & Repair or On Board Maintenance.

PRODUCT INFORMATION	Colour	KHA323-Red, KHA322-Grey (North America only)
	Finish/Sheen	Sheen
	Part B (Curing Agent)	KHA362
	Volume Solids	67% ±2% (ISO 3233:1998)
	Mix Ratio	3.00 volume(s) Part A to 1 volume(s) Part B
	Typical Film Thickness	150 microns dry (224 microns wet)
	Theoretical Coverage	4.47 m ² /litre at 150 microns dft, allow appropriate loss factors
	Method of Application	Airless Spray, Brush, Roller
	Flash Point (Typical)	Part A 25°C; Part B 24°C; Mixed 27°C
	Induction Period	Not required

Drying Information	-5°C	5°C	25°C	35°C
Touch Dry [ISO 9117/3:2010]	4 hrs	2.5 hrs	60 mins	45 mins
Hard Dry [ISO 9117-1:2009]	24 hrs	12 hrs	4 hrs	2.5 hrs
Pot Life	6 hrs	5 hrs	2 hrs	60 mins

Overcoating Data - see limitations

Overcoated By	Substrate Temperature							
	-5°C		5°C		25°C		35°C	
	Min	Max	Min	Max	Min	Max	Min	Max
Interbond 201	24 hrs	14 days	12 hrs	14 days	4 hrs	14 days	-	-
Intergard 263	24 hrs	14 days	12 hrs	14 days	4 hrs	14 days	2.5 hrs	14 days
Intergard 282	24 hrs	14 days	12 hrs	14 days	4 hrs	14 days	-	-
Intergard 740	-	-	12 hrs	7 days	4 hrs	7 days	2.5 hrs	7 days
Intertuf 362	24 hrs	15 days	12 hrs	15 days	4 hrs	15 days	2.5 hrs	15 days

Note The overcoating data above for Interbond 201 applies to the **Low Temperature** version only.

REGULATORY DATA	VOC	283 g/lit as supplied (EPA Method 24) 199 g/kg of liquid paint as supplied. EU Solvent Emissions Directive (Council Directive 1999/13/EC) 248 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 standard Worldwide Marine Specifications.

All surfaces to be coated should 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.

Intertuf 362 can be applied over Intergard 269, when used as a holding primer to protect the blast. The primer surface should be dry and free from all contamination and Intertuf 362 must be applied within the overcoating interval specified (consult the Intergard 269 product data sheet).

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). 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.

MAJOR REFURBISHMENT

Abrasive blast clean to Sa2 (ISO 8501-1:2007). If oxidation has occurred between blasting and application of Intertuf 362, the surface should be reblasted to the specified visual standard.

Surface defects revealed by the blast cleaning process, should be ground, filled, or treated in the appropriate manner.

Intertuf 362 may be applied to surfaces prepared to International Paint Hydroblasting Standard HB2 which have flash rusted to no worse than HB2M. Hydroblasting is only recommended for underwater hull, above water and topside areas.

Intertuf 362 may be applied to surfaces prepared to International Slurry Blasting Standard SB2 which have flash rusted no worse than SB2M. Slurry blasting is only recommended for underwater hull, above water and topside areas.

REPAIR

Consult International Paint.

Consult your International Paint representative for specific recommendations.

NOTE

For use in Marine situations in North America, the following surface preparation standards can be used:

SSPC-SP10 in place of Sa2½ (ISO 8501-1:2007)

SSPC-SP6 in place of Sa2 (ISO 8501-1:2007)

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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 0.53-0.84 mm (21-33 thou) Total output fluid pressure at spray tip not less than 176 kg/cm ² (2500 p.s.i.)
Conventional Spray	Application by conventional spray is not recommended.
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/GTA220

Work Stoppages and Cleanup Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA822/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 GTA822/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

China - Contact (86) 532 83889090

R.O.W. - Contact Regional Office

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LIMITATIONS

A system of Intertuf 362 followed by Intergard 263 may be used for the spot repair or upgrade of the following substrates:

Spot Repair (Suitable Substrates): - Epoxy, Coal Tar Epoxy, Chlorinated Rubber, Vinyl Tar, Tar-free Vin

Substrates not suitable for repair : - Bituminous

Upgrade (Suitable Substrates): - Epoxy, Coal Tar Epoxy, Chlorinated Rubber

Substrates not suitable for upgrading:- Vinyl Tar, Tar-free Vinyl, Bituminous

Feathered overlap areas must be kept to a minimum.

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.

Under certain climatic conditions, particularly at low temperature and high humidity, amine bloom can occur on the coating surface during drying. In order to prevent this, an induction period of 30 minutes is recommended between mixing and paint application at temperatures below 25°C.

UNIT SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 lt	15 lt	20 lt	5 lt	5 lt
	4 US gal	3 US gal	5 US gal	1 US gal	1 US gal

For availability of other unit sizes consult International Paint

UNIT SHIPPING WEIGHT (TYPICAL)	Unit Size	Unit Weight
	20 lt	33.33 Kg
	4 US gal	56 lb

STORAGE	Shelf Life	Part A - 6 months minimum at temperatures up to 25°C Part B - 12 months minimum at 25°C. Subject to reinspection 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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