

Epoxy Intermediate/ Finish

PRODUCT DESCRIPTION A two pack, high build epoxy intermediate or finish coat with good chemical and abrasion resistance.

INTENDED USES For use on above water areas and in dry cargo holds as a high build intermediate or finish coat on structural steel, piping etc.
For use at Newbuilding, Maintenance & Repair or On Board Maintenance.

PRODUCT INFORMATION

Colour	EMB000-White ; and a wide range of colours.
Finish/Sheen	Gloss
Part B (Curing Agent)	EMA080
Volume Solids	60% ±2% (ISO 3233:1998)
Mix Ratio	4 volume(s) Part A to 1 volume(s) Part B
Typical Film Thickness	125 microns dry (208 microns wet)
Theoretical Coverage	4.8 m²/litre at 125 microns dft, allow appropriate loss factors
Method of Application	Airless Spray, Brush, Conventional Spray, Roller
Flash Point (Typical)	Part A 30°C; Part B 29°C; Mixed 30°C
Induction Period	Not required

Drying Information	10°C	15°C	25°C	35°C
Touch Dry [ISO 9117/3:2010]	5 hrs	4 hrs	2 hrs	60 mins
Hard Dry [ISO 9117-1:2009]	24 hrs	20 hrs	10 hrs	6 hrs
Pot Life	8 hrs	6 hrs	4 hrs	2 hrs

Overcoating Data - see limitations

	Substrate Temperature							
	10°C		15°C		25°C		35°C	
Overcoated By	Min	Max	Min	Max	Min	Max	Min	Max
Intergard 410	24 hrs	10 days	20 hrs	7 days	10 hrs	7 days	6 hrs	4 days
Interthane 990	24 hrs	10 days	20 hrs	7 days	10 hrs	7 days	6 hrs	4 days

REGULATORY DATA

VOC	403 g/lit as supplied (EPA Method 24) 338 g/kg of liquid paint as supplied. EU Solvent Emissions Directive (Council Directive 1999/13/EC) 369 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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CERTIFICATION

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

- Food Contact - Carriage of Grain (NOHA)
- Fire Resistance - Marine Equipment Directive compliant
- Fire Resistance - Surface Spread of Flame (Exova Warringtonfire)
- Fire Resistance - Smoke & Toxicity (Exova Warringtonfire)

Consult your International Paint representative for details.

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.

NEWBUILDING/MAJOR REFURBISHMENT

Intergard 410 should always be applied over a recommended primer coating scheme. The primer surface should be dry and free from all contamination, and Intergard 410 must be applied within the overcoating intervals specified (consult the relevant product data sheet). Areas of breakdown, damage etc., should be prepared to the specified standard (e.g. Sa2½ (ISO 8501-1:2007) and primed prior to the application of Intergard 410

REPAIR

Repair corroded areas with the specified anticorrosive scheme and apply Intergard 410 within the overcoating intervals specified for the primer (consult relevant primer data sheet).

Apply the Intergard 410 within the overcoating interval specified for the primer, (consult relevant primer data sheet).

Ensure that the area is clean and dry prior to application of Intergard 410.

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)**

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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 0.45-0.58 mm (18-23 thou) Total output fluid pressure at spray tip not less than 176 kg/cm ² (2500 p.s.i.)
Conventional Spray	Suitable. Use suitable proprietary equipment. Thinning may be required.
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
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. 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

This product will not cure adequately below 5°C. For maximum performance ambient curing temperatures should be above 10°C.

In common with all epoxy based coatings Intergard 410 will exhibit chalking of the film on UV exposure.

Where a cosmetic finish with good gloss and colour retention is required, overcoat with recommended top coats.

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	16 lt	20 lt	4 lt	5 lt

For availability of other unit sizes consult International Paint

UNIT SHIPPING WEIGHT (TYPICAL)	Unit Size	Unit Weight
	20 lt	28.4 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.	

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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