

## Epoxy

### PRODUCT DESCRIPTION

A two component, fast drying modified epoxy phosphate prefabrication primer for manual or automatic spray application.

### INTENDED USES

To preprime steel prior to the fabrication process.

Can be overcoated with a large range of coating systems which are suitable for use in a wide spectrum of environments ranging from water immersion, aggressive coastal to rural situations.

### PRACTICAL INFORMATION FOR INTERPLATE 398

<b>Colour</b>	Red, Grey
<b>Gloss Level</b>	Matt
<b>Volume Solids</b>	25%
<b>Typical Thickness</b>	25 microns (1 mils) dry equivalent to 100 microns (4 mils) wet
<b>Theoretical Coverage</b>	10 m <sup>2</sup> /litre at 25 microns d.f.t and stated volume solids 401 sq.ft/US gallon at 1 mils d.f.t and stated volume solids
<b>Practical Coverage</b>	Allow appropriate loss factors
<b>Method of Application</b>	Airless Spray, Air Spray, Brush, Roller

#### Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
10°C (50°F)	4 minutes	5 minutes	16 hours	Extended <sup>1</sup>
15°C (59°F)	4 minutes	4 minutes	12 hours	Extended <sup>1</sup>
25°C (77°F)	3 minutes	4 minutes	6 hours	Extended <sup>1</sup>
40°C (104°F)	2 minutes	3 minutes	4 hours	Extended <sup>1</sup>

<sup>1</sup> See International Protective Coatings Definitions and Abbreviations

### REGULATORY DATA

<b>Flash Point (Typical)</b>	Part A -17°C (1°F); Part B 5°C (41°F); Mixed -17°C (1°F)	
<b>Product Weight</b>	1.10 kg/l (9.2 lb/gal)	
<b>VOC</b>	617 g/kg	EU Solvent Emissions Directive (Council Directive 1999/13/EC)
See Product Characteristics section for further details		

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### SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2000.

Where necessary, remove weld spatter and smooth weld seams and sharp edges.

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

### Abrasive Blast Cleaning

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of Interplate 398, 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.

This product is NOT recommended over hand prepared steel.

### APPLICATION

<b>Mixing</b>	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 a power agitator.	
	(2)	Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.	
<b>Mix Ratio</b>	19 part(s) : 1 part(s) by volume		
<b>Working Pot Life</b>	10°C (50°F) 16 hours	15°C (59°F) 16 hours	25°C (77°F) 40°C (104°F) 16 hours 16 hours
<b>Airless Spray</b>	Recommended	Automatic plant: Tip range 0.45-0.53 mm (18-21 thou) Manual application: Tip range 0.38-0.53 mm (15-21 thou) Total output fluid pressure at spray tip not less than 88 kg/cm <sup>2</sup> (1,250 p.s.i.)	
<b>Air Spray (Pressure Pot)</b>	Suitable	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E
<b>Air Spray (Conventional)</b>	Recommended	Use suitable proprietary equipment	
<b>Brush</b>	Suitable	Only for small areas or touch ups	
<b>Roller</b>	Suitable	Only for small areas or touch ups	
<b>Thinner</b>	International GTA803	Do not thin more than allowed by local environmental legislation	
<b>Cleaner</b>	International GTA803		
<b>Work Stoppages</b>	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA803. 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.		
<b>Clean Up</b>	Clean all equipment immediately after use with International GTA803. 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.		
	All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.		

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### PRODUCT CHARACTERISTICS

Satisfactory welding properties will only be obtained by strict control of application to the recommended film thickness. Over application of Interplate 398 will result in increased levels of weld fume on cutting and welding, and will also increase the porosity of the welds.

Best results will be obtained from application by automatic plant to preheated steel at a temperature of 40°C (104°F). Roller and handling damage can occur by using automatic plant at lower temperatures. When using manual spray application avoid dry spray and over-application.

Failure to obtain an even film and coverage of blast profile will result in rapid rash rusting on exposure to weathering.

The drying times quoted are for recommended dry film thickness at stated temperatures and will be extended by over-application.

Thicker films of Interplate 398 will provide longer periods of corrosion resistance, but will compromise welding, cutting and handling properties. In most environments to obtain 3-6 months protection 25 microns (1 mil) is the recommended dry film thickness

Excessive film thickness may lead to splitting of the film when overcoated with high build systems.

Note, this product dries too quickly to enable accurate wet film thickness measurements.

When overcoated with the correct anti-corrosive systems, Interplate 398 is suitable for underwater use and is compatible with cathodic protection systems.

For further information on application, handling and weathering properties, consult International Protective Coatings.

Note: VOC values are typical and are provided for guidance purpose only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

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### SYSTEMS COMPATIBILITY

Interplate 398 can be overcoated with a number of systems suitable for steel protection in a wide range of environments.

The following products can be applied directly to Interplate 398:

Intercure 200	Intergard 475HS
Intercure 420	InterH2O 401
Intercure 422	Interlac 645
Intercure 426	Interlac 665
Intercryl 525	Interprime 466
Intergard 251	Interseal 670HS
Intergard 269	Interzone 505
Intergard 410	Interzone 954

For other suitable topcoats/intermediates consult International Protective Coatings.

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### ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at [www.international-pc.com](http://www.international-pc.com):

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage

Individual copies of these information sections are available upon request.

### SAFETY PRECAUTIONS

This product is intended for use only by professional applicators in industrial situations in accordance with the advice given on this sheet, the Material Safety Data Sheet and the container(s), and should not be used without reference to the Material Safety Data Sheet (MSDS) which International Protective Coatings has provided to its customers.

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.

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.

If in doubt regarding the suitability of use of this product, consult International Protective Coatings for further advice.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 litre	19 litre	20 litre	1 litre	1 litre
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
		23.2 kg		1 kg	
	20 litre				
STORAGE	Shelf Life	6 months minimum at 25°C (77°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.			

### 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](http://www.international-marine.com) or [www.international-pc.com](http://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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