

Interprime 820

Primers

High Performance Epoxy Primer



PRODUCT DESCRIPTION

High performance 2-component epoxy primer containing inert pigments and extenders. Interprime 820 is suitable for use on a variety of substrates above and below water

* Excellent anticorrosive protection

* Easy sanding

PRODUCT INFORMATION

Colour	YPA828-White
Finish	Satin
Specific Gravity	1.54
Volume Solids	47%
Mix Ratio	3:1 by volume
Converter/Curing Agent	YPA824
Typical Shelf Life	2 yrs
VOC (As Supplied)	420 g/t
Unit Size	4 Lt 20 Lt

DRYING/OVERCOATING INFORMATION

	Drying			
	10°C (50°F)	15°C (59°F)	23°C (73°F)	35°C (95°F)
Touch Dry	12 hrs	9 hrs	6 hrs	5 hrs
Pot Life	12 hrs	6 hrs	4 hrs	3 hrs

Overcoated By	Overcoating Substrate Temperature							
	10°C (50°F)		15°C (59°F)		23°C (73°F)		35°C (95°F)	
	Min	Max	Min	Max	Min	Max	Min	Max
Epiglass HT9000 Standard	48 hrs	3 mths	36 hrs	3 mths	24 hrs	3 mths	24 hrs	3 mths
Interfill 830	48 hrs	3 mths	36 hrs	3 mths	24 hrs	3 mths	24 hrs	3 mths
Interfill 833	48 hrs	3 mths	36 hrs	3 mths	24 hrs	3 mths	24 hrs	3 mths
Interfill 835	48 hrs	3 mths	36 hrs	3 mths	24 hrs	3 mths	24 hrs	3 mths
Intergard 216	48 hrs	3 mths	36 hrs	3 mths	24 hrs	3 mths	24 hrs	3 mths
Intergard 263	48 hrs	3 mths	36 hrs	3 mths	24 hrs	3 mths	24 hrs	3 mths
Interprime 820	36 hrs	6 mths	16 hrs	6 mths	8 hrs	6 mths	6 hrs	3 mths
Interprotect	36 hrs	6 mths	16 hrs	6 mths	8 hrs	6 mths	6 hrs	3 mths
Interprotect (Professional)	36 hrs	6 mths	16 hrs	6 mths	8 hrs	6 mths	6 hrs	3 mths
Microsurfacers	48 hrs	3 mths	36 hrs	3 mths	24 hrs	3 mths	24 hrs	3 mths
Perfection Undercoat	36 hrs	6 days	16 hrs	5 days	12 hrs	3 days	6 hrs	2 days
YRA600 Undercoat	36 hrs	6 days	16 hrs	5 days	12 hrs	3 days	6 hrs	2 days

APPLICATION AND USE

Preparation

STEEL Thoroughly degrease with a suitable thinner/cleaner using the 2 cloth method prior to carrying out any mechanical cleaning. Blast damaged or corroded areas to near white metal surface as per AS1627.4 Class 2.5. If blasting is not possible, grind with 24-36 grade (grit) discs to a uniform, clean, bright metal surface with a 50-75 microns anchor pattern. Thin the first coat of primer 15% with suitable thinner.

ALUMINIUM Thoroughly degrease with a suitable thinner/cleaner using the 2 cloth method prior to carrying out any mechanical cleaning. Low pressure grit blast using aluminium oxide or a copper-free equivalent. If blasting is not possible, power disc with 24-36 grade discs to a surface profile of 50-75 micron/ 2-3 mils. (NB Power wire brushing is not permitted as it is ineffective and wires are often steel, leading to corrosion). Thin the first coat of primer 15% with suitable thinner.

STAINLESS STEEL Thoroughly degrease with a suitable thinner/cleaner using the 2 cloth method prior to carrying out any mechanical cleaning. Grit blast to produce a profile of 50 microns. Thin the first coat of primer 15% with suitable thinner.

EPOXY PRIMERS Sweep blast or abrade with 280 grade paper.

EPOXY FILLERS Sand with 60-120 grade (grit) paper. Do not wipe down any epoxy fillers with solvent.

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BARE GRP/COMPOSITE Ensure all waxes and uncured resins are removed. Sand with 80-180 grade (grit) paper.
GELCOATS Sand to remove oxidation and gloss, avoiding cutting too deep into the surface which may result in small air bubbles being exposed which will then require filling.

LEAD Thoroughly degrease with a suitable thinner/cleaner using the 2 cloth method. Rub down with an emery cloth or power wire brush. Rub down with an emery cloth or power wire brush. Thin the first coat of primer 15% with suitable thinner.

BARE WOOD Sand with 80-280 grade paper. Remove oil from oily woods eg teak, using Universal Thinners #4. Change rags frequently. Everdure may be used to seal any timbers if required. Thin the first coat of primer 15% with suitable thinner.

For further information refer to International Professional Application Manual or the International Boat Painting and Product Guide.

Method

Remove blast/grinding/sanding residues with a clean air line & sweep with a clean brush, or vacuum clean for best results. On blasted and rough ground surfaces do not try and wipe with rags and thinners as the rags will catch and leave particles of cloth behind. Apply required number of coats, detailed in the specification sheets, by spray, allowing required overcoating interval between applications. Thin first coat applications as detailed above.

Hints

Mixing Mix base and curing agent thoroughly at the specified ratio.

Thinner YTA061 International Epoxy Thinners #7.

Cleaner YTA061 International Epoxy Thinners #7.

Airless Spray Pressure: 175 bar. Tip Size: 1560-2180.

Conventional Spray For conventional spray, thin up to 20% with YTA061. Do not excessively thin for high build coats. Pressure: <1 bar (Pot)/3-4 bar (Atomising). Tip Size: 1.8 mm.

Brush Use brush application for touch-ups

Other Do not apply at a thickness greater than recommended, as this may lead to solvent entrapment within the coating. As a guide, fillers should be allowed to cure to a 'Shore D' hardness of 50 before overcoating.

Some Important Points

Do not use below 10°C/50°F. Do not use unless mixed thoroughly with the curing agent at specified ratio. Do not apply when there is a chance of condensation forming on the substrate. Do not apply thicker coats than indicated as this may lead to cracking and solvent entrapment within the coating. Ambient temperature should be minimum 10°C and maximum 35°C. Product temperature should be minimum 10°C and maximum 35°C. Substrate temperature should be minimum 10°C and maximum 35°C.

Compatibility/Substrates

If applying direct to metal substrates Interprime 820 should be thinned 15% with YTA061 and applied at 125 microns WFT. For airless application at this film thickness, smaller tip sizes may be appropriate (1560-1880).

Coverage

(Theoretical) - 3.64 m²/L per coat Practical Coverage = 2.8 m²/lt, spray.

Recommended DFT per coat

125 microns dry

Recommended WFT per coat

266 microns wet

Application Methods

Airless Spray, Brush, Conventional Spray, Airmix, Roller

TRANSPORTATION, STORAGE AND SAFETY INFORMATION

Storage

GENERAL INFORMATION:

Exposure to air and extremes of temperature should be avoided. For the full shelf life of Interprime 820 to be realised ensure that between use the container is firmly closed and the temperature is between 5°C/41°F and 35°C/95°F. Keep out of direct sunlight.

TRANSPORTATION:

Interprime 820 should be kept in securely closed containers during transport and storage.

Safety

GENERAL:

Read the label safety section for Health and Safety Information, also available from our Technical Help Line.

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.

Remainders of Interprime 820 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.

IMPORTANT NOTES

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 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.

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