

Interplate 408

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Product Description

A two component iron oxide epoxy shop primer.
 Approved for welding by Industrial Health Authorities.
 Approved for welding by Lloyds Register and Det Norske Veritas.

Intended Uses

As a shop primer for the protection of steel during fabrication and assembly.
 Weathering protection up to 6 months.
 Compatible with most overcoating systems.

Practical Information for Interplate 408

Colour	Pink and Red			
Gloss Level	Matt			
Volume Solids	24%			
Typical Thickness	25 microns (1.0 mils) dry equivalent to 104 microns (4.2 mils) wet			
Theoretical Coverage	9.6 m ² /litre at 25 microns d.f.t and stated volume solids 385 sq.ft/US gallon at 1 mils d.f.t and stated volume solids			
Practical Coverage	Allow appropriate loss factors			
Method of Application	Automatic airless spray, Air spray			
Drying Time				
			Overcoating Interval with recommended topcoats	
Temperature	Touch Dry	Hard Dry	<i>Minimum</i>	<i>Maximum</i>
10°C (50°F)	5-6 minutes	8-10 minutes	12 hours	Extended*
15°C (59°F)	4-5 minutes	5-8 minutes	12 hours	Extended*
25°C (77°F)	3-4 minutes	4-5 minutes	6 hours	Extended*
40°C (104°F)	2-3 minutes	3-4 minutes	4 hours	Extended*

* See International Protective Coatings Definitions & Abbreviations

Regulatory Data

Flash Point	Base (Part A) -17°C (1°F)	C/A (Part B) 2°C (36°F)	Mixed -17°C (1°F)
Product Weight	1.1 g/l (9.2 lb/gal)		
VOC	680 g/l	UK - PG6/23(92), Appendix 3	
	5.65 lb/gal (677 g/l)	USA - EPA Method 24	

Interplate 408

E p o x y

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 8504:1992.

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

Abrasive Blast Cleaning

Abrasive blast clean to Sa2½ (ISO 8501-1:1988) or SSPC-SP6. If oxidation has occurred between blasting and application of Interplate 408, 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.

A surface profile of 35-50 microns (1.5-2.0 mils) is recommended with preferably a rounded shape. Blasting with angular shaped abrasive may produce excessive peaks in the profile which may protrude through the primer allowing for corrosion.

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 a power agitator. (2) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.			
Mix Ratio	3 parts : 1 part by volume			
Working Pot Life	10°C (50°F) 16 hours	15°C (59°F) 16 hours	25°C (77°F) 16 hours	40°C (104°F) 16 hours
Airless Spray	Recommended	- Tip range 0.38 - 0.53 mm (15-21 thou) - Total output fluid pressure at spray tip not less than 88 kg/cm ² (1250 p.s.i.)		
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E	
Air Spray (Conventional)	Recommended	Use suitable proprietary equipment.		
Brush	Not Recommended			
Roller	Not Recommended			
Thinner	International GTA803 Do not thin more than allowed by local environmental legislation.			
Cleaner	International GTA803			
Work Stoppages	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.			
Clean Up	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.			

Interplate 408

E p o x y

Product Characteristics

This product is designed for use in an automatic plant. It can be applied by manual spray but this is not recommended for complex structures.

Dry film thicknesses above 30 microns (1.1 mils) and below 20 microns (0.8 mils) may adversely affect appearance and performance.

Above 30 microns (1.1 mils) DFT will increase level of weld fume and weld porosity.

Drying times will depend on the substrate temperature and ventilation.

Shop primers are not recommended for use as touch-up primers after fabrication.

This product has the following specification approvals:-

Approved for Welding by Industrial Health Authorities

Approved for Welding by Lloyds Register and Det Norske Veritas

Systems Compatibility

The following topcoats are recommended for Interplate 408:

Intergard 251
Intergard 269
Intergard 400
Intergard 410
Interprime 198
Intertuf 564

For other suitable primers/topcoats, please consult International Protective Coatings.

Interplate 408

E p o x y

Additional Information

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following sections of the International Protective Coatings data manual:

- 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	5 litre unit	Interplate 408 Base	3.75 litres in a 5 litre container
		Interplate 408 Curing Agent	1.25 litres in a 2.5 litre container
	20 litre unit	Interplate 408 Base	15 litres in a 20 litre container
		Interplate 408 Curing Agent	5 litres in a 5 litre container
For availability of other pack sizes contact International Protective Coatings			
Shipping Weight	U.N. Shipping No. 1263		
	5 litre unit	4.9 kg (10.9lbs) Base (Part A)	1.5kg (3.2lbs) Curing Agent (Part B)
	20 litre unit	19.6kg (43.1lbs) Base (Part A)	4.8kg (10.5lbs) Curing Agent (Part B)
Storage	Shelf Life		
	12 months minimum at 25°C (77°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.		

Disclaimer

The information given in this sheet is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. Any warranty, if given, or specific Terms & Conditions of Sale are contained in International's Terms & Conditions of Sale, a copy of which can be obtained on request. Whilst we endeavour to ensure that all advice we give about the product (whether in this sheet or otherwise) is correct we have no control over either the quality or 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 whatsoever or howsoever arising for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of the use of the product. 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.

It is the user's responsibility to check that this sheet is current prior to using the product. Issue date: 1st June 1997

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