

Epoxy

PRODUCT DESCRIPTION

A two component, high solids, low VOC epoxy micaceous iron oxide intermediate coating offering excellent barrier protection, low temperature cure and rapid overcoating properties.

Pigmented with micaceous iron oxide to comply with the requirements of BS5493:1977

INTENDED USES

As a high build intermediate to provide excellent barrier protection as part of a high performance system in aggressive environments including offshore structures, bridges, chemical and petrochemical plants and power stations.

The incorporation of plate-like micaceous iron oxide pigment both increases the barrier effect and improves long term overcoating properties of the system making this material ideally suitable for application in the fabrication shop, prior to shipping, with final overcoating at site.

The rapid curing and overcoating properties of Intercure 384 provide production flexibility, making this product suitable for use both in new construction and on site as a maintenance coating.

PRACTICAL INFORMATION FOR INTERCURE 384

Colour	Silver Grey MIO
Gloss Level	Matt
Volume Solids	72%
Typical Thickness	125-175 microns (5-7 mils) dry equivalent to 174-243 microns (7-9.7 mils) wet
Theoretical Coverage	5.80 m ² /litre at 125 microns d.f.t and stated volume solids 231 sq.ft/US gallon at 5 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Air Spray, Brush, Roller

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
5°C (41°F)	4 hours	14 hours	7 hours	Extended ¹
15°C (59°F)	2.5 hours	8 hours	4 hours	Extended ¹
25°C (77°F)	2.5 hours	3.5 hours	3.5 hours	Extended ¹
40°C (104°F)	45 minutes	1.5 hours	1 hour	Extended ¹

¹ See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical) Part A 37°C (99°F); Part B 27°C (81°F); Mixed 33°C (91°F)

Product Weight 1.79 kg/l (14.9 lb/gal)

VOC 169 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.

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 Intercure 384, 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.

Shop Primed Steel

Weld seams and damaged areas should be blast cleaned to Sa2½ (ISO 8501-1:2007) or SSPC-SP6.

If the shop primer shows extensive or widely scattered breakdown overall sweep blasting may be necessary.

Metallic Zinc Primed Surfaces

Ensure that the surface of the primer is clean, dry and free from contamination and zinc salts before application of Intercure 384. Ensure zinc primers are fully cured before overcoating.

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	3.00 part(s) : 1.00 part(s) by volume		
Working Pot Life	5°C (41°F) 90 minutes	15°C (59°F) 90 minutes	25°C (77°F) 40°C (104°F) 60 minutes 30 minutes
Airless Spray	Recommended	Tip Range 0.38-0.58 mm (15-23 thou) Total output fluid pressure at spray tip not less than 176 kg/cm ² (2503 p.s.i.)	
Air Spray (Pressure Pot)	Recommended (5% thinning required)	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E
Brush	Suitable - small areas only	Typically 75 microns (3.0 mils) can be achieved	
Roller	Suitable - small areas only	Typically 75 microns (3.0 mils) can be achieved	
Thinner	International GTA220	Do not thin more than allowed by local environmental legislation	
Cleaner	International GTA822		
Work Stoppages	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 Up	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.		
	All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.		

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PRODUCT CHARACTERISTICS

Intercure 384 is capable of curing at temperatures below 0°C (32°F). However, this product should not be applied at temperatures below 0°C (32°F) where there is a possibility of ice formation on the substrate.

This product must only be thinned using recommended International GTA220 thinners. The use of alternative thinners, particularly those containing ketones, can severely inhibit the curing mechanism of the coating.

Surface temperature must always be a minimum of 3°C (5°F) above dew point.

Over-application of Intercure 384 will extend both the minimum overcoating periods and handling times, and may be detrimental to long term overcoating properties.

Absolute measured adhesion of topcoats to aged Intercure 384 is less than that to fresh material, however, it is adequate for the specified end use.

This product is frequently used as a 'travel coat' prior to final overcoating on site. To ensure best extended overcoating properties ensure over-application does not occur and that the surface is fully cleaned of any contamination which may be present in the surface texture due to the coarse nature of the micaceous iron oxide pigmentation.

In common with all epoxies Intercure 384 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

As with all products with high micaceous iron oxide levels, only relatively dark colours can be formulated, consequently with some colours of thin film finishes two coats may be needed to give good coverage.

Intercure 384 is not designed for continuous water immersion.

This product has the following specification approvals:

- BS5493:1977 KUID & KF1F
- UK Department of Transport Item No.112

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.

SYSTEMS COMPATIBILITY

Please consult International Protective Coatings for specific information regarding application to prefabrication primers.

The following primers are recommended for Intercure 384:

Intercure 200HS	Interzinc 12 - mist coat may be required
Intercure 324	Interzinc 22 - mist coat may be required
Intercure 202	Interzinc 42
Intergard 251	Interzinc 52
Intergard 269	Interzinc 135
	Interzinc 315

The following topcoats are recommended for Intercure 384:

Interfine 629HS
Intergard 740
Interthane 990

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:

- 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	15 litre	20 litre	5 litre	5 litre
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
		kg		kg	
	20 litre	32.8		5.36	
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.			

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.

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