

Ultra High Build Epoxy

PRODUCT DESCRIPTION

A two component, high build, high solids low VOC polyamide cured epoxy.

INTENDED USES

To provide long term protection to steel structures exposed to aggressive environments. The high build nature allows for a reduced number of coats, offering cost savings.

Overcoatable with a wide range of epoxy and polyurethane coatings.

PRACTICAL INFORMATION FOR INTERSEAL 211HS

Colour	Wide range
Gloss Level	Semi-gloss
Volume Solids	80% ± 2%
Typical Thickness	100-200 microns (4-8 mils) dry equivalent to 125-250 microns (5-10 mils) wet
Theoretical Coverage	5.33 m ² /litre at 150 microns d.f.t and stated volume solids 214 sq.ft/US gallon at 6 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Conventional Spray, Brush, Roller.

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
10°C (50°F)	4 hours	12 hours	24 hours	6 months
15°C (59°F)	2 hours	9 hours	16 hours	6 months
25°C (77°F)	60 minutes	6 hours	12 hours	6 months
40°C (104°F)	30 minutes	4 hours	8 hours	6 months

REGULATORY DATA

Flash Point (Typical)	Part A 23°C (73°F); Part B 23°C (73°F); Mixed 23°C (73°F)		
Product Weight	1.5 kg/l (12.5 lb/gal)		
VOC	1.50 lb/gal (180 g/l)	EPA Method 24	

See Product Characteristics section for further details

Protective Coatings

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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 clean to a minimum of Sa2½ (ISO 8501-1:2007) SSPC-SP6. If oxidation has occurred between blasting and application of Interseal 211HS the surface should be re-blasted to the specified visual standard. Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner.

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.			
	<ol style="list-style-type: none"> (1) Agitate Base (Part A) with a power agitator. (2) Agitate Curing Agent (Part B) with a power agitator. (3) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator. 			
Mix Ratio	6 part(s) : 1 part(s) by volume			
Working Pot Life	10°C (50°F) 10 hours	15°C (59°F) 8 hours	25°C (77°F) 6 hours	40°C (104°F) 4 hours
Airless Spray	Recommended	Tip Range 0.52-0.65 mm (20-26 thou) Total output fluid pressure at spray tip not less than 197 kg/cm ² (2801 p.s.i.)		
Air Spray (Conventional)	Suitable	Use suitable proprietary equipment		
Brush	Suitable - small areas only			
Roller	Suitable - small areas only			
Thinner	Not recommended	Use International Solvent GTA220 only in exceptional circumstances up to 5%. DO NOT dilute more than allowed by local 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 clean equipment during the course of the working day. Frequency of cleaning will depend upon amount used, 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

Interseal 211HS is preferred for use with systems for chemical environments where zinc based materials can be subject to attack in both acidic and alkaline conditions.

Over-application should be avoided as thick films will not be as good a substrate for topcoat adhesion after ageing as those at the specified thickness.

Over-application of Interseal 211HS will extend both the minimum overcoating periods and handling times, and may be detrimental to long term overcoating properties.

For optimum application and drying characteristics, the air and substrate temperature should be greater than 10°C (50°F) and relative humidity less than 85%. Good air flow and ventilation should be maintained to improve drying and recoat properties and speed up the application. Application at temperatures below 10°C (50°F) will retard drying and extend overcoatings intervals, as will higher humidities.

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

In common with all epoxy coatings Interseal 211HS may chalk or discolour on exterior exposure. Rate of chalking will depend upon climatic conditions, will have no adverse effect upon anti-corrosive property and will be limited to a thin surface layer. Where a durable cosmetic finish with good gloss and colour retention is required overcoat with recommended topcoats.

Interseal 211HS is not designed for continuous water immersion.

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.

Low molecular weight reactive additives, which will form part of the film during normal ambient cure conditions, will also affect VOC values determined using EPA Method 24.

SYSTEMS COMPATIBILITY

Where a cosmetically acceptable topcoat is required the following products are recommended:

Interthane 441	Interthane 582
Interthane 870	Interthane 990

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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
	3.6 litre	3.09 litre	3.6 litre	0.51 litre	0.9 litre
	20 litre	17.14 litre	20 litre	2.86 litre	3.6 litre

For availability of other pack sizes, contact International Protective Coatings.

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
	20 litre	29.54 kg	3.01 kg
	3.6 litre	5.42 kg	0.59 kg

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.
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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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