

Interseal® 670

Surface Tolerant Epoxy

Product Description A two component corrosion inhibitive surface tolerant epoxy. Provides surface tolerant application and high build formulation. Can be utilized with alternate converter for low temperature or fast recoat applications. Low VOC.

Intended Uses A corrosion resistant primer for structural steel and processing vessel exteriors. Excellent water resistance. Exhibits excellent performance in industrial and marine environments subject to acids, alkalis, solvents, salts and other aggressive exposure.

Practical Information for Interseal 670

Color Red, Buff, Black and special colors not suitable for immersion service can be matched to meet customer specifications.

Gloss Level Eggshell

Volume Solids 72%

Typical Thickness 4.0-6.0 mils (100-150 microns) dry equivalent to 5.6-8.3 mils (139-208 microns) wet

Theoretical Coverage 231 sq.ft./US gallon at 5 mils d.f.t. and stated volume solids
5.8 m²/liter at 125 microns 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			
			Self		Interthane 990	
			Minimum	Maximum	Minimum	Maximum
50°F (10°C)	12 hours	28 hours	16 hours	3 months	16 hours	7 days
59°F (15°C)	10 hours	24 hours	12 hours	2 months	12 hours	5 days
77°F (25°C)	6 hours	18 hours	6 hours	2 months	6 hours	3 days
90°F (32°C)	3 hours	10 hours	4 hours	1 month	4 hours	2 days

* For curing at low temperatures, an alternate curing agent is available. See Product Characteristics for details.

Regulatory Data

Flash Point Base (Part A) 107°F (41°C) C/A (Part B) 103°F (39°C) Mixed 100°F (38°C)

Product Weight 11.85 lb/gal (1.42 kg/l)

VOC  2.67 lb/gal (320 g/l) as supplied (EPA Method 24). Maximum thinning for VOC compliance is color specific. Contact your International Representative for thinning and VOC information.

Ecotech is an initiative by International Protective Coatings, a world leader in coating technology, to promote the use of environmentally sensitive products across the globe.

Interseal® 670

Surface Tolerant Epoxy

Surface Preparation

The performance of this product will depend upon the degree of surface preparation. The surface 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.

Accumulated dirt and soluble salts must be removed. Dry bristle brushing will normally be adequate for accumulated dirt. Soluble salts should be removed by fresh water washing.

Abrasive Blast Cleaning

For immersion service, Interseal 670 must be applied to surfaces blast cleaned to SSPC-SP10 or Sa2½ (ISO 8501-1:1988). However, for atmospheric exposure best performance will be achieved when Interseal 670 is applied to surfaces prepared to a minimum of SSPC-SP6 or Sa2½ (ISO 8501-1:1988).

Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner.

A surface profile of 2-3 mils (50-75 microns) is recommended.

Hand or Power Tool Preparation

Hand or power tool clean to a minimum SSPC-SP2 or St2 (ISO 8501-1:1988).

Note: All scale must be removed and areas which cannot be prepared adequately by chipping or needle gun should be spot blasted to a minimum standard of SSPC-SP6 or Sa2 (ISO 8501-1:1988). Typically this would apply to C or D grade rusting in this standard.

Ultra High Pressure Hydroblasting/Abrasive Wet Blasting

May be applied to surfaces prepared to SSPC-SP6 or Sa2½ (ISO 8501-1:1988) which have flash rusted to no worse than Grade HB2½M (refer to International Hydroblasting Standards). It is also possible to apply to damp surfaces in some circumstances. Further information is available from International Protective Coatings.

Aged Coatings

Interseal 670 is suitable for overcoating a limited range of intact, tightly adherent aged coatings. Loose or flaking coatings should be removed back to a firm edge. Glossy finishes may require light abrasion to provide a physical 'key'. See Product Characteristics section for further information.

Interseal 670 is suitable for application to steelwork freshly coated with zinc silicate shop primers. If the zinc shop primer shows extensive or widely scattered breakdown, or excessive zinc corrosion products, overall sweep blasting will be necessary. Other types of shop primer are not suitable for overcoating and will require complete removal by abrasive blast cleaning.

Weld seams and damaged areas should be blast cleaned to Sa2½ (ISO 8501-1:1988) SSPC SP6.

In the case of zinc primers, where necessary remove weld spatter, smooth weld seams and sharp edges and blast clean welds and damaged primer to Sa2½ (ISO 8501-1:1988) SSPC-SP6. The shop primer or other primer surface should be dry and free of all contamination (oil, grease, salt etc) and overcoated with Interseal 670 within the overcoating intervals specified for the primer (consult the relevant data sheet).

Ensure zinc primer has fully cured and is clean, dry and free from zinc salts prior to 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	4 parts : 1 part by volume			
Working Pot Life	50°F (10°C) 12 hours	59°F (15°C) 10 hours	77°F (25°C) 8 hours	90°F (32°C) 5 hour
Airless Spray	Recommended	- Tip range 19-23 thou (0.48-0.58 mm) - Total output fluid pressure at spray tip not less than 2,500 p.s.i. (176 kg/cm ²)		
Air Spray (Pressure Pot)	Recommended	Gun	DeVilbiss MBC or JGA	
		Air Cap	704	
		Fluid Tip	E	
Brush	Recommended	Typically 3-4 mils (75-100 microns) can be achieved		
Roller	Recommended	Typically 3-4 mils (75-100 microns) can be achieved		
Thinner	International GTA415	Do not thin more than allowed by local environmental legislation.		
Cleaner	International GTA415 (or GTA822)			
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA415. Once units of paint have been mixed they should not be resealed. It is advised that after prolonged stoppages work recommences with freshly mixed units.			
Clean Up	Clean all equipment immediately after use with International GTA415. 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.			

Interseal® 670

Surface Tolerant Epoxy

Product Characteristics

When applying Interseal 670 by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

Maximum film build in one coat is best attained by airless spray. When applying by methods other than airless spray, the required film build is unlikely to be achieved. Application by conventional air spray may require a multiple cross spray pattern to attain maximum film build. Lower or high temperatures may require specific application techniques to achieve maximum film build.

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

If applying Interseal 670 in enclosed maintenance conditions ensure adequate ventilation.

In common with all epoxies Interseal 670 will chalk and discolor on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

USDA Accepted for incidental food contact surfaces in federally inspected meat and poultry plants. Subject to Inspector-in-charge approval.

Low Temperature Properties

When low temperature cure is required, use KHA 414 Low Temperature Converter. Follow dry time and recoat parameters shown below.

Pot Life	20°F (-7°C)	41°F (5°C)	77°F (25°C)
	12 hours	8 hours	4 hours

Overcoating Interval with Epoxy Urethane Finishes

Temperature	Touch Dry	Hard Dry	Minimum	Maximum	Minimum	Maximum
20°F (-7°C)	24 Hours	96 Hours	58 Hours	3 Months	58 Hours	---
41°F (5°C)	10 Hours	16 Hours	12 Hours	2 Months	12 Hours	7 Days
77°F (25°C)	2 Hours	8 Hours	6 Hours	1 Month	6 Hours	5 Days

Systems Compatibility

Interseal 670 will normally be applied to correctly prepared steel substrates. However, it can be used over suitably primed surfaces. Suitable primers are:

Intercure 200 Interplus 356
Intergard 269 Interzinc 315
Interplus 256

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

Intercryl 530 Interplus 880
Interfine 629 HS Interthane 990
Intergard 740

Other suitable primers/topcoats are available. Consult International Protective Coatings.

Interseal® 670

Surface Tolerant Epoxy

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 gallon unit	Interseal 670 Base	4 gallons in 5 gallon container
		Interseal 670 Curing Agent	1 gallons in 1 gallon container

For availability of other pack sizes contact International Protective Coatings

Shipping Weight	U.N. Shipping No. 1263
	5 gallon unit 57.0 lb (25.9 kg) Base (Part A) 8.3 lb (3.8 kg) Curing Agent (Part B)

Storage	Shelf Life	24 months minimum at 77°F (25°C). 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. While we endeavor 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 August 1997

Copyright © International Paint Ltd. * and International are trademarks.

International Protective Coatings

World Centre	Asia Region	Australasia Region	Europe Region	Middle East Region	North America Region	South America Region
50 George Street London W1A 2BB England	3 Neythal Road Jurong Town Singapore 628570	115 Hyde Road Yeronga Brisbane Queensland Australia	50 George Street London W1A 2BB England	PO Box 37 Dammam 31411 Saudi Arabia	6001 Antoine Drive Houston Texas 77091	Rua Gomes de Carvalho, 1356, 15° Andar, Vila Olimpia, São Paulo, S.P. CEP: 04547-005 Brazil

Tel: (44) 171 612 1400 Fax: (44) 171 612 1561	Tel: (65) 663 3066 Fax: (65) 266 5287	Tel: (61) 7 3892 8866 Fax: (61) 7 3892 4287 H&S (61) 1800 807 001	Tel: (44) 171 612 1410 Fax: (44) 171 612 1555	Tel: (966) 3 842 8436 Fax: (966) 3 842 4361	Tel: (1) 713 682 1711 Fax: (1) 713 684 1327	Tel: (011) 3044 0344 Fax: (011) 3044 0322
--	--	---	--	--	--	--

USA Toll Free Number (800) 589 1267
www.international-pc.com