

Intercure 200

Rapid Recoat Epoxy

PRODUCT DESCRIPTION

A two component epoxy zinc phosphate/micaceous iron oxide primer, formulated on proprietary polymer technology, which provides rapid cure and overcoating even under low temperature conditions.

A high solids, low VOC product.

INTENDED USES

As a primer for steelwork intended for use in a wide range of aggressive environments, including offshore, chemical and petrochemical plants, industrial buildings, pulp and paper mills, power plants and bridges.

Suitable for overcoating within 3 hours in most climatic conditions hence speeding up production and throughput in fabrication shops.

Can also be used on site as a rapid curing, maintenance coating.

PRACTICAL INFORMATION FOR INTERCURE 200

| | |
|------------------------------|---|
| Colour | Buff, Red Oxide |
| Gloss Level | Matt |
| Volume Solids | 67% |
| Typical Thickness | 75-100 microns (3-4 mils) dry equivalent to 112-149 microns (4.5-6 mils) wet |
| Theoretical Coverage | 8.90 m ² /litre at 75 microns d.f.t and stated volume solids 358 sq.ft/US gallon at 3 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) | 40 minutes | 4.5 hours | 3 hours | Extended ¹ |
| 15°C (59°F) | 30 minutes | 3 hours | 2 hours | Extended ¹ |
| 25°C (77°F) | 20 minutes | 2 hours | 1 hours | Extended ¹ |
| 40°C (104°F) | 15 minutes | 30 minutes | 30 minutes | Extended ¹ |

¹ See International Protective Coatings Definitions and Abbreviations

Maximum overcoating intervals are shorter when using polysiloxane topcoats. Consult International Protective Coatings for further details.

REGULATORY DATA

| | | | |
|-----------------------|------------------------------|--|----------------------|
| Flash Point | Base (Part A) 27°C (81°F) | C/A (Part B) 28°C (82°F) | Mixed 27°C (81°F) |
| Product Weight | 1.6 kg/l (13.4 lb/gal) | | |
| VOC | 320 g/l (2.67 lb/gal) | UK - PG6/23(04), Appendix 3 | |
| | 2.67 lb/gal (320 g/l) | USA - EPA Method 24 | |
| | 339 g/l, 212 g/kg | EU Solvent Emissions Directive (Council Directive 1999/13/EC) | |

See Product Characteristics section for further details



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.

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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 Grit Blast Cleaning

Abrasive grit blast clean to Sa2½ (ISO 8501-1:1988) or SSPC-SP6. If oxidation has occurred between blasting and application of Intercure 200, 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 sharp, angular surface profile of 50-75 microns (2-3 mils) is recommended.

Intercure 200 is suitable for application to grit blast cleaned surfaces which were initially to the above standard but have been allowed to deteriorate under good shop conditions for up to 7-10 days. The surface may deteriorate to Sa2 standard but must be free from loose powdery deposits.

Shop Primed Steel

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

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

If the shop primer was applied over shot blasted surfaces, overall grit sweep blasting will be necessary prior to application of Intercure 200.

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 part(s) : 1 part(s) by volume | | | |
| Working Pot Life | 5°C (41°F) | 15°C (59°F) | 25°C (77°F) | 40°C (104°F) |
| | 6 hours | 3 hours | 2 hours | 45 minutes |
| Airless Spray | Recommended | Tip Range 0.43-0.53 mm (17-21 thou) Total output fluid pressure at spray tip not less than 176 kg/cm ² (2503 p.s.i.) | | |
| Air Spray (Pressure Pot) | Recommended | Gun | DeVilbiss MBC or JGA | |
| | | Air Cap | 704 or 765 | |
| | | Fluid Tip | E | |
| Brush | Suitable - small areas only | Typically 50-75 microns (2.0-3.0 mils) can be achieved | | |
| Roller | Suitable - small areas only | Typically 50-75 microns (2.0-3.0 mils) can be achieved | | |
| Thinner | International GTA220 (or International GTA415) | Do not thin more than allowed by local environmental legislation | | |
| Cleaner | International GTA220 | (or International GTA415) | | |
| Work Stoppages | Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA220. 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 GTA220. 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 200 is preferred for use with systems for chemical environments where zinc based materials can be subject to attack in both acidic and alkaline conditions.

The maximum overcoating interval will be dependent upon the integrity of the exposed film. A film of 75 microns (3 mils) dry film thickness will normally be overcoatable after 6 months exposure provided it is adequately cleaned and any areas of mechanical damage repaired.

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. When using as a blast holding primer avoid over-application as thick films may suffer from cohesive film splitting if subsequent coats are also over-applied.

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

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

Low Temperature Curing

Intercure 200 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.

For further details regarding cure times and overcoatability, please contact International Protective Coatings.

This product is not available in pale and pastel shades due to a tendency to discolour rapidly. Additionally, in common with all epoxies Intercure 200 will chalk on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

Intercure 200 is not intended for use as a primer for steelwork which may be subjected to immersion conditions.

Intercure 200 can also be used as a primer for substrates other than blasted steel, e.g. stainless steel, alloys, etc. Consult International Protective Coatings for further details.

Absolute measured adhesion of topcoats to aged Intercure 200 is less than that to fresh material, however, it is adequate for the specified end use.

Note: VOC values quoted are based on maximum possible for the product taking into account variations due to colour differences 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

Intercure 200 will normally be applied to suitably prepared steel, e.g. blast cleaned. However, if necessary, application over prefabrication blast primers can be performed. Consult International Protective Coatings for further details.

The following primers are recommended for Intercure 200:

Interzinc 22 (mist coat or tie coat may be required)*

The following topcoats/intermediates are recommended for Intercure 200:

Intercure 420
Interfine 979
Intergard 475HS
Intergard 740
Interseal 670HS
Interthane 990
Interzone 1000
Interzone 954

For other suitable topcoats/intermediates, consult International Protective Coatings.

*See relevant product data sheet for details.

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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 | 20 Litre unit | Intercure 200 Base | 15 litres in a 20 litre container |
| | | Intercure 200 Curing Agent | 5 litres in a 5 litre container |
| | 4 Gallon unit | Intercure 200 Base | 3 gallons in a 5 gallon container |
| | | Intercure 200 Curing Agent | 1 gallon in a 1 gallon container |

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

| | | |
|------------------------|------------------------|---|
| SHIPPING WEIGHT | U.N. Shipping No. 1263 | |
| | 20 Litre unit | 29.1 kg (64.1 lb) Base (Part A) 5.3 kg (11.7 lb) Curing Agent (Part B) |
| | 4 Gallon unit | 22.6 kg (49.8 lb) Base (Part A) 4 kg (8.8 lb) Curing Agent (Part B) |


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|----------------|------------|--|
| 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 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: 11/12/2006

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