Interseal® 1509

Epoxy

PRODUCT DESCRIPTION

A two component, low VOC, high build, high solids, fast curing epoxy primer/finish, with excellent edge retention properties. Contains zinc phosphate anti-corrosive pigmentation.

INTENDED USES

Interseal 1509 has been designed for use as a single coat system to afford anti-corrosive protection for structural steelwork exposed to the environment where cosmetic appearance is important, e.g. in dry internal areas or low corrosivity external environments.

It is particularly suited for use as a rapid drying versatile primer/finish designed to maximise the steel throughput in fabrication yards.

PRACTICAL INFORMATION FOR INTERSEAL 1509

Colour	Limited range
Gloss Level	Semi-gloss
Volume Solids	80%-± 3%
Typical Thickness	100-300 microns (4-12 mils) dry equivalent to 125-375 microns (5-15 mils) wet
Theoretical Coverage	5.30 m²/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,Air spray, Brush, Roller

Drying Time

			Overcoating Interval with recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
10°C (50°F)	60 minutes	5 hours	5 hours	3 months
15°C (59°F)	35 minutes	3 hours	3 hours	3 months
25°C (77°F)	20 minutes	2 hours	2 hours	3 months
40°C (104°F)	10 minutes	60 minutes	60 minutes	3 months

REGULATORY DATA

Flash Point (Typical)	Part A 24°C (75°F); Part B 33°C (91°F); Mixed 27°C (81°F)
Product Weight	1.64 kg/l (13.7 lb/gal)
VOC	1.84 lb/gal (221 g/lt) EPA Method 24

See Product Characteristics section for further details

Epoxy

SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. Prior to 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.

Steel

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of Interseal 1509, 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 50-75 microns (2-3 mils) is recommended.

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

1 part(s) : 1 part(s) by volume

Working Pot Life

10°C (50°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
4 hours	3 hours	2 hours	60 minutes

Airless Spray	Recommended	Tip Range 0.48-0.53 mm (19-21 thou) Total output fluid pressure at spray tip not less than 209 kg/cm² (2972 p.s.i.)
Air Spray (Conventional)	Recommended	Use suitable proprietary equipment
Brush	Suitable	Small areas only
Roller	Suitable	Small areas only
Thinner	International GTA713	
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.

PRODUCT CHARACTERISTICS

Apply in good climatic conditions. The temperature of the surface to be coated must be at least 3°C (5°F) above the dew point.

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 air spray may require a multiple cross spray pattern to attain maximum film build. Low or high temperatures may require specific application techniques to achieve maximum film build.

When applying Interseal 1509 by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

This product will not cure adequately below 5°C (41°F). For maximum performance ambient curing temperatures should be above 10°C (50°F).

Level of sheen and surface finish are dependent on application method. Avoid using a mixture of application methods whenever possible.

Condensation occurring during or immediately after application may result in a matt finish and an inferior film.

Exposure to dew or rain prior to specified hard dry time may cause a deterioration in surface appearance which may in turn impair overall performance. This phenomenon is particularly prominent in darker shades.

In common with all epoxies Interseal 1509 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance. Where a durable cosmetic finish with good gloss and colour retention is required overcoat with recommended topcoats.

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

Interseal 1509 is normally applied direct to metal.

The following topcoat is recommended for Interseal 1509:

Interthane 990

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
	40 litre	20 litre	20 litre	20 litre	20 litre
	For availability of other pack sizes, contact International Protective Coatings.				
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	40 litre	32.35 kg		35.81 kg	
STORAGE	Shelf Life	12 months at 25°C (77°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.			

Important Note

www.international-pc.com