

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 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, Air spray, Brush, Roller			
Drying Time	Overcoating Interval with recommended topcoats			
Temperature	Touch Dry	Hard Dry	<i>Minimum</i>	<i>Maximum</i>
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/l) EPA Method 24

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 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) 4 hours	15°C (59°F) 3 hours	25°C (77°F) 2 hours	40°C (104°F) 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/cm ² (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.			

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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

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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
	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	
		32.35 kg		35.81 kg	
	40 litre				
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

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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