

PRODUCT DESCRIPTION A high solids, hard wearing, surface tolerant, two pack epoxy primer/finish with good colour retention.

INTENDED USES As an anticorrosive primer/finish for decks, deck fittings, cargo holds, topsides and boottops.
For use at Maintenance & Repair or On Board Maintenance.

PRODUCT INFORMATION	Colour	KQA101-Red, KQA102-Grey, KQA103-Green, KQA109-Black
	Finish/Sheen	Gloss
	Converter/Curing Agent	KQA100
	Volume Solids	80% \pm 2% (ISO 3233:1998)
	Mix Ratio	3.00 volumes Part A to 1 volume Part B
	Typical Film Thickness	4.9 mils dry (6.1 mils wet)
	Theoretical Coverage	261 (ft ² /US Gal) at 125 microns dft, allow appropriate loss factors
	Method of Application	Airless Spray, Brush, Roller
	Flash Point	Part A 82°F ; Part B 79°F ; Mixed 99°F (Product produced and supplied in North America has flash points of Part A 48°C (119°F), Part B 59°C (139°F) and Mixed 50°C (122°F) respectively due to locally sourced solvents. There is no detrimental effect on product performance.)
	Induction Period	15 minutes at temperatures below 25°C (77°F)

Drying Information

	50°F	59°F	77°F	95°F
Touch Dry [ISO 1517:73]	16hrs	13hrs	8hrs	2hrs
Hard Dry [ISO 9117:90]	24hrs	20hrs	10hrs	3hrs
Pot Life	4hrs	3.5hrs	2.5hrs	1hrs

Overcoating Data - see limitations

	Substrate Temperature							
	50°F		59°F		77°F		95°F	
Overcoated By	Min	Max	Min	Max	Min	Max	Min	Max
Interbond 501	24hrs	28days	20hrs	28days	10hrs	28days	6hrs	10days

REGULATORY DATA **VOC** 213 g/lit as supplied (EPA Method 24)

CERTIFICATION

When used as part of an approved scheme, this material has the following certification:

- Food Contact - Carriage of Grain (NOHA)
- Food Contact - FDA Compliant: Dry Foodstuffs

Consult your International Paint representative for details.

**SYSTEMS AND
COMPATIBILITY**

Consult your International Paint representative for the system best suited for the surfaces to be protected. When using in cargo holds, consult the Interbond 501 Cargo Hold Application Procedures.

**SURFACE
PREPARATIONS**

Use in accordance with the standard Worldwide Marine Specifications.

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

High pressure fresh water wash or fresh water wash, as appropriate, and remove all oil or grease, soluble contaminants and other foreign matter in accordance with SSPC-SP1 solvent cleaning.

MAJOR REFURBISHMENT

Abrasive blast clean to Sa2 (ISO 8501-1:1988). If oxidation has occurred between blasting and application of Interbond 501, 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.

Interbond 501 may be applied to surfaces prepared to International Paint Hydroblasting Standard HB2 which have flash rusted to no worse than HB2M.

REPAIR/OBM - Exposed steel and corrosion:

Hand or power tool clean to a minimum 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 Sa2 (ISO 8501-1:1988). Typically this would apply to C or D grade steel in this standard.

Or

Abrasive blast clean to Sa2 (ISO 8501-1:1988). If oxidation has occurred between blasting and application of Interbond 501, 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.

Or

Interbond 501 may be applied to surfaces prepared to International Paint Hydroblasting Standard HB2 which have flash rusted to no worse than HB2M.

Interbond 501 is suitable for overlap onto most aged coating systems. Loose or flaking coatings should be removed back to a firm edge and Interbond 501 should be applied to overlap the existing coating by 2-3 centimetres (one inch). Glossy epoxies and polyurethanes may require abrasion.

Intact Coatings:

This product may be applied as a full coat over most generic types of paint that have been aged for at least 3 months. It is advisable that a small trial be carried out before applying a full coat over certain generic types. Consult International Paint for acceptable generic types and extent of surface preparation required. Accurate film thickness control is essential, particularly when overcoating existing systems.

Consult your International Paint representative for specific recommendations.

NOTE:

For use in Marine situations in North America, the following surface preparation standards can be used:

SSPC-SP6 in place of Sa2 (ISO 8501-1:1988)

SSPC-SP2 in place of St2 (ISO 8501-1:1988)

SSPC-SP10 in place of Sa2½ (ISO 8501-1:1988)

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.
Thinner	Not recommended. Use International GTA220 only in exceptional circumstances (max 5% by volume)
Airless Spray	Recommended. - Tip range 0.53 - 0.66mm (21-26 thou) - Total output fluid pressure at spray tip not less than 176 kg/cm ² (2500 p.s.i.)
Conventional Spray	Application by conventional spray is not recommended.
Brush	Application by brush is recommended for small areas only. Multiple coats may be required to achieve specified film thickness.
Roller	Application by roller is recommended for small areas only. Multiple coats may be required to achieve specified film thickness.
Cleaner	International GTA220, GTA822 or International GTA220 (USA)
Work Stoppages and Cleanup	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA220, GTA822 or International GTA220 (USA). 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 all equipment immediately after use with International GTA220, GTA822 or GTA220 (USA). 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, relative humidity and elapsed time, including any delays. Do not exceed pot life limitations. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.
Welding	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. In North America do so in accordance with instruction in ANSI/ASC Z49.1 "Safety in Welding and Cutting."

SAFETY

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.
Prior to use, obtain, consult and follow the Material Safety Data Sheet for this product concerning health and safety information. Read and follow all precautionary notices on the Material Safety Data Sheet and container labels. If you do not fully understand these warnings and instructions or if you can not strictly comply with them, do not use this product. Proper ventilation and protective measures must be provided during application and drying to keep solvent vapour concentrations within safe limits and to protect against toxic or oxygen deficient hazards. Take precautions to avoid skin and eye contact (ie. gloves, goggles, face masks, barrier creams etc.) Actual safety measures are dependant on application methods and work environment.

EMERGENCY CONTACT NUMBERS:
USA/Canada - Medical Advisory Number 1-800-854-6813
Europe - Contact (44) 191 4696111. For advice to Doctors & Hospitals only contact (44) 207 6359191
R.O.W. - Contact Regional Office (see page 4 of Data Sheet)

LIMITATIONS

For wet holds and boottops: abrasive blast clean to Sa2½ (ISO8501-1 : 1988) or SSPC-SP10. If oxidation has occurred between blasting and application of Interbond 501, 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. Apply one coat of the recommended primer. Interbond 501 must be applied within the overcoating interval specified on the primer product data sheet.

Interbond 501 is not recommended for application below 10°C (50°F).

For dry holds, decks, deck fittings and topsides: optimum performance is achieved when this coating is applied over blasted steel.


When spraying large areas, application of a brush coat is recommended over pitted or rough surfaces to ensure full penetration. Stripe coating of complex structures is recommended.

In common with all epoxy based coatings Interbond 501 will exhibit chalking of the film on UV exposure. Overcoating information is given for guidance only and is subject to regional variation depending upon local climate and environmental conditions. Consult your local International Paint representative for specific recommendations. Apply in good weather. Temperature of the surface to be coated must be at least 3°C (5°F) above the dew point. For optimum application properties bring the material to 21-27°C (70-80°F), unless specifically instructed otherwise, prior to mixing and application. Unmixed material (in closed containers) should be maintained in protected storage in accordance with information given in the STORAGE Section of this data sheet. Technical and application data herein is for the purpose of establishing a general guideline of the coating application procedures. Test performance results were obtained in a controlled laboratory environment and International Paint makes no claim that the exhibited published test results, or any other tests, accurately represent results found in all field environments. As application, environmental and design factors can vary significantly, due care should be exercised in the selection, verification of performance and use of the coating.

UNIT SIZE	20 litre unit: Interbond 501, Part A, 15 litres in a 20 litre container and Part B, 5 litre in a 5 litre container. 4 US gallon unit: Interbond 501, Part A, 3 US gallons in a 5 US gallon container and Part B, 1 US gallon in a 1 US gallon container. <i>For availability of other unit sizes consult International Paint.</i>
UNIT SHIPPING WEIGHT	20 litre unit: 30.72 kg 4 Gallon Unit (15.14 l) - 51.9 lb (23.6 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.
WORLDWIDE AVAILABILITY	Consult International Paint.

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 his own risk. All advice we give 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 law) any loss or damage arising out of the use of the product. All products supplied and technical advice given are subject to our standard terms and 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 that this data sheet is current prior to using the product. It is the user's responsibility to check with his local International Paint representative that this data sheet is current prior to using the product.

 and product names mentioned in this data sheet are trademarks of or are licensed to Akzo Nobel.
© Akzo Nobel, 2004

Worldwide Operations

Argentina, Australia, Bahrain, Belgium, Brazil, Bulgaria, Canada, Chile, Colombia, Croatia, Cuba, Cyprus, Denmark, Ecuador, Egypt, Estonia, Fiji, Finland, France, Germany, Greece, Hong Kong, Iceland, India, Indonesia, Iran, Italy, Japan, Kuwait, Latvia, Lithuania, Luxembourg, Malaysia, Malta, Mexico, Netherlands, New Zealand, Northern Ireland, Norway, Pakistan, Panama, Papua New Guinea, Peoples Republic of China, Peru, Philippines, Poland, Portugal, Qatar, Republic of Ireland, Romania, Russia, Saudi Arabia, Singapore, Slovenia, South Africa, South Korea, Spain, Sri Lanka, Sweden, Taiwan, Thailand, Turkey, U.S.A., Ukraine, United Arab Emirates, United Kingdom, Uruguay, Venezuela, Vietnam, Western Samoa, Yemen

Head Office

International Paint Ltd, Oriel House, 16 Connaught Place, London W2 2ZB, United Kingdom, Tel: +44 (0) 207 479 6000, Fax: +44 (0) 207 479 6500

www.international-marine.com