Interseal 547

Surface Tolerant E p o x y

PRODUCT DESCRIPTION

A low VOC, two component high build, high solids surface tolerant epoxy maintenance coating. Available in colours.

Also available in an aluminium pigmented version to provide additional anti-corrosive barrier protection.

INTENDED USES

For application to a wide variety of substrates including hand prepared rusty steel, abrasive blast cleaned and hydroblasted steel, and a wide range of intact, aged coatings. Capable of being utilised in both maintenance and new construction situations.

Provides excellent anti-corrosive protection in industrial, coastal structures, pulp and paper plants, bridges and offshore environmental in both atmospheric exposure and immersion service.

PRACTICAL INFORMATION FOR INTERSEAL 547

Colour	Aluminium and a selected range of colours
Gloss Level	Semiglossy
Volume Solids	82% ± 2% (depends on colour)
Typical Thickness	100-200 microns (4-8 mils) dry equivalent to 122-244 microns (4.9-9.8 mills) wet
Theoretical Coverage	8 m^2/litre at 100 microns d.f.t at stated volume solids 263 sq.ft/US gallon at 5 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless spray, Brush

Drying Time

			Overcoating Interval of Interseal with self		Overcoating Interval with recommended topcoats	
Temperature	Touch Dry	Hard Dry	Minimum	Maximum	Minimum	Maximum
25°C (77°F)	4 hours	16 hours	16 hours	6 Months	16 hours	6 Months
45°C (104°F)	2 hours	8 hours	12 hours	3 Months	8 hours	3 Months

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REGULATORY DATA

Flash Point	Base (Part A)	C/A (Part B)	Mixed
	36°C (97°F)	31°C (88° F)	35°C (95°F)

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SURFACE PREPARATION

The performance of this product will depend upon the degree of surface preparation. The surface to be coated must 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 547 must be applied to surfaces blast cleaned to Sa2½ (ISO 8501-1:1988) or SSPC-SP10. However, for atmospheric exposure best performance will be achieved when Interseal 547 is applied to surfaces prepared to a minimum of Sa2½ (ISO 8501-1:1988) or SSPC-SP6.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.

Hand or Power Tool Preparation
Hand or power tool clean to a minimum St2 (ISO 8501-1:1988) or SSPC-SP2.
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) or SSPC-SP6. Typically this would apply to C or D grade rusting in this standard.

Aged Coatings
Interseal 547 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.

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 3.0 parts : 1.00 part by volume

Working Pot Life	15° C (59° F) 3 hours	25°C (77°F) 2 hours	40° C (104° F) 1 hour
Airless Spray	Recommended	- Tip range 0.45-0.58mm (18-23 thou) - Total output fluid pressure at spray tip not less than 176 kg/cm2 (2,500 p.s.i)	
Brush	Recommended	Typically 75-125 microns (3-5 mils) can be achieved	
Roller	Recommended	Typically 75-100 microns (3-4 mils) can be achieved	
Thinner	International GTA220	Do not thin more than allowed by local envionmental legislation.	
Cleaner	International GTA822 (or GTA415)		

Work Stoppages Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA 822. 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 up all equipment immediately after use with International GTA 822. 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 diagnosed of in accordance with appropriate regional regulations / legislation.

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PRODUCT CHARACTERISTICS

In order to achieve optimum performance on hand prepared steel, the aluminium pigment version should be applied as a primer coat by brush to ensure thorough wetting out of the substrate by Interseal 547.

For water immersion service, surface preparation to a minimum of Sa21/2 (IS08501-1:1988) or SSPC-SP10 followed by application of multi-coats of Interseal 547 to a total minimum dry film thickness of 250 microns (10 mils) is required.

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. Low or high temperatures may require specific application techniques to achieve maximum film build.

If salt water is used in the wet blast process the resulting surface must be thoroughly washed with fresh water before application of Interseal 547. With freshly blast cleaned surfaces a slight degree of flash rusting is allowable, and is preferable to the surface being too wet. Puddles, ponding and accumulations of water must be removed.

Interseal 547 is suitable for overcoating intact, aged, epoxy and polyurethane systems. However, this product is not recommended where thermoplastic coatings such as chlorinated rubbers and vinyls have previously been used. Please consult International Protective Coatings for alternative recommendations.

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

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

In common with all epoxies Interseal 547 will chalk and discolour on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance. Premature exposure to ponding water will cause a color change, especially in dark colours.

SYSTEMS COMPATABILITY

Interseal 547 will normally be applied to correctly prepared steel substrates. However, it can be used over suitably primed surfaces. Suitable primers are :-

Intergard 269
Interplus 256

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

Intergard 740
Interthane 990
Interthane 138

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

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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 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 sheets (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 and 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	Interseal 547 Base	15 litres in a 20 litre container
		Interseal 547 Curing Agent	5 litres in a 3.7 litre container
	5 litres unit	Interseal 547 base	3.75 litres in a 5 litre container
		Interseal 547 Curing Agent	1.25 litres in a 2 litre container

For availability of other pack sizes contact International Protective Coatings

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STORAGE Shelf Life 12 months minimum at 25 deg C (77 deg F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Disclaimer

The information given in this sheet in 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. 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.
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