

Intercure 202

Rapid Recoat Epoxy



Product Description

A high solids, low VOC, 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. Pigmented with zinc phosphate anti-corrosive pigment to comply with BS5493 (1977).

Intended Uses

As a primer for steelwork intended for service in a wide range of environmental conditions, including offshore structures, chemical plants, industrial buildings, pulp and paper mills, power plants and bridges.

Suitable for overcoating within 3 hours in most climatic conditions which can greatly speed up production and throughput in fabrication shops.

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

Practical Information for Intercure 202

Colour	Buff, Red oxide			
Gloss Level	Matt			
Volume Solids	67%			
Typical Thickness	75-100 microns (3-4mils) dry equivalent to 112-149 microns (4.5-6.0 mils) wet			
Theoretical Coverage	8.93 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				
			Overcoating Interval with recommended topcoats	
Temperature	Touch Dry	Hard Dry	<i>Minimum</i>	<i>Maximum</i>
5°C (41°F)	40 minutes	4½ hours	3 hours	Extended*
15°C (59°F)	30 minutes	3 hours	2 hours	Extended*
25°C (77°F)	20 minutes	2 hours	1 hour	Extended*
40°C (104°F)	15 minutes	30 minutes	30 minutes	Extended*

* See International Protective Coatings Definitions & Abbreviations

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	1.7 kg/l (14.2 lb/gal)		
VOC	320 g/l	UK - PG6/23(92), Appendix 3	
	2.67 lb/gal (320 g/l)	USA - EPA Method 24	



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 8504:1992.

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Abrasive Blast Cleaning

Abrasive blast clean to Sa2½ (ISO 8501-1:1988) or SSPC-SP6. If oxidation has occurred between blasting and application of Intercure 202, 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.

Intercure 202 is suitable for application to 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 blast cleaned to Sa2½ (ISO 8501-1:1988) or SSPC-SP6.

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

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 parts : 1 part 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/cm² (2,500 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 (2-3 mils) can be achieved

Roller

Suitable - small areas only Typically 50-75 microns (2-3 mils) can be achieved

Thinner

International GTA220 Do not thin more than allowed by local environmental legislation.

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 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 202 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) d.f.t. will normally be overcoatable after 6 months exposure provided it is adequately cleaned and any areas of mechanical damage repaired.

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

This product must only be thinned using International GTA220 thinners. The use of alternative thinners, particularly those containing Ketones, can severely inhibit the curing mechanism of the coating.

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.

Low Temperature Curing

Intercure 202 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.

Temperature	Touch Dry	Hard Dry	Minimum overcoating interval with recommended topcoats	
			<i>Minimum</i>	<i>Maximum</i>
-5°C (23°F)	60 minutes	10 hours	8 hours	Extended
0°C (32°F)	45 minutes	7 hours	6 hours	Extended

Touch dry times shown above are actual drying times due to chemical cure, rather than physical set due to solidification of the coating film at temperatures below 0°C (32°F).

This product is not available in pale and pastel shades due to a tendency to discolour rapidly. Additionally, in common with all epoxies Intercure 202 will chalk on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

Intercure 202 is not intended for use as a primer for steelwork which may be subjected to continuous immersion conditions.

Intercure 202 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 202 is less than that to fresh material, however, it is adequate for the specified end use.

Over-application of Intercure 202 will extend both the minimum overcoating periods and handling times, and may be detrimental to long term overcoating properties.

This product has the following specification approvals:

BS5493:1977 KP1A

UK Department of Transport Item No. 111

Systems Compatibility

Intercure 202 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.

Recommended topcoats/intermediates are:

- Intercure 420
- Intercure 426
- Interfine 629 HS
- Intergard 410
- Intergard 475 HS
- Intergard 740
- Interseal 670 HS
- Interthane 990
- Interzone 505
- Interzone 954 } When used as part of a
- Interzone 1000 } deck coating system

For other suitable topcoats/intermediates, 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 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 202 Base	15 litres in a 20 litre container
		Intercure 202 Curing Agent	5 litres in a 5 litre container
	For availability of other pack sizes contact International Protective Coatings		
Shipping Weight	U.N. Shipping No. 1263		
	20 litre unit	30.6 kg (67.5 lb) Base (Part A)	5.3 kg (11.7 lb) Curing Agent (Part B)
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.	

Disclaimer

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 from 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: 1st September 1997

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International Protective Coatings

Worldwide Availability

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