# Interbond 808

## Epoxy Anticorrosive

**PRODUCT DESCRIPTION**

A light coloured, tar free, surface tolerant, two pack epoxy coating with high volume solids (82%). Interbond 808 is capable of being applied as a one or two coat system over grit blasted, hydroblasted or mechanically cleaned surfaces. It is also tolerant of damp surfaces (see limitations section).

**INTENDED USES**

A high performance epoxy coating for use in water ballast tanks, cofferdams, void spaces, wet spaces, bilges and crude oil tanks.
For use at Maintenance & Repair or On Board Maintenance.

**PRODUCT INFORMATION**

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|---|---|
| **Colour** | KRA850-Buff, KRA852-Grey (available in Singapore only), KRA853-Aluminium, KRA854-White (available in Brazil and Singapore only), KRA859-Black (available in USA only). |
| **Finish/Sheen** | Not applicable |
| **Part B (Curing Agent)** | KRA855 |
| **Volume Solids** | 82% ±2% (ISO 3233:1998) |
| **Mix Ratio** | 4 volume(s) Part A to 1 volume(s) Part B |
| **Typical Film Thickness** | 300 microns dry (366 microns wet) |
| **Theoretical Coverage** | 2.73 m²/litre at 300 microns dft, allow appropriate loss factors |
| **Method of Application** | Airless Spray, Brush |
| **Flash Point (Typical)** | Part A 32°C; Part B 58°C; Mixed 33°C |
| **Induction Period** | Not required |

| **Drying Information** | 5°C | 15°C | 25°C | 35°C |
|---|---|---|---|---|
| Touch Dry [ISO 9117/3:2010] | 15 hrs | 8 hrs | 3.5 hrs | 2 hrs |
| Hard Dry [ISO 9117-1:2009] | 34 hrs | 18 hrs | 7 hrs | 4 hrs |
| Walk-on Time | 44 hrs | 21 hrs | 8.5 hrs | 5 hrs |
| Before Flooding | 3 days | 2 days | 24 hrs | 12 hrs |
| Pot Life | 2 hrs | 100 mins | 75 mins | 30 mins |

**Overcoating Data - see limitations**

| | **Substrate Temperature** | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| | 5°C | | 15°C | | 25°C | | 35°C | |
| **Overcoated By** | Min | Max | Min | Max | Min | Max | Min | Max |
| Interbond 808 | 48 hrs | 14 days | 30 hrs | 10 days | 12 hrs | 7 days | 8 hrs | 5 days |

**REGULATORY DATA**

**VOC**

220 g/lt as supplied (EPA Method 24)
152 g/kg of liquid paint as supplied. EU Solvent Emissions Directive (Council Directive 1999/13/EC)
150 g/lt Chinese National Standard GB23985

**Note:** VOC values are typical and are provided for guidance purposes only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

**CERTIFICATION**

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

- Food Contact - Carriage of Grain (NOHH)

Consult your International Paint representative for details.
Approvals issued by external bodies may be dependent upon formulation and/ or manufacturing site.

**SYSTEMS AND COMPATIBILITY**

Consult your International Paint representative for the system best suited for the surfaces to be protected.

**SURFACE PREPARATIONS**

Paint only clean surfaces. Remove all grease, oil, soluble contaminants and other foreign matter by "solvent cleaning" (SSPC-SP1).

**MAJOR REFURBISHMENT**
Abrasive blast clean to Sa2 (ISO 8501:1:2007) or hydroblast to International Paint hydroblasting standard HB2M/H (If abrasive blasting, the area should be fresh water washed prior to commencement).

**REPAIR/OBM**
Prepare areas of corrosion by mechanical cleaning to St3 (ISO 8501-1 : 2007) or hydroblast to International Paint Standard HB2M/H. Abrade surrounding intact area and feather the edges.

If overcoating large areas of aged two component coatings, the surfaces should be high pressure fresh water washed prior to application. Consult your International Paint representative for specific recommendations regarding two component coatings suitable for overcoating with Interbond 808. Interbond 808 should not be used to maintain or overcoat one component ballast coatings.
When applying Interbond 808 as a two coat scheme, Interbond 808 Aluminium must always be applied as the first coat.

**NOTE**
**For use in Marine situations in North America, the following surface preparation standards can be used:**
**SSPC-SP6 in place of Sa2 (ISO 8501-1:2007)**
**SSPC-SP3 or SSPC-SP11 in place of St3 (ISO 8501-1:2007)**

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**APPLICATION**

| | |
|---|---|
| **Mixing** | Material is supplied in 2 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.<br>(1) Agitate Base (Part A) with a power agitator.<br>(2) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator. |
| **Thinner** | International GTA220. Thinning is not normally required. Consult the local representative for advice during application in extreme conditions. Do not thin more than allowed by local environmental legislation. |
| **Airless Spray** | Recommended<br>Tip Range 0.45-0.66 mm (18-26 thou)<br>Total output fluid pressure at spray tip not less than 190 - 246 kg/cm² (2700 - 3500 p.s.i.) |
| **Brush** | Application by brush is recommended for small areas only. Multiple coats may be required to achieve specified film thickness. |
| **Roller** | Not recommended. |
| **Cleaner** | International GTA822/GTA220 |
| **Work Stoppages and Cleanup** | Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA822/GTA220. 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.<br>Clean all equipment immediately after use with International GTA822/GTA220. 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. Do not exceed pot life limitations.<br>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**
**China – Contact (86) 532 83889090**
**R.O.W. - Contact Regional Office**

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**LIMITATIONS**

This product will not cure adequately below 5°C. Substrate temperature should not exceed 40°C.
Interbond 808 can be applied over a damp but drying surface - not a wet surface. It cannot be applied over pools of water or water droplets. A simple test for dampness is as follows: With a finger, mark a 'V' on the surface to be coated. If drops of water collect at the bottom of the 'V', then the surface is wet not damp and should not be coated. The surface may be dried however and coated provided that it does not become wet during application.
Interbond 808 series is capable of continuing its cure process once immersed in water. However, early immersion following application will tend to retard coating cure and may result in soft films. See 'Drying Times, before flooding'.
The curing agent for Interbond 808 has a tendency to go cloudy when stored at temperatures below 5°C. Warming the curing agent above 5°C will restore the clear nature of the product. No adverse effect on performance is observed if the curing agent is cloudy when used.
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.
For optimum application properties bring the material to 25-30°C, 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**

| Unit Size | Part A | | Part B | |
|---|---|---|---|---|
| | Vol | Pack | Vol | Pack |
| 20 lt | 16 lt | 20 lt | 4 lt | 5 lt |
| 5 US gal | 4 US gal | 5 US gal | 1 US gal | 1 US gal |
| 1 US gal | 0.8 US gal | 1 US gal | 0.2 US gal | 1 US quart |

*For availability of other unit sizes consult International Paint*

**UNIT SHIPPING WEIGHT (TYPICAL)**

| Unit Size | Unit Weight |
|---|---|
| 1 US gal | 18 lb |
| 20 lt | 34.7 Kg |
| 5 US gal | 86.7 lb |

**STORAGE**

Shelf Life: 12 months at 25°C. Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

**WORLDWIDE AVAILABILITY**

KRA852 - Grey available in Singapore only.
KRA854 - White available in Brazil and Singapore only.
KRA859 - Black available in USA only.
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 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.*

*This Technical Data Sheet is available on our website at www.international-marine.com or www.international-pc.com, and should be the same as this document. Should there be any discrepancies between this document and the version of the Technical Data Sheet that appears on the website, then the version on the website will take precedence.*



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