

Intercure® 420
Rapid Recoat Epoxy

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 SSPC-SP6 or Sa2½ (ISO 8501-1:1988). If oxidation has occurred between blasting and application of Intercure 420, the surface should be retreated to the specified visual standard.

Surface defects revealed by the blast cleaning process, should be ground, filled, or treated in the appropriate manner.

Shop Primed Surfaces

Weld seams and damaged areas should be blast cleaned to SSPC-SP6 or Sa2½ (ISO 8501-1:1988).

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

Zinc Primed Surfaces

Ensure that the surface of the primer is clean, dry and free from contamination and zinc salts before application of Intercure 420. Ensure zinc primers are fully cured before overcoating.

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	41°F (5°C)	59°F (15°C)	77°F (25°C)	104°F (40°C)
	8 hours	4 hours	2 hours	45 minutes

Airless Spray Recommended

- Tip range 17-21 thou (0.43-0.53 mm)
- Total output fluid pressure at spray tip not less than 2,500 p.s.i. (176 kg/cm²)

Air Spray (Pressure Pot) Recommended

	Gun	DeVilbiss M5C or JCA
	Air Cap	704 or 765
	Fluid Tip	E

Brush Suitable - small areas only. Typically 3 mils (75 microns) can be achieved.

Roller Suitable - small areas only. Typically 2.3 mils (60-75 microns) can be achieved.

Thinner International GTA415 (or GTA230). Do not thin more than allowed by local environmental legislation.

Cleaners International GTA415 (or GTA822).

Work Stoppages Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA415. 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 GTA415. 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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