Interprime 820

Primers

High Performance Epoxy Primer

PRODUCT DESCRIPTION

High performance 2-component epoxy primer containing inert pigments and extenders. Interprime 820 is suitable for use on a variety of substrates above and below water.

* Excellent anticorrosive protection
* Easy sanding

PRODUCT INFORMATION

Colour	YPA828-White, YPA829-Grey (EU only)
Finish	Satin
Specific Gravity	1.54
Volume Solids	49%
Mix Ratio	3:1 by volume
Converter/Curing Agent	YPA824
Typical Shelf Life	2 yrs
VOC (As Supplied)	448 g/L
Unit Size	5 Lt, 20 Lt

DRYING/OVERCOATING INFORMATION

Drying

	10°C (50°F)	15°C (59°F)	25°C (77°F)	35°C (95°F)
Touch Dry	12 hrs	9 hrs	6 hrs	5 hrs
Pot Life	12 hrs	6 hrs	4 hrs	3 hrs

Overcoating

Substrate Temperature

Overcoated By	10°C (50°F)		15°C (59°F)		25°C (77°F)		35°C (95°F)	
	Min	Max	Min	Max	Min	Max	Min	Max
Epiglass HT9000	36 hrs	6 mths	16 hrs	6 mths	8 hrs	6 mths	6 hrs	3 mths
Epoxy Tiecoat	36 hrs	6 mths	16 hrs	6 mths	8 hrs	6 mths	6 hrs	3 mths
Interfill 830	48 hrs	3 mths	36 hrs	3 mths	24 hrs	3 mths	24 hrs	3 mths
Interfill 833	48 hrs	3 mths	36 hrs	3 mths	24 hrs	3 mths	24 hrs	3 mths
Interprime 820	36 hrs	6 mths	16 hrs	6 mths	8 hrs	6 mths	6 hrs	3 mths
Interprime 880	36 hrs	6 mths	16 hrs	6 mths	8 hrs	6 mths	6 hrs	3 mths
Interprotect	36 hrs	6 mths	16 hrs	6 mths	8 hrs	6 mths	6 hrs	3 mths
Interprotect (Professional)	36 hrs	6 mths	16 hrs	6 mths	8 hrs	6 mths	6 hrs	3 mths
Microsurfacer	36 hrs	6 mths	16 hrs	6 mths	8 hrs	6 mths	6 hrs	3 mths
Perfection Pro Undercoat	36 hrs	6 days	16 hrs	5 days	12 hrs	3 days	6 hrs	2 days
Quick Build Sealer	36 hrs	6 mths	16 hrs	6 mths	12 hrs	6 mths	6 hrs	3 mths
Quick Build Surfacer	36 hrs	6 mths	16 hrs	6 mths	12 hrs	6 mths	6 hrs	3 mths
YRA600 Undercoat	36 hrs	6 mths	16 hrs	6 mths	8 hrs	6 mths	6 hrs	3 mths

APPLICATION AND USE

Preparation

STAINLESS STEEL/STEEL/ALUMINIUM/LEAD: Thoroughly degrease with a suitable thinner/cleaner using the 2 cloth method prior to carrying out any mechanical cleaning.
STEEL: Blast damaged or corroded areas to near white metal surface as per AS1627.4 Class 2.5. If gritblasting is not possible, grind the metal surface with 24-36 grit abrasive discs to a uniform, clean, bright metal surface with a 50-75 microns anchor pattern.
LEAD: Sand well using 120 grade paper or power wire brush. Clean thoroughly and ensure surface is dry. Pre-prime using an International primer as detailed for specific coating systems.
ALUMINIUM: Low pressure grit blast using aluminium oxide or a copper-free equivalent. If blasting is not possible, power disc with 24-36 grade discs to a surface profile of 50-75 micron/ 2-3 mils. (NB Power wire brushing is not permitted as it is ineffective and wires are often steel, leading to corrosion).
STAINLESS STEEL: Light gritblast to produce a profile of 50 microns (2 mil) prior to applying a thinned coat of Interprime 820 as a tie coat.
GRP (GELCOAT): Wash down with Super Cleaner or Thinner No. 7 (AP), rinse with fresh water and allow to dry. Sand

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	with 180 grade (grit) paper. Ensure all waxes and uncured resins are removed. Ensure sanding debris is removed by vacuuming and compressed air blow down prior to proceeding. **BARE WOOD**: Sand with 80-280 grade paper. Remove oil from oily woods eg teak, using recommended thinners. Change rags frequently. Everdure (AP only) may be used to seal any timbers if required. Thin the first coat of primer 15% with suitable thinner. **EPOXY PRIMERS**: Sweep blast or abrade with 120-180 grade paper. **EPOXY FILLERS**: Sand with 60-120 grade (grit) paper. Do not wipe down any epoxy fillers with solvent.
Method	Remove blast/grinding/sanding residues with a clean air line & sweep with a clean brush, or vacuum clean for best results. On blasted and rough ground surfaces do not try and wipe with rags and thinners as the rags will catch and leave particles of cloth behind. Apply required number of coats, detailed in the specification sheets, by spray, allowing required overcoating interval between applications. If applying direct to metal substrates, Interprime 820 should be thinned 15% with YTA061 International Epoxy Thinner No. 7 (AP only), YTA910, YTA920 and applied at 160 microns WFT.
Hints	**Mixing**: Mix base and curing agent thoroughly at the specified ratio. **Thinner**: YTA910, YTA920 or YTA061 epoxy thinner No. 7 (AP only). The choice of which thinner to use is dependent on the temperature of application, and is related to the method of application (e.g. airless or conventional spray, pressure settings etc.) **Cleaner**: International Equipment Cleaner GTA822 or YTA061 International Epoxy Thinner No.7 (AP only). **Airless Spray**: Pressure: 175 bar. Tip Size: 1560-2180. **Air Atomized**: For conventional spray, thin 15-20% with YTA910, YTA920 or up to 20% with YTA061. Do not excessively thin for high build coats. Pressure: <1 bar (Pot)/3-4 bar (Atomising). Tip Size: 1.8 mm. **Brush**: Use brush application for touch-ups **Other**: Do not apply at a thickness greater than recommended, as this may lead to solvent entrapment within the coating. As a guide, fillers should be allowed to cure to a 'Shore D' hardness of 50 before overcoating.
Some Important Points	Do not use below 10°C/50°F. Do not use unless mixed thoroughly with the curing agent at specified ratio. Do not apply when there is a chance of condensation forming on the substrate. Do not apply thicker coats than indicated as this may lead to cracking and solvent entrapment within the coating. Do not wipe down cured filler with thinners/solvents. Ambient temperature should be minimum 10°C and maximum 35°C. Product temperature should be minimum 10°C and maximum 35°C. Substrate temperature should be minimum 10°C and maximum 35°C.
Compatibility/Substrates	Suitable for use on steel, aluminum and fiberglass. Suitable for stainless steel trim tabs and stern drive gear. Compatible with selected epoxy based primers and fillers.
Coverage	(Theoretical) - 3.64 m²/L per coat (Practical) - 2.8 m²/L per coat by spray
Recommended DFT per coat	125 microns dry
Recommended WFT per coat	255 microns wet
Application Methods	Airless Spray, Brush, Air Atomized, Roller

TRANSPORTATION, STORAGE AND SAFETY INFORMATION

Storage	**GENERAL INFORMATION:** Exposure to air and extremes of temperature should be avoided. For the full shelf life of Interprime 820 to be realised ensure that between use the container is firmly closed and the temperature is between 5°C/41°F and 35°C/95°F. Keep out of direct sunlight. **TRANSPORTATION:** Interprime 820 should be kept in securely closed containers during transport and storage.
Safety	**GENERAL:** Read the label safety section for Health and Safety Information, also available from our Technical Help Line. **DISPOSAL:** Do not discard tins or pour paint into water courses, use the facilities provided. It is best to allow paints to harden before disposal. Remainders of Interprime 820 cannot be disposed of through the municipal waste route or dumped without permit. Disposal of remainders must be arranged for in consultation with the authorities.
IMPORTANT NOTES	*The information given in this sheet is not intended to be exhaustive. Any person using the product without first making further written enquiries as to the suitability of the product for the intended purpose does so at their own risk and we can accept no responsibility for the performance of the product or for any loss or damage (other than death or personal injury resulting from negligence) arising out of such use. 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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