



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 steel and aluminium above and below water

* Excellent anticorrosive protection

* Easy sanding

* Two colours for overcoating identification

PRODUCT INFORMATION

Colour	YPA828-White, YPA829-Grey
Finish	Eggshell
Specific Gravity	1.54
Volume Solids	47%
Mix Ratio	3:1 by volume , Converter/Curing Agent - YPA824
Typical Shelf Life	2 yrs
VOC (As Supplied)	462 g/lit
Unit Size	5 Lt 20 Lt

DRYING/OVERCOATING INFORMATION

Drying

	10°C	15°C	23°C	35°C
Touch Dry [ISO]	12hrs	9hrs	6hrs	5hrs
Pot Life	12hrs	6hrs	4hrs	3hrs

Overcoating Substrate Temperature

Overcoated By	10°C		15°C		23°C		35°C	
	Min	Max	Min	Max	Min	Max	Min	Max
Interfill 830	48hrs	3mths	36hrs	3mths	24hrs	3mths	24hrs	3mths
Interfill 833	48hrs	3mths	36hrs	3mths	24hrs	3mths	24hrs	3mths
Interfill 835	48hrs	3mths	36hrs	3mths	24hrs	3mths	24hrs	3mths
Interprime 820	36hrs	6mths	16hrs	6mths	8hrs	6mths	6hrs	3mths
Interprime 880	36hrs	6mths	16hrs	6mths	8hrs	6mths	6hrs	3mths
Interprotect	36hrs	6mths	16hrs	6mths	8hrs	6mths	6hrs	3mths
Interprotect (Professional)	36hrs	6mths	16hrs	6mths	8hrs	6mths	6hrs	3mths
Interthane 990	36hrs	6days	16hrs	5days	12hrs	3days	6hrs	2days
Polyurethane Basecoat	36hrs	6days	16hrs	5days	12hrs	3days	6hrs	2days

APPLICATION AND USE

Preparation

STEEL/ALUMINIUM: Thoroughly degrease with Yacht Line Super Cleaner.

STEEL: Gritblast to Sa 2½ - near white metal surface. 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.

ALUMINIUM: Blast with aluminium oxide or copper-free equivalent. If blasting is not possible,

disc with 24-36 grade aluminium oxide paper to a uniform, clean, bright metal surface with a 50-75 micron/ 2-3 mils anchor pattern.

STAINLESS STEEL: Light gritblast to produce a profile of 50 microns prior to applying a thinned coat of Interprime 820 as a tie coat.

BARE GRP: Wash down with Yacht Line Super Cleaner, rinse with fresh water and allow to dry. Sand with 80 grade (grit) paper. Ensure sanding debris is removed prior to proceeding.

EPOXY PRIMERS: Sweep blast or abrade with 280 grade paper.

ALL SUBSTRATES: Wipe down blasted metal or epoxy primers with a clean rag and solvent using 2 rag wipe-down method.

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. 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 YTA910, YTA925, YTA920 and applied at 125 microns WFT.
Hints	<p>Mixing Mix base and curing agent thoroughly at the specified ratio.</p> <p>Thinner YTA910, YTA925, YTA920 Fast YTA910, Slow YTA920, Extra Slow YTA925. The choice of which thinner to use is dependant on the temperature of application, and is related to the method of application (e.g. airless or conventional spray, pressure settings etc.)</p> <p>Cleaner Use GTA822 for equipment cleaning.</p> <p>Airless Spray Pressure: 175 bar. Tip Size: 1560-2180. For airless spray application at 125 microns WFT, the smaller tip sizes may be appropriate (1560-1880).</p> <p>Conventional Spray For conventional spray, thin 15-20% with YTA910, YTA925, YTA920. Do not excessively thin for high build coats. Pressure: <1 bar (Pot)/3-4 bar (Atomising). Tip Size: 1.8 mm.</p> <p>Brush Use brush application for touch-ups</p> <p>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.</p>
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 and Aluminium surfaces. Suitable for stainless steel trim tabs and stern drive gear. Compatible with selected International epoxy based primers and fillers.
Coverage	(Theoretical) - 3.64 (m ² /lt) (Practical) - 2.80 (m ² /lt) by spray
Recommended DFT	125 microns dry
Recommended WFT	275 microns wet
Application Methods	Brush, Roller, Conventional Spray, Airmix, Airless Spray

TRANSPORTATION, STORAGE AND SAFETY INFORMATION

Storage	<p>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/40°F and 35°C/95°F. Keep out of direct sunlight.</p> <p>TRANSPORTATION: Interprime 820 should be kept in securely closed containers during transport and storage.</p>
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 or 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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