Interdur® 8808

Epoxy Zinc-Rich

PRODUCT DESCRIPTION

A two component, metallic zinc rich epoxy primer which complies with the composition and performance requirements of SSPC Paint 20 and HG/T3668, designed to give fast cure at low temperatures.

INTENDED USES

As a zinc rich primer to form part of a coating system, to provide corrosion protection for steel substrates in a wide range of industrial situations, including high value infrastructure projects, offshore facilities, petrochemical and chemical plants, pulp and paper plants, refineries and on bridges.

PRACTICAL INFORMATION FOR INTERDUR 8808

Colour	Grey
Gloss Level	Matt
Volume Solids	65% ± 2%
Typical Thickness	50-100 microns (2-4 mils) dry equivalent to 77-154 microns (3.1-6.2 mils) wet
Theoretical Coverage	9.29 m²/litre at 70 microns d.f.t and stated volume solids 372 sq.ft/US gallon at 2.8 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Brush, Roller

Drying Time

			Overcoating Interval with recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
5°C (41°F)	90 minutes	4 hours	8 hours	Extended[1]
15°C (59°F)	60 minutes	3 hours	4 hours	Extended[1]
25°C (77°F)	30 minutes	2 hours	3 hours	Extended[1]
40°C (104°F)	15 minutes	60 minutes	2 hours	Extended[1]

[1] See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical)	Part A 32°C (90°F); Part B 31°C (88°F); Mixed 31°C (88°F)	
Product Weight	1.8 kg/l (15.0 lb/gal)	
VOC	2.78 lb/gal (334 g/lt) 246 g/lt	EPA Method 24 Chinese National Standard GB23985

Coating hazard marker GB 30981.2-S-Pb≤1000-NC Qualified for GB 30981.2-2025

See Product Characteristics section for further details

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 GB18839-2002.

Oil or grease should be removed in accordance with GB 18839-2002 solvent cleaning.

Abrasive Blast Cleaning

Abrasive blast clean to Sa 2.5 (GB 8923-1:1988), If oxidation has occurred between blasting and application of Interdur 8808, the surface should be reblasted to the specified visual standard.

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

A surface profile of 40-75 microns (1.5-3.0 mils) is recommended.

Shop Primed Steel

Interdur 8808 is suitable for application to unweathered steelwork freshly coated with zinc silicate shop primers.

If the zinc shop primer shows extensive or widely scattered breakdown, or excessive zinc corrosion products, overall sweep blasting will be necessary. Other types of shop primer are not suitable for overcoating and will require complete removal by abrasive blast cleaning.

Weld seams and damaged areas should be blast cleaned to Sa2.5 (GB 8923-1:1988).

Damaged / Repair Areas

All damaged areas should ideally be blast cleaned to original standard i.e. Sa2.5 (GB 8923-1 : 1988). However, it is acceptable that small areas can be power tool cleaned to Pt3 (JSRA SPSS : 1984) or SSPC-SP11, provided the area is not polished.

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

4 part(s) : 1 part(s) by volume

Working Pot Life

5°C (41°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
3.5 hours	2.5 hours	1.5 hours	40 minutes

Airless Spray	Recommended	Tip Range 0.43-0.53 mm (17-21 thou) Total output fluid pressure at spray tip not less than 191 kg/cm² (2716 p.s.i.) A 9 mm (0.375") fluid hose of maximum 15 metres (49 ft) is recommended.
Brush	Suitable - small areas only	Typically 25-50 microns (1.0-2.0 mils) can be achieved
Roller	Suitable - small areas only	Typically 25-50 microns (1.0-2.0 mils) can be achieved
Thinner	International GTA822 (or International GTA415)	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.
Cleaner	International GTA822 (or International GTA415)	

Work Stoppages

Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA822 or 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 GTA822 or International GTA415. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency should 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.

PRODUCT CHARACTERISTICS

When Interdur 8808 is allowed to weather before topcoating ensure all zinc salts are removed prior to paint application and only topcoat with recommended materials.

When it is necessary for Interdur 8808 to be overcoated by itself due to low dry film thickness the coating surface must be fresh and unweathered. A minimum of 50 microns (2 mils) dft of any subsequent coat of Interdur 8808 is needed to ensure good film formation.

Excessive film thickness or overapplication of Interdur 8808 could lead to higher gloss and reduced performance. This will necessitate complete removal of the affected areas by abrasive blast cleaning and re-application in accordance with the specification.

In line with good painting practice, application should not take place in conditions which are deteriorating, e.g. dew point is falling or there is a risk of condensation forming.

When applying Interdur 8808 in confined spaces ensure adequate ventilation.

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

Low molecular weight reactive additives, which will form part of the film during normal ambient cure conditions, will also affect VOC values determined using EPA Method 24.

SYSTEMS COMPATIBILITY

Recommended topcoats/intermediates are:

- Interdur 8814
- Interdur 8840
- Interdur 8860
- Intergard 475HS

For other suitable topcoats/intermediates, consult International Protective Coatings.

ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at www.international-pc.com:

- 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 Safety Data Sheet and the container(s), and should not be used without reference to the Safety Data Sheet (SDS).

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 AkzoNobel for further advice.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	10 litre	8 litre	10 litre	2 litre	5 litre
	For availability of other pack sizes, contact AkzoNobel.				

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
	10 litre	15.4 kg	2.3 kg

STORAGE	Shelf Life	12 months at 25°C (77°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

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.

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