**Product Description**

A low VOC, two component high build, high solids surface tolerant epoxy maintenance coating.

Available in an aluminum pigmented version to provide additional anti-corrosive barrier protection.

**Intended Uses**

For application to a wide variety of substrates including hand prepared rusty steel, abrasive blast cleaned and hydroblasted steel, and a wide range of intact, aged coatings.

Provides excellent anti-corrosive protection in industrial, coastal structures, pulp and paper plants, bridges and offshore environments in both atmospheric exposure and immersion service.

**Practical Information for Interseal 670HS**

**Color**

Range

**Gloss Level**

Semi-gloss (Aluminum is eggshell)

**Volume Solids**

82% ±3% (depends on color)

**Typical Thickness**

4-8 mils (100-200 microns) dry equivalent to 4.9-9.8 mils (122-244 microns) wet

**Theoretical Coverage**

263 sq.ft./US gallon at 5 mils d.f.t. and stated volume solids

6.56 m²/liter at 125 microns d.f.t. and stated volume solids

**Practical Coverage**

Allow appropriate loss factors

**Method of Application**

Airless spray, Air spray, Brush, Roller

**Drying Time**

<table>
<thead>
<tr>
<th>Temperature (°F)</th>
<th>Touch Dry</th>
<th>Hard Dry</th>
<th>Overcoating Interval</th>
<th>Overcoating Interval with recommended topcoats</th>
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<tbody>
<tr>
<td>50°F (10°C)</td>
<td>8 hours</td>
<td>32 hours</td>
<td>Min</td>
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<td>12 weeks</td>
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<tr>
<td>59°F (15°C)</td>
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<td>26 hours</td>
<td>Min</td>
<td>Max*</td>
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<td>26 hours</td>
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<td>Max*</td>
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<td>4 weeks</td>
</tr>
<tr>
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<td>2 hours</td>
<td>6 hours</td>
<td>Min</td>
<td>Max*</td>
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<td>6 hours</td>
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<td>4 hours</td>
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<td>2 weeks</td>
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</table>

*For curing at low temperatures, an alternative curing agent is available. See Product Characteristics for details.
†Refer to atmospheric service only.
*See International Protective Coatings Definitions & Abbreviations.

**Flash Point**

Base (Part A) 97°F (36°C)

C/A (Part B) 133°F (56°C)

Mixed 91°F (33°C)

**Product Weight**

13.3 lb/ gal (1.6 kg/ l)

**VOC**

2.00 lb/ gal (240 g/ l) USA - EPA Method 24

175 g/ l UK - PG6/23(92), Appendix 3

Ecotech is an initiative by International Protective Coatings, a world leader in coating technology, to promote the use of environmentally sensitive products across the globe.
The performance of this product will depend upon the degree of surface preparation. The surface
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.

Accumulated dirt and soluble salts must be removed. Dry bristle brushing will normally be
adequate for accumulated dirt. Soluble salts should be removed by fresh water washing.

**Abrasive Blast Cleaning**

For immersion service, Interseal 670H S must be applied to surfaces blast cleaned to SSPC-SP10 or
Sa2½ (ISO 8501-1:1988). However, for atmospheric exposure best performance will be achieved
when Interseal 670H S is applied to surfaces prepared to a minimum of SSPC-SP6 or
Sa2½ (ISO 8501-1:1988).

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

A surface profile of 2-3 mils (50-75 microns) is recommended.

**Hand or Power Tool Preparation**

Hand or power tool clean to a minimum SSPC-SP2 or St2 (ISO 8501-1:1988).

Note, all scale must be removed and areas which cannot be prepared adequately by chipping or
needle gun should be spot blasted to a minimum standard of SSPC-SP6 or Sa2 (ISO 8501-1:1988).

Typically this would apply to C or D grade rusting in this standard.

**Ultra High Pressure Hydroblasting/ Abrasive Wet Blasting**

May be applied to surfaces prepared to SSPC-SP6 or Sa2½ (ISO 8501-1:1988) which have flash rusted
to no worse than Grade H8/B8/M (refer to International Hydroblasting Standards) or Grade S8/B8/M
(refer to International Slurry blasing Standards). It is also possible to apply to damp surfaces in
some circumstances. Further information is available from International Protective Coatings.

**Aged Coatings**

Interseal 670H S is suitable for overcoating a limited range of intact, tightly adherent aged coatings.
Loose or flaking coatings should be removed back to a firm edge. Glossy finishes may require light
abrasion to provide a physical ‘key’. See Product Characteristics section for further information.

### 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

5.67 parts : 1.00 part by volume

### Working Pot Life

<table>
<thead>
<tr>
<th>Temperature</th>
<th>Hours</th>
</tr>
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<tbody>
<tr>
<td>50°F (10°C)</td>
<td>5</td>
</tr>
<tr>
<td>59°F (15°C)</td>
<td>3</td>
</tr>
<tr>
<td>77°F (25°C)</td>
<td>2</td>
</tr>
<tr>
<td>104°F (40°C)</td>
<td>1</td>
</tr>
</tbody>
</table>

### Airless Spray

Recommended
- Tip range 18-23 thou (0.45-0.58 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 MBC or JGA
- Air Cap 704 or 765
- Fluid Tip E

### Brush

Recommended
Typically 4-5 mils (100-125 microns) can be achieved

### Roller

Recommended
Typically 3-4 mils (75-100 microns) can be achieved

### Thinner

International GTA415
(or GTA220)
May be necessary at low temperatures, see
Product Characteristics.
Do not thin more than allowed by local
environmental legislation.

### Cleaner

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.
In order to achieve optimum performance on hand prepared steel, the aluminum pigmented version should be applied as a primer coat by brush to ensure thorough wetting out of the substrate by Interseal 670HS.

For water immersion service, surface preparation to a minimum of SSPC-SP10 or Sa2½ (ISO 8501-1:1988) followed by application of multi-coats of Interseal 670HS to a total minimum dry film thickness of 10 mils (250 microns) is required.

Maximum film build in one coat is best attained by airless spray. When applying by methods other than airless spray, the required film build is unlikely to be achieved. Application by air spray may require a multiple cross spray pattern to attain maximum film build. Low or high temperatures may require specific application techniques to achieve maximum film build.

If salt water is used in the wet blast process the resulting surface must be thoroughly washed with fresh water before application of Interseal 670HS. With freshly blasted surfaces a slight degree of flash rusting is allowable, and is preferable to the surface being too wet. Puddles, ponding and accumulations of water must be removed.

Interseal 670HS is suitable for overcoating intact, aged alkyd, epoxy and polyurethane systems. However, this product is not recommended where thermoplastic coatings such as chlorinated rubbers and vinyls have previously been used. Please consult International Protective Coatings for alternative recommendations.

Surface temperature must always be a minimum of 5°F (3°C) above dew point.

Level of sheen and surface finish is dependent on application method. Avoid using a mixture of application methods whenever possible.

In common with all epoxies Interseal 670HS will chalk and discolor on exterior exposure. However, these phenomena are not detrimental to anti-corrosive performance.

Low Temperature Curing

A winter grade curing agent is also available to enable more rapid cure at temperatures less than 50°F (10°C).

Interseal 670HS is capable of curing at temperatures below 32°F (0°C). However, this product should not be applied at temperatures below 32°F (0°C) where there is a possibility of ice formation on the substrate.

Interseal 670HS can be used as a non-skid deck system by modification with addition of GMA132 (crushed flint) aggregate. Application should then be to a suitably primed surface. Typical thicknesses will be between 20-40 mils (500-1,000 microns). Preferred application is by a suitable large tip hopper gun (e.g. Sagola 429 or Air texture gun fitted with a 5-10 mm nozzle). Trowel or roller can be used for small areas. Alternatively, a broadcast method of application can be used. Consult International Protective Coatings for further details.

Interseal 670HS is certified to ANSI/NSF Standard 61 (selected colors only). Certification is for tanks greater than 100 gallons (378½ liters) and for pipes and valves which are 2 inches (5 cm) in diameter or greater.

Interseal 670HS will normally be applied to correctly prepared steel substrates. However, it can be used over suitably primed surfaces. Suitable primers are:

- Intercure 200
- Intergard 269
- Interplus 256
- Intergard 269
- Interplus 356
- Intergard 269
- Interzinc 315
- Intergard 740

Where a cosmetically acceptable topcoat is required the following products are recommended:

- Intercryl 530
- Interthane 870
- Interfine 629HS
- Interthane 990
- Intergard 740

Other suitable primers/topcoats are available. Consult International Protective Coatings.
Interseal® 670HS Surface Tolerant Epoxy

Additional Information

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following sections of the International Protective Coatings data manual:

- 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 Material Safety Data Sheet and the container(s), and should not be used without reference to the Material Safety Data Sheet (MSDS) which International Protective Coatings has provided to its customers.

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 International Protective Coatings for further advice.

Pack Size

<table>
<thead>
<tr>
<th>Pack Size</th>
<th>Interseal 670HS Base</th>
<th>Interseal 670HS Curing Agent</th>
</tr>
</thead>
<tbody>
<tr>
<td>5 gallon unit</td>
<td>4.25 gallons in a 5 gallon container</td>
<td>0.75 gallons in a 1 gallon container</td>
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<tr>
<td>20 liter unit</td>
<td>17 liters in a 20 liter container</td>
<td>3 liters in a 3.7 liter container</td>
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For availability of other pack sizes contact International Protective Coatings

Shipping Weight

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<tr>
<th>Shipping Weight</th>
<th>U.N. Shipping No.</th>
<th>1263</th>
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<tbody>
<tr>
<td>5 gallon unit</td>
<td>64.9 lb (29.4 kg) base (Part A)</td>
<td>6.8 lb (3.08 kg) curing agent (Part B)</td>
</tr>
<tr>
<td>20 liter unit</td>
<td>67.9 lb (30.8 kg) base (Part A)</td>
<td>7.6 lb (3.5 kg) curing agent (Part B)</td>
</tr>
</tbody>
</table>

Storage

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

Disclaimer

The information given in this sheet is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. Any warranty, if given, or specific Terms & Conditions of Sale are contained in International’s Terms & Conditions of Sale, a copy of which can be obtained on request. While we endeavor to ensure that all advice we give about the product (whether in this sheet or otherwise) is correct we have no control over either the quality or 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 whatsoever or howsoever arising for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of the use of the product. 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.

It is the user’s responsibility to check that this sheet is current prior to using the product. Issue date: 03/03/2003

International Protective Coatings Worldwide Availability

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<th>World Region</th>
<th>Asia Region</th>
<th>Australasia Region</th>
<th>Europe Region</th>
<th>Middle East Region</th>
<th>North America Region</th>
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<tr>
<td>World Centre</td>
<td>P.O Box 20980</td>
<td>3 Neythai Road, Jurong Town, Singapore 628570</td>
<td>P.O Box 20980, Oriel House, 16 Connaught Place, London, W2 2ZB, England</td>
<td>P.O Box 37, Damman, 31411, Saudi Arabia</td>
<td>6001 Antoine Drive, Houston, Texas 77091</td>
<td>Av Para 999, Navea, Sao Goncalo, Rio de Janeiro, Brazil</td>
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<tr>
<td>Americas</td>
<td>Tel: (44) 20 7479 6000</td>
<td>Tel: (65) 663 3066</td>
<td>Tel: (61) 7 3892 8888</td>
<td>Tel: (44) 20 7479 6000</td>
<td>Tel: (966) 3 812 1044</td>
<td>Tel: (55) 21 624 7100</td>
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<tr>
<td>Tel: (61) 7 3892 8888</td>
<td>Fax: (65) 266 5287</td>
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<td>Fax: (1) 713 684 1514</td>
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