

## **International Paint LLC**

# **Interbond 998, Two Pack Anticorrosive High Solids Epoxy Deck Primer**

### **PRODUCT DESIGNATIONS**

Part A: KRA920/922/924/925

Part B: KRA923

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MIL-PRF-23236

MIL-PRF-32171

MIL-PRF-32584

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If this product is to be applied as part of a coating system, all components of the system must be as listed on the QPL.

This NAVSEA-REVIEWED ASTM F-718 data sheet is the only data sheet approved for use when utilizing this coating for U.S. Navy preservation projects. NAVSEA's review covers only the application process for the material. The review does not denote the material as a qualified product, nor does it constitute an approval for purchase/procurement of the material. For products on the Qualified Products List (QPL) for this MILSPEC, please refer to <http://qpldocs.dla.mil/search/default.aspx>.

Questions regarding modifications or updates of this ASTM F-718 shall be directed toward:

NSWCPD

[NSWCPD\\_ASTM\\_F718.fct@navy.mil](mailto:NSWCPD_ASTM_F718.fct@navy.mil)

# ASTM F 718

## SHIPBUILDERS AND MARINE PAINTS AND COATINGS PRODUCT/PROCEDURE DATA SHEET

CONTINUATION SHEET USED: ☐ YES ☐ NO

Date: 11/2017

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<b>I. GENERIC TYPE AND DESCRIPTION:</b> Interbond 998, two pack anticorrosive high solids epoxy deck primer Specification Number: MIL-PRF-23236, MIL-PRF-32171, MIL-PRF-32584	
<b>II. MANUFACTURERS DATA:</b> (a) MANUFACTURER: International Paint LLC, 6001 Antoine Drive, Houston, TX 77091 (b) PRODUCT DESIGNATION: Part A: KRA920/922/924/925; Part B: KRA923 (c) COLOR(S): Haze Grey (KRA922), Dark Grey (KRA925), Terracotta Red (KRA924) , Off White (KRA920) (d) USES: Wet Spaces, ballast tanks, fuel tanks, bilges, machinery spaces, plenums, interior spaces, above and below the waterline (e) TECHNICAL SERVICE REPRESENTATIVE (Include Telephone Numbers): 1-800-525-6824 (or contact your local International Paint representative) (f) NOT INTENDED FOR USE IN: Potable Water tanks	
<b>III. PROPERTIES:</b> (a) PERCENT VOLUME SOLIDS (ASTM D2697): 90% $\pm$ 2% (b) PERCENT WEIGHT SOLIDS (ASTM D2369): 93% $\pm$ 2% (c) FLASH POINT (ASTM D3278): Part A 180°F, Part B 157°F, Mixed 170°F (d) WEIGHT PER VOLUME (ASTM D1475): Part A: 14.0 -14.6 lbs/gal (KRA922), 14.0-14.6 lbs/gal (KRA924), 13.89 – 14.30 (KRA925), 14.0-14.7 lbs/gal (KRA920) Part B: 8.30 -8.60 lbs/gal Mixed: 12.09-12.60 lbs/gal (KRA922), 12.15–12.60 lbs/gal (KRA924), 12.00–12.40 lbs/gal (KRA925), 12.20-12.65 lbs/gal (KRA920) (e) PERCENT EDGE RETENTION (IF REQUIRED BY APPLICABLE SPECIFICATION – LIST TEST METHOD USED): 70% minimum on 1mm radius (f) SHELF LIFE: 12 months (Part A and Part B) (g) VISCOSITY (ASTM D562): COMPONENT A: $\geq$ 141 KU @ 77°F COMPONENT B: 68 – 78 KU @ 77°F MIXED: 105 – 120 KU @ 77°F (h) PACKAGING: Part A: 2 gal in a 5 gal container; Part B 1 gal in a 1 gal container (i) NUMBER OF COMPONENTS: 2 (j) GLOSS (ASTM D523): 50 – 70 gloss units (60°) (k) STORAGE REQUIREMENTS: TEMPERATURE 40°F MIN. 100°F MAX. ADDITIONAL PAINT STORAGE REQUIREMENTS: Refer to Standard Item 009-32 (l) VOLATILE ORGANIC COMPOUNDS (VOCs- EPA TEST METHOD 24): 98 g/L, 0.82 lbs/gal (m) WEIGHT PER AREA OF DRY FILM AT 1 MIL THICKNESS: 0.0082 lb/sqft (n) SPECIAL PROPERTIES: Edge Retentive, High Solids, Moisture Tolerant	

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## IV. SURFACE PREPARATION MINIMUM REQUIREMENTS:

- (a) INITIAL: Abrasive Blast to SSPC-SP 10 or Hydroblasting to SSPC SP WJ-2 L or M
- (b) TOUCH-UP: Waterjet to SSPC-SP WJ-2L or M / NACE WJ-2 L or M (Formerly SSPC-SP 12 / NACE 5) or mechanical clean to SSPC-SP 2, SP 3, or SP 11 as appropriate. Abrade surrounding areas and feather edges
- (c) PROFILE (INCLUDE METHOD USED): 2 mils MIN. 6 mils MAX. (Profilometer Gauge or Testex Replica Tape)
- (d) SPECIAL INSTRUCTIONS: N/A
- (e) PRIMER REQUIREMENTS: N/A
- (f) MAXIMUM ALLOWABLE CONDUCTIVITY: 10µg/cm<sup>2</sup> Perform the extraction according to ISO8502-6: 2006 "Extraction of soluble contaminants for analysis - The Bresle Method", followed by ISO8502-9:1998 "Field Method for the Conductimetric Determination of water-soluble salts".
- (g) MAXIMUM DEGREE OF FLASH RUSTING ALLOWED: SSPC-SP WJ-2 M / NACE WJ-2 M

## SPECIAL SAFETY PRECAUTIONS:

PLEASE REFER TO MATERIAL SAFETY DATA SHEET

## V. MIXING PROCEDURES:

- (a) MIXING RATIOS BY WEIGHT: 3.4:1 (A:B)  
BY VOLUME: 2:1 (A:B)
- (b) INDUCTION TIME: None
- (c) RECOMMENDED CLEANING SOLVENT (NO THINNING ALLOWED): GTA415 or GTA220
- (d) POT LIFE:
- 90 Min(s) @ 41°F
- 75 Min(s) @ 50°F
- 60 Min(s) @ 77°F
- 45 Min(s) @ 95°F
- (e) SPECIAL INSTRUCTIONS: Pre-mix Part A one minute using appropriate drill and Jiffy blade or equivalent suitable for a 5 gallon container. Empty Part B into Part A and mix three minutes using appropriate drill and Jiffy blade or equivalent suitable for a 5 gallon container

## VI. APPLICATION:

## (a) ENVIRONMENTAL LIMITATIONS:

SUBSTRATE TEMPERATURE: 50°F MIN. 120° F MAX.  
 AMBIENT TEMPERATURE: 41°F MIN. 100° F MAX.

MINIMUM SUBSTRATE TEMPERATURE DIFFERENCE ABOVE THE DEW POINT: 5°F  
 (Note: This item is not applicable when the product is being applied as a Type VII Class 17 system.)

MAXIMUM PERCENT RELATIVE HUMIDITY: Refer to NAVSEA Standard item 009-32  
 (Note: This item is not applicable when the product is being applied as a Type VII Class 17 system.)

- (b) FILM THICKNESS (SSPC PA2-73T) - PER COAT:  
 WET MIN. 6.7 mils WET MAX. 22 mils

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DRY MIN. 6 mils

DRY MAX. 20 mils

TOTAL SYSTEM: 40mil DFT maximum

Single Coat:

WET MIN. 20

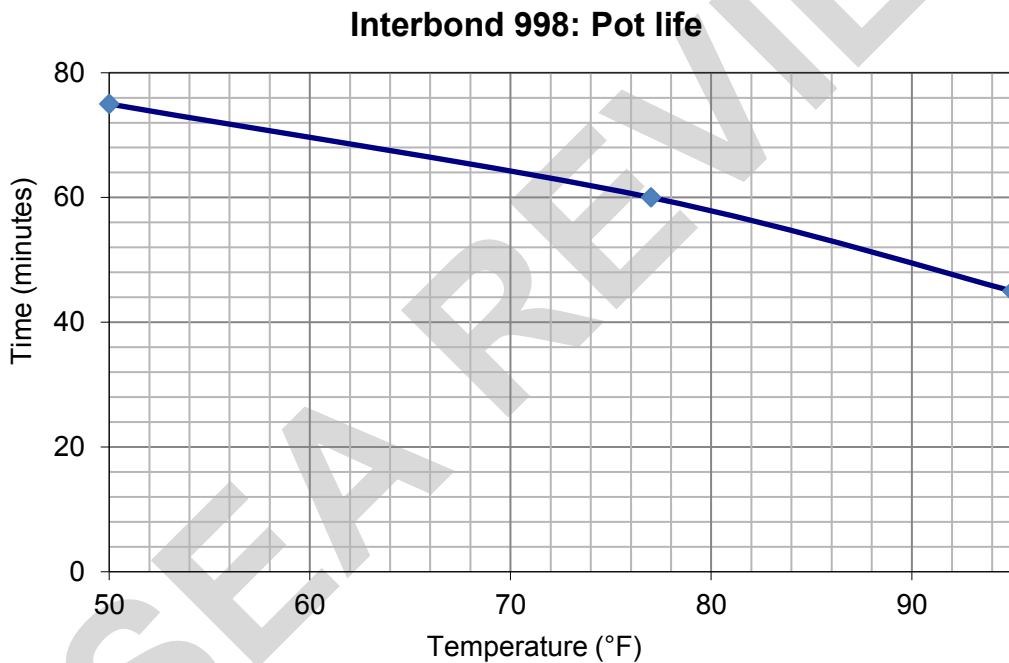
WET MAX. 22

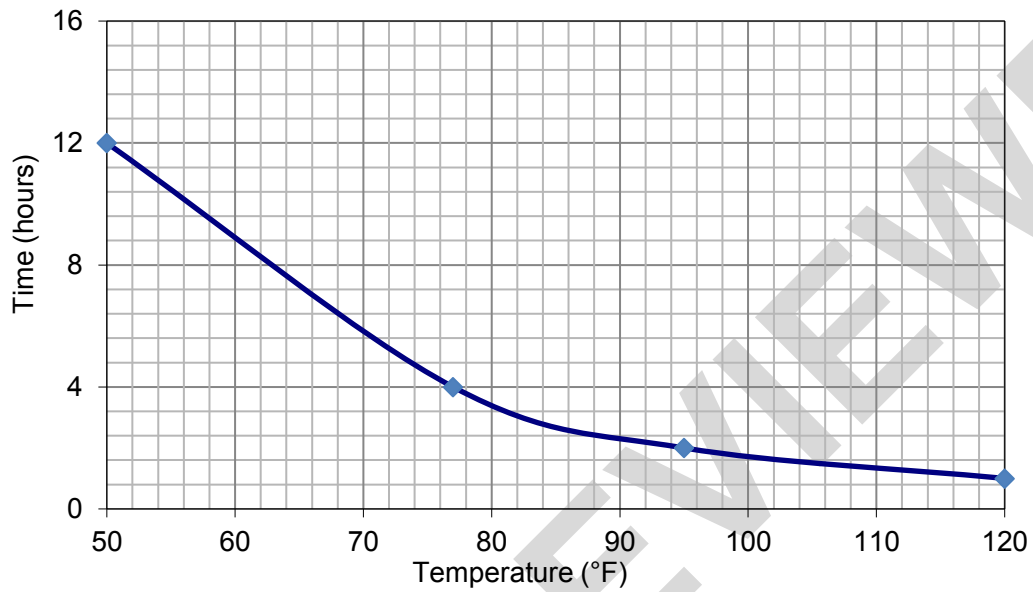
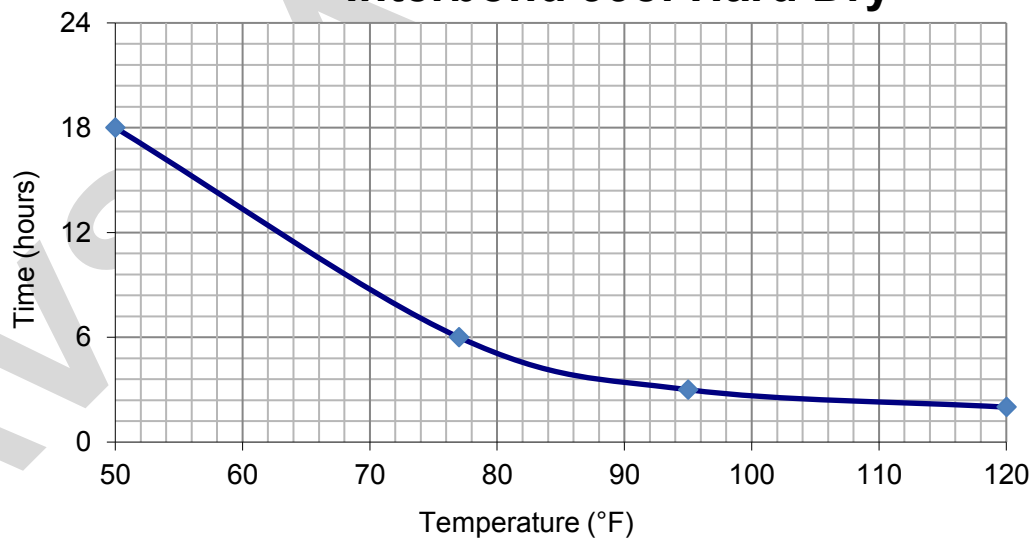
DRY MIN. 18

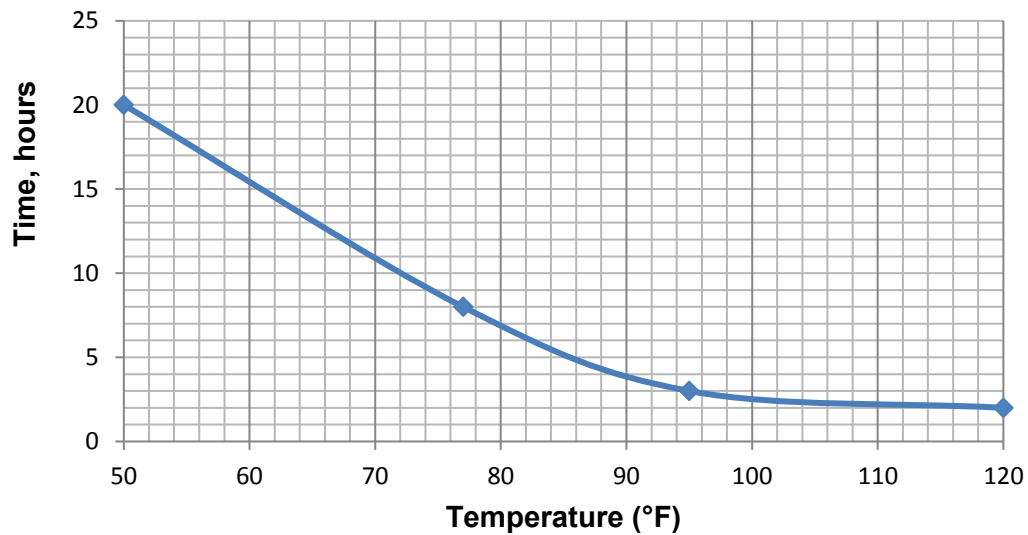
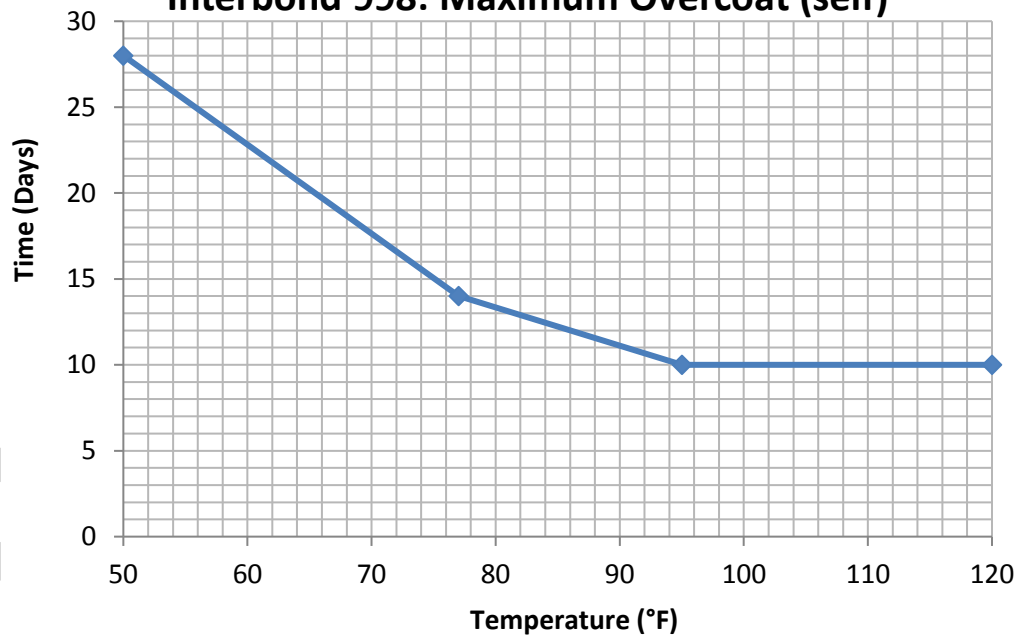
DRY MAX. 20

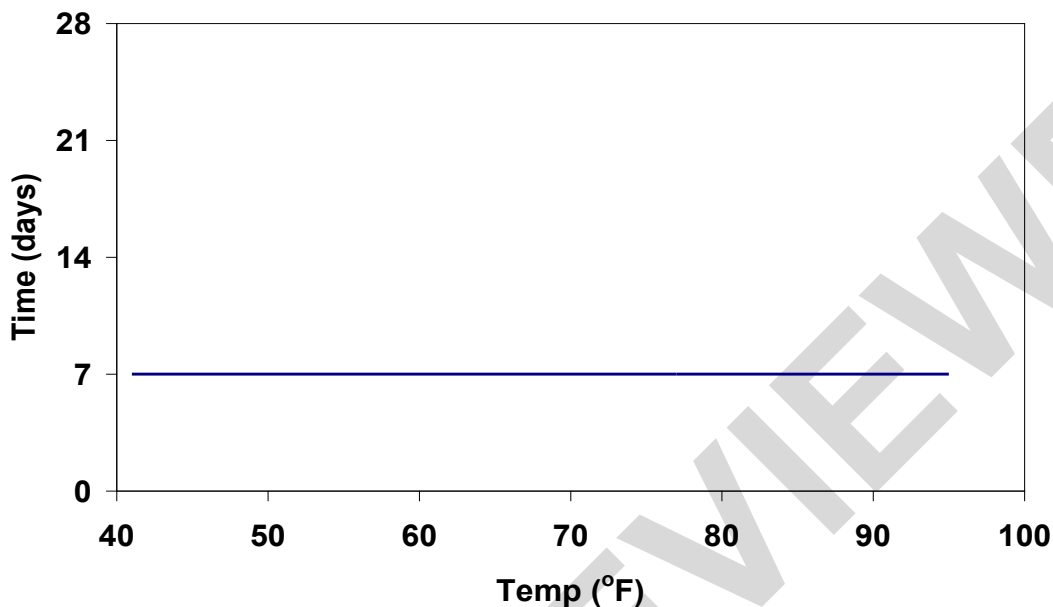
NOTE: Interbond 998 can be applied in a single-coat up to 20mils DFT. When applied as a single coat, a stripe coat is recommended to ensure proper thickness on edges and angles. Per STD item 009-32, stripe coats are not required although additional thickness measurements must be taken to ensure proper thicknesses on edges and angles. Applicators are cautioned as coating thickness increases above 20 mils DFT the risk of runs, drips, and sags increases.

(c) DRY TIMES (ASTM D1640): See below Graphs



**Interbond 998: Touch Dry****Interbond 998: Hard Dry**

**Interbond 998: Minimum Overcoat (self)****Interbond 998: Maximum Overcoat (self)**

**Interbond 998: Time to Immersion**

(d) EQUIPMENT REQUIREMENTS: Airless Spray recommended. Use a 70:1 ratio or greater pump with .015" - .019" tip. Roller (3/8 - 3/4" nap) or Brush for touch up only. Stripe coats can be applied via brush, roller or spray.

(e) SPECIAL INSTRUCTIONS: N/A

IF OVERCOAT WINDOW HAS BEEN EXCEEDED FOR CRITICAL APPLICATIONS: If the overcoat window has been exceeded, Clean surface of coating per SSPC-SP 1, aggressively abrade surface with 80 grit sandpaper or equivalent to promote adhesion, clean surface to SSPC-SP 1 again.

## ADDITIONAL DATA/INSTRUCTIONS:

## II. MANUFACTURERS DATA:

## III. PROPERTIES:

IV. SURFACE PREPARATION MINIMUM REQUIREMENTS: Cleaning via UHP-WJ does not create an anchor tooth profile. Additional blasting may be necessary to create an acceptable specified profile prior to application of approved primer

## V. MIXING PROCEDURES:

## VI. APPLICATION REQUIREMENTS:

Dry times are normally a function of humidity, ventilation and temperature. Information given is to be used as a guideline only. When substrate temperatures fall below 50°F after application, the Interbond 998 Primer dry time is retarded requiring additional dry time. Applicators must take this into consideration before the next coating process is started in allowing for sufficient dry time.

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For crew use Interbond 998 can be overcoated with Interfine 979SG. Application of the Interfine 979SG over the Interbond 998 must occur between thumb print tacky and maximum 24 hours.

The technical data given herein has been compiled for your assistance and guidance. It is based upon our experience and knowledge. However, as we have no control over the use to which this information is put, no warranty, expressed or implied, is intended or given.