

Water Borne Acrylic

PRODUCT DESCRIPTION A single component water borne finish formulated on weather resistant acrylic copolymer technology.

INTENDED USES

Primarily designed as a durable finish coat for use over water borne primers and intermediates where colour and gloss retention are important.

Can also be used over some solvent based primers and intermediates.

For exposure in a wide variety of environments, including offshore structures, bridges, refineries, petrochemical and chemical plants.

Suitable for use during new construction or maintenance and repair.

PRACTICAL INFORMATION FOR INTERCRYL 530

Colour	Range of colours via the Chromascan system			
Gloss Level	Gloss			
Volume Solids	35% ± 2% (depends on colour)			
Typical Thickness	50-77 microns (2-3.1 mils) dry equivalent to 143-220 microns (5.7-8.8 mils) wet			
Theoretical Coverage	7 m ² /litre at 50 microns d.f.t and stated volume solids 281 sq.ft/US gallon at 2 mils d.f.t and stated volume solids			
Practical Coverage	Allow appropriate loss factors			
Method of Application	Airless Spray, Air Spray, Brush, Roller			
Drying Time	Overcoating interval with self			
Temperature	Touch Dry	Hard Dry	<i>Minimum</i>	<i>Maximum</i>
10°C (50°F)	1 hour	6 hours	6 hours	Extended ¹
15°C (59°F)	1 hour	5 hours	5 hours	Extended ¹
25°C (77°F)	30 minutes	4 hours	4 hours	Extended ¹
40°C (104°F)	15 minutes	3 hours	3 hours	Extended ¹

¹ See International Protective Coatings Definitions and Abbreviations
Drying times are dependent upon ambient conditions. The figures quoted above have been determined at the quoted temperature and 50% relative humidity.

REGULATORY DATA

Flash Point (Typical)	Part A >101°C (214°F)		
Product Weight	1.25 kg/l (10.4 lb/gal)		
VOC	0.35 lb/gal (43 g/lit)	EPA Method 24	

See Product Characteristics section for further details

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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 ISO 8504:2000.

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Strict adherence to all cleanliness standards is essential for application of water based coatings

Primed Surfaces

Intercryl 530 should always be applied over a recommended anti-corrosive coating scheme. The primer surface should be dry and free from all contamination and Intercryl 530 must be applied within the overcoating intervals specified (consult the relevant product data sheet).

Areas of breakdown, damage etc., should be prepared to the specified standard (e.g. Sa2½ (ISO 8501-1:2007) or SSPC-SP6, Abrasive Blasting, or SSPC-SP11, Power Tool Cleaning) and patch primed prior to the application of Intercryl 530.

APPLICATION

Mixing	This material is a one component coating and should always be mixed thoroughly with a power agitator before application.		
Airless Spray	Recommended	Tip Range 0.38-0.53 mm (15-21 thou) Total output fluid pressure at spray tip not less than 126 kg/cm ² (1792 p.s.i.)	
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E
Brush	Suitable	Typically 30-50 microns (1.2-2.0 mils) can be achieved	
Roller	Suitable	Typically 30-50 microns (1.2-2.0 mils) can be achieved	
Thinner	Clean Water / International GTA991		
Cleaner	Clean Water / International GTA991		
Work Stoppages	Thoroughly flush all equipment with International GTA991. All unused material should be stored in tightly closed containers. Partially filled containers may show surface skinning and/or a viscosity increase of the material after storage. Material should be filtered prior to use.		
Clean Up	Clean all equipment immediately after use with clean water followed by International GTA991. 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 material and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.		

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PRODUCT CHARACTERISTICS

Apply by air or airless spray. Thoroughly flush equipment with International GTA991 thinner, or alcohol, followed by water prior to use. To obtain maximum edge protection and film build, airless or air spray application is recommended. Application by other methods, e.g. brush or roller, may require more than one coat.

As with all water borne coatings careful control of application conditions is required to ensure good performance.

The following basic parameters must be adhered to:

Intercryl 530 must be protected from freezing at all times during storage.

The minimum steel temperature for application must be above 10°C (50°F), and be at least 3°C (5°F) above dew point.

The relative humidity should be lower than 70% otherwise drying and overcoating times will be severely extended.

Good airflow is essential around the object being painted [minimum air speed 0.1m/sec (4 inches/sec)].

Minor areas which are difficult to ventilate should be brush applied to prevent over-application.

Application below the minimum film forming temperature (M.F.F.T.) of the coating and/or poor ventilation will result in poor film coalescence and a powdery cracked film which will require removal and re-application.

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

For brush and roller application, and in some colours, two coats of Intercryl 530 may be required to give uniform coverage.

Intercryl 530 must be fully hardened before exposing to ponding water otherwise adhesion loss can occur.

Although Intercryl 530 is slightly thermoplastic above 50°C (120°F) the polymer system is stable to continuous temperatures of 150°C (300°F) with intermittent temperatures of 200°C (390°F).

This product has the following specification approvals:

- USDA approval for incidental food contact surface in federally inspected meat and poultry plants. Subject to Inspector-In-Charge approval.

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.

SYSTEMS COMPATIBILITY

This product is primarily designed for use as a finish over water based priming systems such as:

InterH2O 280
InterH2O 401

However, it is also suitable for application to a number of solvent based products

Intercure 200	Interseal 670HS
Intercure 420	Interzinc 12 (mist coat or tie coat may be required)*
Intergard 251	Interzinc 22 (mist coat or tie coat may be required)*
Intergard 269	Interzinc 42
Intergard 475HS	Interzinc 52
Interprime 198	Interzinc 315

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

See relevant product data sheet for details.

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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 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	Unit Size	
	Vol	Pack
	20 litre	20 litre
	5 US gal	5 US gal
For availability of other pack sizes, contact International Protective Coatings.		
SHIPPING WEIGHT (TYPICAL)	Unit Size	
	20 litre	26.9 kg
	5 US gal	55.5 lb
STORAGE	Shelf Life	18 months minimum at 25°C (77°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition. Protect from freezing at all times during storage.

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.

This Technical Data Sheet is available on our website at www.international-marine.com or www.international-pc.com, and should be the same as this document. Should there be any discrepancies between this document and the version of the Technical Data Sheet that appears on the website, then the version on the website will take precedence.

Issue date: 05/02/2015

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