

Polyurethane

PRODUCT DESCRIPTION

A three component acrylic polyurethane, giving excellent durability with an aluminium finish.

INTENDED USES

Suitable for use both in new construction and as a maintenance finish. Meets the market requirement for metallic finish.

PRACTICAL INFORMATION FOR INTERTHANE 1044

Colour	Aluminium			
Gloss Level	Metallic			
Volume Solids	50% ± 2%			
Typical Thickness	50 microns (2 mils) dry equivalent to 100 microns (4 mils) wet			
Theoretical Coverage	10 m ² /litre at 50 microns d.f.t and stated volume solids 401 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)	6 hours	30 hours	30 hours	60 hours
15°C (59°F)	5 hours	24 hours	24 hours	52 hours
25°C (77°F)	4 hours	8 hours	8 hours	48 hours
40°C (104°F)	3 hours	7 hours	7 hours	44 hours

REGULATORY DATA

Flash Point (Typical) Part A 23°C (73°F); Part B 23°C (73°F); Part C 23°C (73°F); Mixed 23°C (73°F)

Product Weight 1.08 kg/l (9.0 lb/gal)

VOC 450 g/l Calculated

See Product Characteristics section for further details

Protective Coatings

Polyurethane

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 Petrobras Standard N-5.

Primed Surfaces

The primer surface should be dry and free from all contamination and Interthane 1044 must be applied within the overcoating intervals specified (consult the relevant product data sheet).

APPLICATION

Mixing	Material is supplied in three 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.		
	<ol style="list-style-type: none"> (1) Agitate Base (Part A) with a power agitator. (2) Agitate Curing Agent (Part B) with a power agitator. (3) Combine entire contents of Base (Part A), Curing Agent (Part B) and Accelerator (Part C) and mix thoroughly with power agitator. 		
Mix Ratio	3.6 part(s) : 1 part(s) : 0.4 part(s) by volume		
Working Pot Life	10°C (50°F) 6 hours	15°C (59°F) 5 hours	25°C (77°F) 40°C (104°F) 4 hours 3 hours
Airless Spray	Recommended	Tip Range 0.33-0.45 mm (13-18 thou) Total output fluid pressure at spray tip not less than 155 kg/cm ² (2204 p.s.i.)	
Air Spray (Pressure Pot)	Recommended	Thinning may be required.	
Brush	Suitable - Small touch-up areas only		
Roller	Suitable - Small touch-up areas only	Multiple coats may be required to achieve specified film thickness.	
Thinner	Not recommended	Use International GTA713 only in exceptional circumstances (maximum 5% by volume). Do not thin more than allowed by local environmental legislation.	
Cleaner	International GTA713		
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA713. 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 GTA713. 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.		

Polyurethane

PRODUCT CHARACTERISTICS

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

Best results in terms of gloss and appearance will always be obtained by conventional air spray application.

Apply in good climatic conditions. The temperature of the surface to be coated must be at least 3°C (5°F) above the dew point.

Unmixed material (in closed containers) should be maintained in protected storage in accordance with information given in the Storage section of this datasheet.

Do not apply if relative humidity exceeds 85%.

Interthane 1044 should be applied within the specified overcoating intervals (consult the relevant product datasheet), otherwise coating adhesion may be affected.

Drying times are dependent upon ambient conditions and film thicknesses applied.

Dry film thicknesses greater than specified should be avoided to prevent solvent retention.

This product has the following specification approvals:

- Petrobras Standard N-2677

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

Interthane 1044 should only be topcoated with itself, and should never be overcoated with another product.

Consult International Protective Coatings regarding specific recommendations.

Polyurethane

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

Warning: Contains isocyanate. Wear air-fed hood for spray application.

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	Part A		Part B		Part C	
		Vol	Pack	Vol	Pack	Vol	Pack
	3.6 litre	2.58 litre	3.6 litre	0.72 litre	0.9 litre	0.3 litre	0.9 litre
	20 litre	14.4 litre	20 litre	4 litre	5 litre	1.6 litre	3.6 litre
For availability of other pack sizes, contact International Protective Coatings.							
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B		Part C	
	3.6 litre	2.91 kg		0.9 kg		0.55 kg	
	20 litre	15.67 kg		4.78 kg		2.73 kg	
STORAGE	Shelf Life	12 months minimum 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.

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.

Copyright © AkzoNobel, 05/02/2015.

All trademarks mentioned in this publication are owned by, or licensed to, the AkzoNobel group of companies.

www.international-pc.com