Intercryl® 853

Acrylic

PRODUCT DESCRIPTION

A heavy duty water borne acrylic coating.

Excellent weather resistance.

Outstanding gloss and colour retention over extended periods.

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 in both new construction and industrial maintenance situations.

PRACTICAL INFORMATION FOR INTERCRYL 853

Colour	Limited pastel range.
Gloss Level	Gloss
Volume Solids	40%
Typical Thickness	25-50 microns (1-2 mils) dry equivalent to 63-125 microns (2.5-5 mils) wet
Theoretical Coverage	16 m²/litre at 25 microns d.f.t and stated volume solids 642 sq.ft/US gallon at 1 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 recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
10°C (50°F)	2 hours	36 hours	18 hours	Extended[1]
15°C (59°F)	105 minutes	26 hours	12 hours	Extended[1]
25°C (77°F)	90 minutes	12 hours	7 hours	Extended[1]
40°C (104°F)	30 minutes	6 hours	5 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 60% relative humidity

REGULATORY DATA

Flash Point (Typical)	>65°C (>149°F)
Product Weight	1.26 kg/l (10.5 lb/gal)
VOC	83 g/l (0.69 lb/gal) (Calculated) 185 g/l (1.54 lb/gal)(water reduced)

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 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 853 should always be applied over a recommended anti-corrosive coating scheme. The primer surface should be dry and free from all contamination and Intercryl 853 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 853.

Concrete and Cement
Concrete should be cured for a minimum of 28 days prior to coating and cement should be cured for a minimum of 14 days prior to coating. The moisture content of the concrete should be below 6%. All surfaces should be clean, dry and free from curing compounds, release agents, trowelling compounds, surface hardeners, efflorescence, grease, oil, dirt, old coatings and loose or disintegrating concrete. All poured and precast concrete must also be sweep blasted (preferred) or acid etched to remove laitence.

Large cracks should be filled with the appropriate filler. When coating new tilt formed concrete an epoxy sealer must be employed. When coating new cement thin the first coat up to 15% with fresh clean water.

Galvanised Steel
Degrease to SSPC-SP1 and remove any white zinc corrosion products by hand abrasion cleaning. Weathered galvanised steel should have areas of red rust wire brushed to remove loose rust and spot primed with Interzinc 52 or Interplus 356 and degreased as above.

APPLICATION

Mixing	This material is a one component coating and should always be mixed thoroughly with a power agitator before application.		
Mix Ratio	Not applicable		
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/cm² (1792 p.s.i.)	
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E
Brush	Suitable - small areas only	Typically 50-75 microns (2.0-3.0 mils) can be achieved	
Roller	Recommended	Typically 50-75 microns (2.0-3.0 mils) can be achieved	
Thinner	Clean Water		
Cleaner	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 International GTA991. 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 material and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

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 853 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 853 may be required to give uniform coverage.

Intercryl 853 must be fully hardened before exposing to ponding water otherwise adhesion loss can occur.

Although Intercryl 853 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).

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

Intercryl 853 can be overcoated with a wide range of products, including:

Water borne:

- Intergard 270
- InterH2O 280
- InterH2O 401

Solvent borne:

Intercure 200	Interseal 670HS
Intercure 420	Interseal 2020
Intergard 251	Interzinc 12*
Intergard 269	Interzinc 22*
Intergard 475	Interzinc 42
Intergard 475HS	Interzinc 52
Interprime 198	Interzinc 315

*mist coat may be required

For other suitable primers/topcoats, 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 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	20 litre
4 litre	20 litre	4 litre

For availability of other pack sizes, contact International Protective Coatings.

SHIPPING WEIGHT (TYPICAL)

Unit Size	
20 litre	27.1 kg
4 litre	5.4 kg

STORAGE

Shelf Life: 24 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

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