

Direct to Metal Polyaspartic

PRODUCT DESCRIPTION

Intercure 99NA polyaspartic technology is applied as a single coat at 150-250 microns (6-10 mils) direct-to-metal using standard application equipment, reducing application time and labour costs compared to two coat applications in moderately corrosive environments (up to C3, ISO 12944-2).

Intercure 99NA is a low VOC, high solids, rapid cure primer/finish, offering excellent anticorrosive protection and long term colour and gloss durability – a combination that cannot be achieved with alternative fast cure, single coat primer finishes.

Intercure 99NA may also be specified as a high build, durable intermediate/finish over approved anti-corrosive primers for more aggressive environments, i.e. ISO 12944 C4 and C5M.

INTENDED USES

Intercure 99NA is intended for use as a single coat high performance finish. For structural steel applications, a reduced number of coats aids in yard throughput and productivity. Rapid cure and early handling properties make it ideal for applications such as wind towers, transformers, mining equipment and pumps where productivity and drying space are of prime importance.

PRACTICAL INFORMATION FOR INTERCURE 99NA

Colour	Wide range via the Chromascan system
Gloss Level	Gloss
Volume Solids	80% ± 1%
Typical Thickness	150-250 microns (6-10 mils) dry equivalent to 188-313 microns (7.5-12.5 mils) wet
Theoretical Coverage	4.60 m ² /litre at 175 microns d.f.t and stated volume solids 183 sq.ft/US gallon at 7 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Air Spray
Drying Time	

Overcoating interval with self

Temperature	Touch Dry	Hard Dry	Minimum	Maximum
5°C (41°F)	1.5 hours	3 hours ¹	3 hours	Extended ²
15°C (59°F)	45 minutes	2.5 hours ¹	2.5 hours	Extended ²
25°C (77°F)	30 minutes	1.5 hours ¹	1.5 hours	Extended ²
40°C (104°F)	30 minutes	1.5 hours ¹	1.5 hours	Extended ²

¹ Drying times quoted relate to 50% R.H. Increased humidity may result in faster drying times.

² See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical)	Part A 39°C (102°F); Part B 81°C (178°F); Mixed 39°C (102°F)
Product Weight	1.28 kg/l (10.7 lb/gal)
VOC	1.62 lb/gal (195 g/l) 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.

Abrasive Blast

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of Intercure 99NA, the surface should be reblasted to the specified visual standard.

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

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

Primed Surfaces

Intercure 99NA can be applied over approved anti-corrosive primers. The primer surface should be dry and free from all contamination and Intercure 99NA 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 and patch primed prior to the application of Intercure 99NA.

APPLICATION

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	2 part(s) : 1 part(s) by volume			
Working Pot Life	5°C (41°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
	2.5 hours	2 hours	75 minutes	60 minutes
Airless Spray	Recommended	Tip Range 0.38-0.48 mm (15-19 thou) Total output fluid pressure at spray tip not less than 176 kg/cm ² (2503 p.s.i.)		
Air Spray (Pressure Pot)	Recommended	Gun	DeVilbiss MBC or JGA	
		Air Cap	704 or 765	
		Fluid Tip	E	
Air Spray (Conventional)	Recommended	Use suitable proprietary equipment		
Brush	Suitable - small areas only	Typically 100-150 microns (4.0-6.0 mils) can be achieved		
Roller	Suitable - small areas only			
Thinner	International GTA713 (or International GTA056)	Do not thin more than allowed by local environmental legislation. Do not use alternative thinners.		
Cleaner	International GTA713 (or International GTA056)	Do not use alternative cleaners.		
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.			

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PRODUCT CHARACTERISTICS

The detailed Intercure 99NA Application Guidelines should be consulted prior to use.

During the spray application of Intercure 99NA at high relative humidity (>85%), a reduction in the quoted pot life time of the mixed material may occur. This can be resolved by placing sufficient solvent to cover the surface of the material in the can. The addition of approx 100 mls of GTA713 or GTA056 per 20 litre mixed unit should suffice.

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

For tinted colours, a 5 minute induction time is recommended to fully develop colour. Failure to allow induction, particularly at low temperatures, may result in inconsistency of the finished shade.

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.

When applying Intercure 99NA by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

Care should be exercised to avoid application in excess of 350 microns (14 mils) dry film thickness.

Application at excessively high relative humidity, or under conditions where condensation is likely to occur, may result in immediate or premature loss of gloss. It is recommended that relative humidity should not exceed 85% during application and cure.

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

Application at humidities greater than 50% may result in faster drying times.

When applying Intercure 99NA in confined spaces ensure adequate ventilation.

Intercure 99NA is not designed for continuous water immersion.

As with other fast dry coating systems care should be taken to prevent overspray contamination of previously coated work pieces.

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

Intercure 99NA may be applied direct to metal for atmospheric exposure in environments up to and including C3 (as defined in ISO12944 Part 2). When using Intercure 99NA in atmospheric environments classed as C4 or C5, a recommended primer must be used.

Suitable primers are:

Intergard 269

Suitable primer(s) for ISO 12944 C4 environment are:

Intercure 200HS

Suitable primer(s) for ISO 12944 C5 environment are:

Interzinc 52

Intercure 99NA must not be applied directly over Interzinc 52 low temperature grade cure.

Absolute maximum overcoating intervals with Intercure 99NA are dependent upon primer. Intercure 99NA Recommended Working Procedures must be consulted prior to use. Intercure 99NA should only be overcoated with itself.

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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
- Intercure 99NA Application Guidelines

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.

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

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	3 US gal	2 US gal	3.5 US gal	1 US gal	1 US gal
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
		25 lb		10 lb	
	3 US gal				
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.

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