

Alkyd

PRODUCT DESCRIPTION

A one component, alkyd resin based anti-corrosive primer containing zinc phosphate pigment.
Contains no toxic or environmentally hazardous lead or chromate based pigments.

INTENDED USES

A general purpose anti-corrosive primer suitable for brush, roller or airless application to hand prepared or blast cleaned steel.

Suitable for use in new construction as a one or two coat on site primer on hand prepared steel, or for site touch-up of shop primed steel, which is to be overcoated with conventional type topcoats.

PRACTICAL INFORMATION FOR INTERPRIME 312

| | |
|------------------------------|---|
| Colour | Red, Green Grey |
| Gloss Level | Matt |
| Volume Solids | 50% |
| Typical Thickness | 50-75 microns (2-3 mils) dry equivalent to 100-150 microns (4-6 mils) wet |
| Theoretical Coverage | 6.70 m ² /litre at 75 microns d.f.t and stated volume solids 267 sq.ft/US gallon at 3 mils d.f.t and stated volume solids |
| Practical Coverage | Allow appropriate loss factors |
| Method of Application | Airless Spray, Brush, Roller |

Drying Time

| Temperature | Touch Dry | Hard Dry | Overcoating Interval with recommended topcoats | |
|--------------|-----------|-----------|--|-----------------------|
| | | | Minimum | Maximum |
| 10°C (50°F) | 6 hours | 24 hours | 24 hours | Extended ¹ |
| 15°C (59°F) | 4 hours | 16 hours | 24 hours | Extended ¹ |
| 25°C (77°F) | 1.5 hours | 7.5 hours | 16 hours | Extended ¹ |
| 40°C (104°F) | 1 hour | 4 hours | 16 hours | Extended ¹ |

¹ See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

| | | |
|------------------------------|-------------------------|---------------|
| Flash Point (Typical) | >33°C (>91°F) | |
| Product Weight | 1.30 kg/l (10.8 lb/gal) | |
| VOC | 3.39 lb/gal (407 g/l) | EPA Method 24 |

See Product Characteristics section for further details

Alkyd

SURFACE PREPARATION

The performance of this product will depend upon the degree of surface preparation. The surface to be coated must be clean, dry and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2000.

Accumulated dirt and soluble salts must be removed. Dry bristle brushing will normally be adequate for accumulated dirt. Soluble salts should be removed by fresh water washing.

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

Abrasive Blast Cleaning

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of Interprime 312, 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.

Interprime 312 is suitable for application to blast cleaned surfaces which were initially to the above standard but have been allowed to deteriorate under good shop conditions for up to 7-10 days. The surface may deteriorate to Sa2 standard but must be free from loose powdery deposits.

Hand Preparation

The product is designed for application to surfaces prepared to St2 (ISO 8501-1:2007) or SSPC-SP2. When using power tools care should be taken to avoid surface polishing. The product may also be applied to surfaces which have been sweep blasted to Sa2. On poor surfaces brush application will assist performance.

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 0.46-0.53 mm (18-21 thou) Total output fluid pressure at spray tip not less than 190 kg/cm ² (2702 p.s.i.) |
| Air Spray (Pressure Pot) | Not recommended | |
| Brush | Recommended | Typically 50 microns (2.0 mils) can be achieved |
| Roller | Recommended | Typically 50 microns (2.0 mils) can be achieved |
| Thinner | International GTA004 | Do not thin more than allowed by local environmental legislation |
| Cleaner | International GTA004 | |
| Work Stoppages | Thoroughly flush all equipment with International GTA004. 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 GTA004. 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. | |

Alkyd

PRODUCT CHARACTERISTICS

In order to ensure good anti-corrosive performance, it is important to achieve a minimum system dry film thickness of 150 microns (6 mils) by application of multi-coats over hand prepared steel.

Anti-corrosive performance on hand prepared steel is related directly to both the degree of surface preparation and the dry film thickness of the system applied.

This product is not intended for use in aggressive, corrosive environments, or on heavily pitted or contaminated steel.

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

Over-application of Interprime 312 will extend both the minimum overcoating periods and handling times, and may be detrimental to long term overcoating properties.

Interprime 312 is not designed for continuous water immersion.

Interprime 312 is not suitable for exposure to acid or alkaline environments.

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

The following primer is recommended for Interprime 312:

Interplate 408

The following topcoats are recommended for Interprime 312:

Interlac 87
Interlac 665

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

Alkyd

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 |
| | 5 litre | 5 litre | 5 litre |
| 20 litre | 20 litre | 20 litre | |

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

| SHIPPING WEIGHT (TYPICAL) | Unit Size | |
|---------------------------|-----------|--------|
| | | |
| | 5 litre | 6.9 kg |
| 20 litre | 27.5 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