

Water Based Acrylic

PRODUCT DESCRIPTION A VOC compliant, single component, water based anti-corrosive primer/finish based on weather resistant acrylic copolymer technology.

INTENDED USES Designed for use as a primer/finish for structural steel, in a wide variety of general industrial environments of light to moderate corrosivity, including on bridges, commercial buildings, infrastructure and manufacturing plants.

Exhibits excellent colour and gloss retention.

PRACTICAL INFORMATION FOR INTERCRYL 525

Colour Wide range via the Chromascan system

Gloss Level Eggshell

Volume Solids 47% ± 2%

Typical Thickness 50-100 microns (2-4 mils) dry equivalent to 106-213 microns (4.2-8.5 mils) wet

Theoretical Coverage 6.30 m²/litre at 75 microns d.f.t and stated volume solids
251 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, Air Spray, Brush, Roller

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
10°C (50°F)	2 hours	6 hours	16 hours	Extended ¹
15°C (59°F)	1 hour	3 hours	12 hours	Extended ¹
25°C (77°F)	30 minutes	2 hours	8 hours	Extended ¹
40°C (104°F)	15 minutes	1 hour	4 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) >101°C (>214°F)

Product Weight 1.31 kg/l (10.9 lb/gal)

VOC 14 g/kg EU Solvent Emissions Directive (Council Directive 1999/13/EC)

See Product Characteristics section for further details

Water Based Acrylic

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.

Abrasive Blast Cleaning

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of Intercryl 525, 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.

Primed Surfaces

Intercryl 525 can be applied over approved anti-corrosive primers. The primer surface should be dry and free from all contamination and Intercryl 525 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 525.

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 175 kg/cm ² (2489 p.s.i.)	
Air Spray (Pressure Pot)	Suitable	Gun	DeVilbiss MBC or JGA
		Air Cap	704 or 765
		Fluid Tip	E
Brush	Suitable	Typically 50 microns (2.0 mils) can be achieved	
Roller	Suitable	Typically 50 microns (2.0 mils) can be achieved	
Thinner	Clean Water or International GTA991	Do not thin more than allowed by local environmental legislation	
Cleaner	Clean Water or 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.		

Water Based Acrylic

PRODUCT CHARACTERISTICS

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.

Application by other methods, e.g. brush or roller, may require more than one coat and should only be used for small areas or touch-up work.

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 525 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.

For brush and roller application, and in some colours, two coats of Intercryl 525 may be required to give uniform coverage.

Although Intercryl 525 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).

Intercryl 525 must be fully cured before exposing to ponding water otherwise adhesion loss can occur.

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

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 as a primer/finish for a water based acrylic paint system. However, it can also be used for application as a semi gloss finish on a wide variety of water based and solvent based primers.

Typical water based primers:

InterH2O 280	InterH2O 499
InterH2O 401	

Typical solvent based primers:

Intergard 242	Interzinc 12
Intergard 251	Interzinc 22
Intergard 269	Interzinc 42
Interplate 11	Interzinc 52
Interplate 240	Interzinc 315
Interplate 398	

Typical water based topcoats:

Intercryl 530	Intercryl 700
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For other suitable primers/topcoats, consult International Protective Coatings.

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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	20 litre
For availability of other pack sizes, contact International Protective Coatings.			
SHIPPING WEIGHT (TYPICAL)	Unit Size		
	20 litre	28.1 kg	
	Non Hazardous		
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. 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.

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