

Alkyd

PRODUCT DESCRIPTION

A single component, fast drying general purpose high gloss enamel for steel structures and equipment.

Dries to a hard film after a very short time.

Provides a brilliant gloss finish with excellent durability.

INTENDED USES

As a fast drying high gloss structural spraying enamel.

Suitable for fixed machinery, equipment, structural steel and sheet steel.

PRACTICAL INFORMATION FOR INTERLAC 649

Colour	White, AS2700 colours available via the Chromascan System.
Gloss Level	High Gloss
Volume Solids	43% ± 2%
Typical Thickness	35-65 microns (1.4-2.6 mils) dry equivalent to 81-151 microns (3.2-6 mils) wet
Theoretical Coverage	8.60 m ² /litre at 50 microns d.f.t and stated volume solids 345 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

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
10°C (50°F)	40 minutes	10 hours	10 hours	Extended ¹
15°C (59°F)	30 minutes	8 hours	8 hours	Extended ¹
25°C (77°F)	20 minutes	6 hours	6 hours	Extended ¹
40°C (104°F)	15 minutes	4 hours	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 60% relative humidity

REGULATORY DATA

Flash Point (Typical)	>10°C (50°F)	
Product Weight	1.15 kg/l (9.6 lb/gal)	
VOC	455 g/l	Calculated

See Product Characteristics section for further details

Protective Coatings

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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.

Primed Surfaces

Interlac 649 should always be applied over a recommended anti-corrosive coating scheme. The primer surface should be dry and free from all contamination and Interlac 649 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 Interlac 649.

APPLICATION

Mixing	This material is a one component coating and should always be mixed thoroughly with a power agitator before application.		
Airless Spray	Recommended	Tip Range 0.25-0.36 mm (10-14 thou) Total output fluid pressure at spray tip not less than 141 kg/cm ² (2005 p.s.i.)	
Air Spray (Pressure Pot)	Recommended	Gun	DeVilbiss MBC or JGA
		Air Cap	704 or 765
		Fluid Tip	E
Brush	Suitable - small areas only	Typically 75 microns (3.0 mils) can be achieved	
Roller	Not recommended		
Thinner	International GTA007 (or International GTA004)	Do not thin more than allowed by local environmental legislation	
Cleaner	International GTA007		
Work Stoppages	Thoroughly flush all equipment with International GTA007. 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 GTA007. 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

Airless spray application at factory can easily lead to over-application with slow through drying and difficulty in handling. Over-application can also cause wrinkling on overcoating after ageing.

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

As with all alkyd systems, Interlac 649 has limited chemical and solvent resistance and is not suitable for use in immersion situations or in conditions of continuous condensation.

Interlac 649 is not designed for application over epoxies or polyurethanes, and should not be applied over zinc based primers because of dangers of saponification of the alkyd resin and consequent adhesion loss.

For brush and roller application, and in some colours, two coats of Interlac 649 may be required to give uniform coverage.

In hot or windy conditions where a slower solvent is required, GTA004 can be used.

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

Interlac 649 is only suitable for application over alkyd or oleoresinous priming systems, e.g.:

Interprime 198
Interprime 371
Interprime 484
Interprime 741

Interlac 649 is only suitable for overcoating with itself or other mineral spirits based primers or finishes.

For other suitable primers, 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
4 litre	4 litre	4 litre	

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

SHIPPING WEIGHT (TYPICAL)	Unit Size	
	20 litre	23 kg
4 litre	4.6 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

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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