

## Water Borne Acrylic

### FORMERLY FLEXCRETE METAL-PRIME WB

#### PRODUCT DESCRIPTION

A single component, water-based (VOC free), epoxy and acrylic-based anti-corrosion primer. Intercrete 4813 is a phosphate free formulation which forms a distinctive oxide red film upon application, ensuring even coverage of the substrate. Extremely effective at preventing flash rusting and rust creep around holidays or areas of damage.

#### INTENDED USES

Ultimately designed to prime substrates and promote adhesion prior to the application of Intercrete high performance coatings. Intercrete 4813 is a single component product and is compatible with a wide range of ferrous, non-ferrous metals and difficult to adhere to substrates including steel, lead, zinc, aluminium, copper, flashband, bitumen paint and roofing felt. It is ideally suited for use in combination with the Intercrete range of cold applied liquid roofing system for the anti-corrosion protection of roofs with metallic protrusions.

#### PRACTICAL INFORMATION FOR INTERCRETE 4813

<b>Volume Solids</b>	47%			
<b>Density</b>	1.2kg/l (10lb/gal)			
<b>Typical Thickness</b>	Approximately 50 microns (2 mils) dry film thickness per coat.			
<b>Practical Coverage</b>	A 5kg unit will cover approximately 40-50m <sup>2</sup> 10m <sup>2</sup> per litre maximum on smooth surfaces 8m <sup>2</sup> per litre on uneven surfaces.			
	A heavy blast profile and other deeply textured or highly irregular surfaces may require a second coat of primer to ensure full coverage.			
<b>Method of Application</b>	Brush, Roller, Spray			
<b>Shelf Life</b>	12 months at 20°C (68°F).			
<b>Pack Size</b>	5 litre units			
<b>Drying Time</b>	Overcoating interval with self			
<b>Temperature</b>	<b>Touch Dry</b>	<b>Hard Dry</b>	<i>Minimum</i>	<i>Maximum</i>
20°C (68°F)	1	30 minutes	30 minutes	24 hours

<sup>1</sup> Not applicable

#### COMPLIANCE AND CERTIFICATION

When used as part of an approved scheme, this material has the following certification:



## Protective Coatings

## Water Borne Acrylic

### SURFACE PREPARATION

#### Steel

All surfaces to be coated should be clean and free from contamination. Prior to application all surfaces should be assessed and treated in accordance with ISO 8504:2000. Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. Where environmental constraints preclude blast cleaning, lower forms of preparation are acceptable providing all loose oxides are removed. Handheld power tools capable of achieving the necessary preparation can be used. Metal prepared in this way should be to minimum standard of ISO8501-1 St3 (SSPC-SP3). Arrises and welds should be ground to remove sharp edges. Remove dirt and oils by solvent cleaning or other suitable detergent/cleaner followed by a thorough water rinsing.

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### APPLICATION

#### Mixing

Intercrete 4813 is a one component product and should always be mixed thoroughly prior to use.

#### Airless Spray

Recommended

Tip Range 0.28-0.48 mm (11-19 thou)

Total output fluid pressure at spray tip not less than 176 kg/cm<sup>2</sup> (2500 p.s.i.)

#### Brush

Recommended

For brush application, use wide, soft nylon or bristle brushes.

#### Roller

Recommended

Medium pile sheepskin, sponge or short pile mohair roller or equivalent

#### Work Stoppages / Clean Up

Clean all equipment immediately after use with clean water. 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

#### Steel

Do not apply when temperature is below 3°C (37°F), when raining or if rain likely within expected cure time.

#### Application

Apply one coat by brush, roller or airless spray at a maximum coverage rate of up to 10m<sup>2</sup>/litre on smooth substrates or 8m<sup>2</sup>/litre on more textured substrates. On surfaces with a heavy blast profile and other deeply textured or highly irregular substrates, two coats may be required to ensure coverage. On completion, check carefully for pinholes and spot treat accordingly.

Allow primer to dry prior to overcoating with the chosen membrane as detailed on the individual Product Data Sheet, ideally within 24 hours. Application may take place within 7 days but, if the primer is left any longer, a further coat of Intercrete 4813 should be applied.

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### APPLICATION TIPS

- Rough, porous or irregular substrates will reduce coverage.
- Clean brushes and rollers occasionally during use.
- Clean spray nozzles regularly to avoid blockages.
- When spraying, use appropriate PPE.
- Cold Weather Working (See separate Guide): ≥3°C (37°F) on a rising thermometer, ≥5°C (41°F) on a falling thermometer.
- Protect from prolonged storage at temperature higher than 40°C (104°F).

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### TECHNICAL DATA / MECHANICAL CHARACTERISTICS

Standard and Property	BS EN 1504-2 Requirement	Result
ASTM G85-94 Prohesion (primer only)		No corrosion after 1250 hours
Immersion (continuous) in Salt Water, 40°C (104°F)		No corrosion after 1500 hours
ASTM D522 Method A Flexibility (conical mandrel)		Remains intact
BS EN ISO 11507:2007 Accelerated Weathering		No blistering, cracking or flaking after 4000 hours
BS 3900-2:1986 Scratch Resistance		Pass with 2.5kg weight

**Note:** The properties given above are obtained from laboratory tests: results obtained from on-site testing may vary according to site conditions.

### 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 Safety Data Sheet and the container(s), and should not be used without reference to the Safety Data Sheet (SDS).

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.

### 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.*

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