

# Intercryl 428

Water borne acrylic

## Product Description

Single pack heavy duty, high build water borne acrylic emulsion which provides excellent pliability and elasticity, allowing appreciable substrate movement without cracking.

Intercryl 428 has been designed to give excellent resistance to gas diffusion and water vapour transmission.

## Intended Uses

For application to a wide range of substrates, including off form concrete and cement rendered structures, where a tough, flexible, weatherproof finish is required. Other typical uses include:

Coating internals and externals of silos and grain storage sheds to provide gas tight seals and heat reflectance  
Roof refurbishment

## Practical Information for Intercryl 428

<b>Colour</b>	White. Colours manufactured to order
<b>Gloss Level</b>	Low sheen
<b>Volume Solids</b>	52%
<b>Typical Thickness</b>	100-300 microns (4-12 mils) dry equivalent to 190-580 microns (7.6-23.2 mils) wet
<b>Theoretical Coverage</b>	2.6 m <sup>2</sup> /litre at 200 microns d.f.t and stated volume solids 106 sq.ft/US gallon at 8 mils d.f.t and stated volume solids
<b>Practical Coverage</b>	Allow appropriate loss factors
<b>Method of Application</b>	Airless spray, Brush or Roller
<b>Drying Time</b>	

Temperature	Touch Dry*	Hard Dry*	Overcoating Interval recommended topcoats	
			<i>Minimum</i>	<i>Maximum</i> †
10°C (50°F)	3 hours	12 hours	12 hours	Extended †
15°C (59°F)	2 hours	8 hours	8 hours	Extended †
25°C (77°F)	1 hour	4 hours	4 hours	Extended †
40°C (104°F)	30 minutes	2 hours	2 hours	Extended †

\* Drying times are dependent upon ambient conditions. The figures quoted above have been determined at the quoted temperature and 60% relative humidity.

† See International Protective Coatings Definitions & Abbreviations.

## Regulatory Data

<b>Flash Point</b>	>101°C (>214°F)
<b>Product Weight</b>	1.35 kg/l (11.3 lb/gal)
<b>VOC</b>	542 g/l (calculated) 43 g/l (water reduced)

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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 8504:1992. Strict adherence to all cleanliness standards is essential for application of water based coatings.

### Steel

Intercryl 428 should always be applied over a recommended anti-corrosive coating scheme. The primer surface should be dry and free from all contamination, and Intercryl 428 must be applied within the overcoating intervals specified (consult the relevant product data sheet).

### Galvanised

Degrease to SSPC-SP1 and remove any white zinc corrosion products by hand abrasion cleaning. Weathered galvanised steel should have areas of red rust wire brushed to remove loose rust and spot primed with Interzinc 52 or Interplus 356 and degreased as above.

### Concrete

Concrete should be cured for a minimum of 28 days prior to coating. The moisture content of the concrete should be below 6%. All surfaces should be clean, dry and free from curing compounds, release agents, trowelling compounds, surface hardeners, efflorescence, grease, oil, dirt, old coatings and loose or disintegrating concrete. All poured and pre-cast concrete must also be swept blasted (preferred) or acid etched to remove laitence. Large cracks should be filled with a suitable filler. When coating new tilt formed concrete, an epoxy sealer must be employed.

## Application

<b>Mixing</b>	This material is a one component coating and should always be mixed thoroughly with a power agitator before application.	
<b>Mix Ratio</b>	Not applicable	
<b>Working Pot Life</b>	Not applicable	
<b>Airless Spray</b>	Recommended	- Tip range 0.48-0.64 mm (19-25 thou) - Total output fluid pressure at spray tip not less than 211 kg/cm <sup>2</sup> (3.000 p.s.i.) - Do not thin
<b>Air Spray (Pressure Pot)</b>	Not recommended	
<b>Brush</b>	Suitable for small areas	Typically 75 microns (3 mils) can be achieved
<b>Roller</b>	Recommended	Typically 75 microns (3 mils) can be achieved
<b>Thinner</b>	Water	
<b>Cleaner</b>	International GTA991	
<b>Work Stoppages</b>	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.	
<b>Clean Up</b>	Clean all equipment immediately after use with water followed by International GTA991.  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

Apply by airless spray. Thoroughly flush equipment with International GTA991 thinner followed by water prior to use. To obtain maximum edge protection and film build, airless spray application is recommended. Application by other methods, e.g. brush or roller, may require more than one coat.

If applying Intercryl 428 by brush or roller, material should be flowed on rather than brushed out.

Application by brush or roller will usually not result in a smooth film.

With all water based coatings careful control of application conditions is required to ensure good long-term performance. International Protective Coatings have available a set of working procedures relating to the application of water borne paints which are available on request.

The following basic parameters must be adhered to:

Intercryl 428 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 that are difficult to ventilate should be brush applied to prevent over-application.

Application below the minimum film forming temperature (M.F.F.T. = 5°C) of the coating and/or poor ventilation will result in poor film coalescence and will result in a powdery cracked film that will require removal and re-application.

## Systems Compatibility

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The following primers are recommended for Intercryl 428 when applied to steel.

### Water Borne

Interzinc 99  
Interprime 371

### Solvent Borne

Interzinc 12	Intercure 200
Interzinc 22	Intergard 251
Interzinc 42	Interzinc 315
Interzinc 52	Interplus 356
Interzinc 251	Interseal 670 HS

This product is self priming over appropriately prepared concrete and galvanised substrates

The following topcoats are recommended for Intercryl 428

Intercryl 530  
Interthane 80

For other suitable primers/topcoats, please 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 sections of the International Protective Coatings data manual:

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage

Individual copies of the following information are available upon request.

- Water Borne Coatings Recommended Working Procedures

## 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.

<b>Pack Size</b>	20 litre unit	20 litres in a 20 litre steel container
	5 gallon unit	5 gallons in a 5 gallon steel container
For availability of other pack sizes contact International Protective Coatings		
<b>Shipping Weight</b>	U.N. Shipping No. 1263	
	20 litre unit	28.5 kg (62.7 lb)
	5 gallon unit	26.9 kg (59.3 lb)
<b>Storage</b>	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.

## Disclaimer

*The information given in this sheet is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. Any warranty, if given, or specific Terms & Conditions of Sale are contained in International's Terms & Conditions of Sale, a copy of which can be obtained on request. Whilst we endeavour to ensure that all advice we give about the product (whether in this sheet or otherwise) is correct we have no control over either the quality or 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 whatsoever or howsoever arising for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of the use of the product. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.*

*It is the user's responsibility to check that this sheet is current prior to using the product. Issue date: 01/10/1998*

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## International Protective Coatings

World Centre	Asia Region	Australasia Region	Europe Region	Middle East Region	North America Region	South America Region
50 George Street London W1A 2BB England	3 Neythal Road Jurong Town Singapore 628570	115 Hyde Road Yeronga Brisbane Queensland Australia	50 George Street London W1A 2BB England	PO Box 37 Dammam 31411 Saudi Arabia	6001 Antoine Drive Houston Texas 77091	Rua Gomes de Carvalho, 1356, 15° Andar, Vila Olimpia, São Paulo, S.P. CEP: 04547-005 Brazil
Tel: (44) 171 612 1400 Fax: (44) 171 612 1561	Tel: (65) 663 3066 Fax: (65) 266 5287	Tel: (61) 7 3892 8866 Fax: (61) 7 3892 4287 H&S (61) 1800 807 001	Tel: (44) 171 612 1410 Fax: (44) 171 612 1555	Tel: (966) 3 842 8436 Fax: (966) 3 842 4361	Tel: (1) 713 682 1711 Fax: (1) 713 684 1327	Tel: (011) 3044 0344 Fax: (011) 3044 0322

### Local Office:

Tel: (61) 7 3892 8888 Fax: (61) 7 3848 8757  
New Zealand (0800 801 342)