

PRODUCT DESCRIPTION

A single component, general purpose alkyd based anti-corrosive primer containing no lead or chromate based pigments.

INTENDED USES

As a single versatile primer for application to general steelwork in a wide range of environmental conditions.

PRACTICAL INFORMATION FOR INTERPRIME 409

Colour	Red
Gloss Level	Matt
Volume Solids	53%
Typical Thickness	50-75 microns (2-3 mils) dry equivalent to 94-142 microns (3.8-5.7 mils) wet
Theoretical Coverage	10.60 m ² /litre at 50 microns d.f.t and stated volume solids 425 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 , Roller

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			<i>Minimum</i>	<i>Maximum</i>
5°C (41°F)	4 hours	24 hours	24 hours	Extended ¹
15°C (59°F)	3 hours	20 hours	20 hours	Extended ¹
25°C (77°F)	2 hours	16 hours	16 hours	Extended ¹
40°C (104°F)	30 minutes	8 hours	8 hours	Extended ¹

¹ See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point	>32°C (90°F)	
Product Weight	1.36 kg/l (11.3 lb/gal)	
VOC	92 g/kg	EU Solvent Emissions Directive (Council Directive 1999/13/EC)
	403 g/l	UK - PG6/23(04), Appendix 3

See Product Characteristics section for further details

**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.

Abrasive Blast Cleaning

Abrasive grit blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of Interprime 409, 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 409 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.

Shop Primed Surfaces

Weld seams and damaged areas should be blast cleaned to Sa2½ (ISO 8501-1:2007) or SSPC-SP6.

If the shop primer shows extensive or widely scattered breakdown overall sweep blasting may be necessary.

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 0.38-0.48 mm (15-19 thou) Total output fluid pressure at spray tip not less than 176 kg/cm ² (2503 p.s.i.)
Air Spray (Conventional)	Recommended	Use suitable proprietary equipment
Brush	Recommended	Typically 25-50 microns (1.0-2.0 mils) can be achieved
Roller	Recommended	Typically 25-50 microns (1.0-2.0 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.	

**PRODUCT
CHARACTERISTICS**

Two coats of Interprime 409 will be required to give satisfactory build and performance.

When applying Interprime 409 by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

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

When applying Interprime 409 in confined spaces ensure adequate ventilation.

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

Interprime 409 is not designed for continuous water immersion.

Interprime 409 is not suitable for exposure to acid or alkaline environments.

Over-application of Interprime 409 will extend both the minimum overcoating periods and handling times, and may be detrimental to long term overcoating properties.

Where a durable cosmetic finish with good gloss and colour retention is required overcoat with recommended topcoats.

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**

For suitable primers or topcoats, please consult International Protective Coatings.

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
5 litre	5 litre	5 litre	
For availability of other pack sizes, contact International Protective Coatings.			
SHIPPING WEIGHT	Unit Size		
	20 litre	29.1 kg	
	5 litre	7.3 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.	

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 International Paint representative that this data sheet is current prior to using the product.

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