

Alkyd

PRODUCT DESCRIPTION

Interprime 406 is a fast drying alkyd primer containing zinc phosphate anti-corrosive pigmentation, designed for application to all types of steel surfaces.

This primer is characterised by good anti-corrosive properties, easy application and the ability to protect hand cleaned steel.

INTENDED USES

Shop priming of structural steel, girders, plates and pre-fabricated structures.

Field priming of all steel structures such as building frames, bridges, towers and tanks.

PRACTICAL INFORMATION FOR INTERPRIME 406

Colour	Red Oxide, Grey
Gloss Level	Low Gloss
Volume Solids	47%
Typical Thickness	40 microns (1.6 mils) dry equivalent to 85 microns (3.4 mils) wet
Theoretical Coverage	11.75 m ² /litre at 40 microns d.f.t and stated volume solids 471 sq.ft/US gallon at 1.6 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
15°C (59°F)	45 minutes	6 hours	8 hours	Extended ¹
25°C (77°F)	30 minutes	4 hours	6 hours	Extended ¹
40°C (104°F)	20 minutes	2 hours	4 hours	Extended ¹

¹ See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical)	23°C (73°F)
Product Weight	1.3 kg/l (10.8 lb/gal)
VOC	3.92 lb/gal (470 g/lit) EPA Method 24

See Product Characteristics section for further details

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SURFACE PREPARATION

The performance of this product will depend upon the degree of surface preparation. The surface to be coated must be clean, dry and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2000.

Accumulated dirt and soluble salts must be removed. Dry bristle brushing will normally be adequate for accumulated dirt. Soluble salts should be removed by fresh water washing.

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

The product is designed for application to surfaces prepared to St2 (ISO 8501-1:2007) or SSPC SP2. When using power tools care should be taken to avoid surface polishing. The product may also be applied to surfaces which have been brush blasted to Sa1 (ISO 8501-1:2007) or SSPC-SP7.

On surfaces prepared to St2 (ISO 8501-1:2007) or SSPC-SP2, brush application will assist surface wetting and improve subsequent coating performance.

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 0.43-0.53 mm (17-21 thou) Total output fluid pressure at spray tip not less than 176 kg/cm ² (2503 p.s.i.)	
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E
Brush	Suitable - small areas only	Typically 25-25 microns (1.0-1.0 mils) can be achieved	
Roller	Suitable - small areas only	Typically 25-25 microns (1.0-1.0 mils) can be achieved	
Thinner	International GTA007	Do not thin more than allowed by local environmental legislation	
Cleaner	International GTA007		
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA007. Partially filled containers may show surface skinning and/or a viscosity increase of the material after storage.		
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

Interprime 406 will provide acceptable levels of corrosion protection in mild to moderate environments, with the level of performance depending on the degree of surface preparation and total system dry film thickness.

Interprime 406 based systems are not suitable for service in wet or aggressive environments. Alternative systems should be considered for these areas.

Do not apply if temperature is less than 10°C (50°F), relative humidity exceeds 85% or temperature is within 3°C (5°F) of dew point.

For brush and roller application, two coats of Interprime 406 may be required to give uniform coverage

Interprime 406 has excellent holdup characteristics and may be applied at 75 microns (3 mils) dry film thickness where additional corrosion protection is required.

Interprime 406 can be applied by dipping methods provided that the viscosity is correctly adjusted and the incidence of runs and sags can be controlled.

SYSTEMS COMPATIBILITY

The following topcoats are recommended for Interprime 406:

- Intergard 740
- Interlac 87
- Interlac 191
- Interlac 665
- Interthane 990
- Intertherm 891

For other suitable 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
	5 litre	5 litre	5 litre
	20 litre	20 litre	20 litre
For availability of other pack sizes, contact International Protective Coatings.			
SHIPPING WEIGHT (TYPICAL)	Unit Size		
	20 litre	30 kg	
	5 litre	7.5 kg	
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.	

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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