

High Temperature Silicone Acrylic

PRODUCT DESCRIPTION

A single component, intermediate temperature finish based on temperature resistant silicone and acrylic resins with thermally stable pigmentation.

Intertherm 1875 has excellent brush and roll characteristics.

INTENDED USES

For use in a wide range of industrial environments including petrochemical plants, oil refineries, offshore structures, chemical plants and power stations. Suitable for areas subject to intermediate service temperature that require a coloured finish.

A heat resistant finish coat for application over properly primed steelwork. For use at both new construction and as a maintenance coating.

Suitable for steelwork operating at temperatures up to 260°C (500°F). Does not require heating between coats.

PRACTICAL INFORMATION FOR INTERTHERM 1875

Colour White, Black, Grey, Aluminium (Colours available on request)

Gloss Level Gloss

Volume Solids 57%

Typical Thickness 25-50 microns (1-2 mils) dry equivalent to
44-88 microns (1.8-3.5 mils) wet

Theoretical Coverage 11.40 m²/litre at 50 microns d.f.t and stated volume solids
457 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, Conventional Spray, Roller

Drying Time

Overcoating interval with self

| Temperature | Touch Dry | Hard Dry | Minimum | Maximum |
|--------------|------------|------------|------------|-----------------------|
| 10°C (50°F) | 40 minutes | 9 hours | 4 hours | Extended ¹ |
| 25°C (77°F) | 20 minutes | 5 hours | 2 hours | Extended ¹ |
| 40°C (104°F) | 8 minutes | 60 minutes | 60 minutes | Extended ¹ |

¹ See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical) 26°C (79°F)

Product Weight 1.28 kg/l (10.7 lb/gal)

VOC 3.28 lb/gal (394 g/l) EPA Method 24

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.

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

Abrasive Blast Cleaning

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP10. If oxidation has occurred between blasting and application of Intertherm 1875, 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.

Intertherm 1875 can be applied over approved anti-corrosive primers. The primer surface should be dry and free from all contamination, and Intertherm 1875 must be applied within the overcoating intervals specified (consult the relevant product data sheet).

In the case of zinc primers, where necessary, remove weld spatter, smooth weld seams and sharp edges and blast clean welds and damaged areas to Sa2½ (ISO 8501-1:2007) or SSPC-SP10. The shop primer or other primer surface should be dry and free of all contamination (oil, grease, salt etc) and overcoated with Intertherm 1875 within the overcoating intervals specified for the primer (consult the relevant product data sheet).

Weld seams and damaged areas should be blast cleaned to Sa2½ (ISO 8501-1:2007) or SSPC-SP10.

Ensure the zinc primer has fully cured and is clean, dry and free from zinc salts prior to overcoating.

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. | | |
| Airless Spray | Suitable | Tip Range 0.38-0.48 mm (15-19 thou) Total output fluid pressure at spray tip not less than 127 kg/cm ² (1806 p.s.i.) | |
| Air Spray (Pressure Pot) | Recommended | Gun | DeVilbiss MBC or JGA |
| | | Air Cap | 704 or 765 |
| | | Fluid Tip | E |
| Air Spray (Conventional) | Recommended | Use suitable proprietary equipment | |
| Brush | Suitable - small areas only | | |
| Roller | Recommended | Use a phenolic core roller only | |
| Thinner | International GTA007 (or International GTA013) | | |
| Cleaner | International GTA007 (or International GTA013) | | |
| Work Stoppages | Thoroughly flush all equipment with International GTA007 or GTA013. 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 or GTA013. 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

For optimum corrosion protection at temperatures up to 260°C (500°F) Intertherm 1875 should be applied over an inorganic zinc silicate primer. The preferred system for use with inorganic zinc silicate is to apply a mist coat followed by a full coat of Intertherm 1875 at 40 microns (1.6 mils) dry film thickness. Application of two full coats can sometimes result in pinholes in the topcoat.

When overcoating weathered zinc silicate primers the surface should be clean, free from contamination, and the presence of zinc corrosion products.

This material is air drying and is suitable for application both in the fabrication yard and on-site where stoving facilities are not available.

Over-application can lead to blistering and cracking at high temperatures, if applied in excess of the recommended DFT range.

Some minor colour and gloss changes will be visible upon high heat exposure.

Note that some yellowing will occur with prolonged exposure of the white finish to temperatures of 260°C (500°F).

Maximum continuous dry temperature resistance for Intertherm 1875 is 260°C (500°F).

Intertherm 1875 can be applied to substrates with surface temperatures at time of application up to 48°C (120°F).

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.

Low molecular weight reactive additives, which will form part of the film during normal ambient cure conditions, will also affect VOC values determined using EPA Method 24.

SYSTEMS COMPATIBILITY

This specialist material is not normally topcoated, and is only compatible with a very limited number of primers.

Suitable primers are:

- Interbond 1202UPC
- Interzinc 22
- Interzinc 22HS
- Interzinc 2265
- Interzinc 2277
- Interzinc 2280

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 |
| | 5 US gal | 5 US gal | 5 US gal |
| For availability of other pack sizes, contact International Protective Coatings. | | | |
| SHIPPING WEIGHT (TYPICAL) | Unit Size | | |
| | 5 US gal | 57.7 lb | |
| 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 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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