

## Polyurethane

### PRODUCT DESCRIPTION

A two component, fast drying, acrylic polyurethane primer/finish giving excellent corrosion resistance and durability.

### INTENDED USES

Interthane 1014 provides a combination of anti-corrosive barrier protection, durability and cosmetic finish.

Suitable for use in OEM applications; pumps, valves, machinery, etc. Interthane 1014 is also suitable for use in new construction and as a maintenance finish.

### PRACTICAL INFORMATION FOR INTERTHANE 1014

<b>Colour</b>	Limited range
<b>Gloss Level</b>	Semi-gloss
<b>Volume Solids</b>	45% ± 3% (depends on colour)
<b>Typical Thickness</b>	40-60 microns (1.6-2.4 mils) dry equivalent to 89-133 microns (3.6-5.3 mils) wet
<b>Theoretical Coverage</b>	9 m <sup>2</sup> /litre at 50 microns d.f.t and stated volume solids 361 sq.ft/US gallon at 2 mils d.f.t and stated volume solids
<b>Practical Coverage</b>	Allow appropriate loss factors
<b>Method of Application</b>	Airless Spray, Air Spray, Brush, Roller, Conventional Spray

#### Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
15°C (59°F)	3 hours	16 hours	16 hours	Extended <sup>1</sup>
25°C (77°F)	20 minutes	8 hours	8 hours	Extended <sup>1</sup>
40°C (104°F)	20 minutes	7 hours	8 hours	Extended <sup>1</sup>

<sup>1</sup> See International Protective Coatings Definitions and Abbreviations

### REGULATORY DATA

<b>Flash Point (Typical)</b>	Part A 25°C (77°F); Part B 49°C (120°F); Mixed 29°C (84°F)
<b>Product Weight</b>	1.18 kg/l (9.8 lb/gal)
<b>VOC</b>	490 g/lit      Calculated

See Product Characteristics section for further details

## Polyurethane

### SURFACE PREPARATION

The performance of this product will depend upon the degree of surface preparation. Best performance will always be achieved when Interthane 1014 is applied to surfaces prepared by abrasive blast cleaning.

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.

#### Steel Substrates

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP10. If oxidation has occurred between blasting and application of Interthane 1014, 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.

#### Hand or Power Tool Preparation

Hand or power tool clean to a minimum St2 (ISO 8501-1:2007) or SSPC-SP2.

#### Pretreatment

Interthane 1014 may be applied over surfaces which have been prepared by phosphating or by using 3-in-1 solution.

### APPLICATION

<b>Mixing</b>	Material is supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. Once the unit has been mixed it must be used within the working pot life specified.		
	(1)	Agitate Base (Part A) with a power agitator.	
	(2)	Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.	
<b>Mix Ratio</b>	6 part(s) : 1 part(s) by volume		
<b>Working Pot Life</b>	15°C (59°F)	25°C (77°F)	40°C (104°F)
	3 hours	90 minutes	60 minutes
<b>Airless Spray</b>	Recommended	Tip Range 0.33-0.45 mm (13-18 thou) Total output fluid pressure at spray tip not less than 155 kg/cm <sup>2</sup> (2204 p.s.i.)	
<b>Air Spray (Pressure Pot)</b>	Recommended	Gun	DeVilbiss MBC or JGA
		Air Cap	704 or 765
		Fluid Tip	E
<b>Air Spray (Conventional)</b>	Recommended	Use suitable proprietary equipment	
<b>Brush</b>	Suitable	Typically 30-40 microns (1.2-1.6 mils) can be achieved	
<b>Roller</b>	Suitable	Typically 30-40 microns (1.2-1.6 mils) can be achieved	
<b>Thinner</b>	International GTA733	Do not thin more than allowed by local environmental legislation	
<b>Cleaner</b>	International GTA733		
<b>Work Stoppages</b>	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA733. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units.		
<b>Clean Up</b>	Clean all equipment immediately after use with International GTA733. 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.		

## Polyurethane

### PRODUCT CHARACTERISTICS

Level of sheen and surface finish are dependent on application method. Avoid using a mixture of application methods. Best results in terms of gloss and appearance will always be obtained with conventional air spray application.

For brush application, two coats of Interthane 1014 may be required to give uniform coverage.

Apply in good climatic conditions. The temperature of the surface to be coated must be at least 3°C (5°F) above the dew point. Do not apply at steel temperatures below 5°C (41°F). When applying Interthane 1014 in confined spaces ensure adequate ventilation.

When overcoating after weathering or ageing, ensure the coating is fully cleaned to remove all surface contamination before application of a further coat of Interthane 1014

Absolute measured adhesion of topcoats to aged Interthane 1014 is less than that to fresh material, however, it is adequate for the specified end use.

Condensation occurring during or immediately after application may result in a matt finish and an inferior film.

This product is not recommended for use in immersion conditions. When severe chemical or solvent splashing is likely to occur contact International Protective Coatings for information regarding suitability.

Special textured finishes are also available up on request. Please consult International Protective Coatings for more details.

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

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Interthane 1014 is suitable for use over the following primers:

Intercure 200HS	Intergard 251
Intergard 1032	

Interthane 1014 may be overcoated with the following products:-

Interthane 990

For other suitable primers/topcoats, consult International Protective Coatings.

## Polyurethane

### 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](http://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.

**Warning: Contains isocyanate. Wear air-fed hood for spray application.**

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	20 litre	17.14 litre	20 litre	2.86 litre	5 litre
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
		kg		kg	
	20 litre	22.9		3.4	
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.*

*This Technical Data Sheet is available on our website at [www.international-marine.com](http://www.international-marine.com) or [www.international-pc.com](http://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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