

Interfine 629 HS

Modified Acrylic

WORLD WIDE PRODUCT RANGE

Product Description

A low VOC, high performance, two component, isocyanate free crosslinking acrylic finish which provides good durability in terms of colour and gloss retention.

Intended Uses

Designed as a finish coat for use in both new construction and industrial maintenance. For use in a wide variety of aggressive environments including offshore structures, petrochemical facilities, bridges, pulp and paper mills, and power plants.

Suitable for both site and factory application situations and is ideal where legislation prevents the use of isocyanates and restricts solvent levels.

Practical Information for Interfine 629 HS

Colour	Wide range available via Chromascan			
Gloss Level	High Gloss			
Volume Solids	65% ± 3% (depends on colour)			
Typical Thickness	50 microns (2 mils) dry equivalent to 77 microns (3.1 mils) wet			
Theoretical Coverage	13.0 m ² /litre at 50 microns d.f.t and stated volume solids 521 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	<div>Overcoating Interval</div> <div>Interfine 629 HS with Self</div> <div>Minimum Maximum</div>			
Temperature	Touch Dry	Hard Dry		
10°C (50°F)	2 hours	30 hours	30 hours	Extended*
15°C (59°F)	90 minutes	24 hours	24 hours	Extended*
25°C (77°F)	60 minutes	18 hours	18 hours	Extended*
40°C (104°F)	45 minutes	6 hours	6 hours	Extended*

* See International Protective Coatings Definitions & Abbreviations

Regulatory Data

Flash Point	Base (Part A) 32°C (90°F)	C/A (Part B) 40°C (104°F)	Mixed 40°C (104°F)
Product Weight	1.5 kg/l (12.7 lb/gal)		
VOC	335 g/l	UK - PG6/23(92), Appendix 3	
	2.80 lb/gal (336 g/l)	USA - EPA Method 24	



Ecotech is an initiative by International Protective Coatings a world leader in coating technology to promote the use of environmentally sensitive products across the globe.

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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.

Primed Surfaces

Interfine 629 HS should always be applied over a recommended anti-corrosive coating scheme. The primer surface should be dry and free from all contamination, and Interfine 629 HS must be applied within the overcoating intervals specified (consult the relevant product data sheet).

Areas of breakdown, damage etc., should be prepared to the specified standard (e.g. Sa2½ (ISO 8501-1:1988), SSPC-SP6, Abrasive Blasting, or SSPC-SP11, Hand/Power Cleaning) and patch primed prior to the application of Interfine 629 HS.

Application

Mixing	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.			
Mix Ratio	7 parts : 1 part by volume			
Working Pot Life	10°C (50°F) 10 hours	15°C (59°F) 5 hours	25°C (77°F) 2 hours	40°C (104°F) 1 hour
Airless Spray	Recommended	- Tip range 0.32-0.48 mm (13-19 thou) - Total output fluid pressure at spray tip not less than 155 kg/cm² (2,200 p.s.i.)		
Air Spray (Pressure Pot)	Recommended	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E	
Air Spray (Conventional)	Suitable	Use suitable proprietary equipment.		
Brush	Suitable	Typically 40-50 microns (1.5-2.0 mils) can be achieved		
Roller	Suitable	Typically 40-50 microns (1.5-2.0 mils) can be achieved		
Thinner	International GTA220 (or GTA415)	Do not thin more than allowed by local environmental legislation.		
Cleaner	International GTA822 (or GTA 415)			
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA822. 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.			
Clean Up	Clean all equipment immediately after use with International GTA822. 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

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

For brush and roller application, and in some colours, two coats of Interfine 629 HS may be required to give uniform coverage. This is particularly true for bright colours such as oranges or yellows when using lead-free pigments. Best practice is to use a colour compatible intermediate or anti-corrosive coating under the Interfine 629 HS.

When overcoating after weathering or ageing, ensure coating is fully cleaned down to remove all surface contamination such as oil, grease, salt crystals and traffic fumes, before application of a further coat of Interfine 629 HS.

This product will not cure adequately below 5°C (41°F). For maximum performance ambient curing temperatures should be above 10°C (50°F).

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

Premature exposure to ponding water will cause colour change, especially in dark colours and when curing occurs at low temperatures.

When applying Interfine 629 HS in confined spaces ensure adequate ventilation.

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

Systems Compatibility

The following primers/intermediates are recommended for Interfine 629 HS:

Intercure 200	Interplus 256	Interzone 505
Intercure 420	Interplus 356	Interzone 954
Intergard 251	Interplus 770	Interzone 1000
Intergard 269	Interseal 670 HS	
Intergard 270	Interzinc 42	
Intergard 401	Interzinc 52	
Intergard 475 HS	Interzinc 315	

Interfine 629 HS is designed only to be topcoated with itself.

For further information on alternative primers/intermediates, 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 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	20 litre unit	Interfine 629 HS Base Interfine 629 HS Curing Agent	17.5 litres in a 20 litre container 2.5 litres in a 2.5 litre container
	5 gallon unit	Interfine 629 HS Base Interfine 629 HS Curing Agent	4.36 gallons in a 5 gallon container 0.63 gallons in a 1 gallon container
	For availability of other pack sizes contact International Protective Coatings		
Shipping Weight	U.N. Shipping No. 1263		
	20 litre unit	30.1 kg (66.4 lb) Base (Part A)	3.0 kg (6.6 lb) Curing Agent (Part B)
	5 gallon unit	28.2 kg (62.3 lb) Base (Part A)	2.9 kg (6.4 lb) Curing Agent (Part B)
Storage	Shelf Life		
	18 months minimum at 25°C (77°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.		

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 from 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: 1st June 1997

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International Protective Coatings

Worldwide Availability

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