

PRODUCT DESCRIPTION

A patented technology, high performance, low VOC single pack acrylic polysiloxane finish coat containing no free isocyanates.

INTENDED USES

Primarily designed for brush and roller application as a maintenance finish coat in industrial and offshore applications such as storage tank externals, pipelines, structural steel and topside structures where a high standard cosmetic appearance is required.

PRACTICAL INFORMATION FOR INTERFINE 1080

Colour Range available via the Chromascan system

Gloss Level Gloss

Volume Solids 68%

Typical Thickness 50-75 microns (2-3 mils) dry equivalent to 74-110 microns (3-4.4 mils) wet

Theoretical Coverage 13.60 m²/litre at 50 microns d.f.t and stated volume solids
545 sq.ft/US gallon at 2 mils d.f.t and stated volume solids

Practical Coverage Allow appropriate loss factors

Method of Application Brush, Roller

Drying Time

Overcoating interval with self

| Temperature | Touch Dry | Hard Dry | Minimum | Maximum |
|--------------|-----------|-----------------------|----------|-----------|
| 5°C (41°F) | 5 hours | 48 hours ¹ | 48 hours | 12 months |
| 15°C (59°F) | 3 hours | 16 hours ¹ | 16 hours | 12 months |
| 25°C (77°F) | 3 hours | 7 hours ¹ | 7 hours | 12 months |
| 40°C (104°F) | 2.5 hours | 6 hours ¹ | 6 hours | 12 months |

¹ Sufficient coating film strength has developed to permit the handling and movement of coated steelwork.

The dry times are influenced by relative humidity. The higher the relative humidity, the faster the dry times. The drying times quoted have been determined at the quoted temperature and 50% relative humidity.

REGULATORY DATA

Flash Point (Typical) 29°C (84°F)

Product Weight 1.51 kg/l (12.6 lb/gal)

VOC 2.29 lb/gal (275 g/l) EPA Method 24
2.09lb/gal (250g/l) EPA Method 24 (Available in North America only)
205 g/kg EU Solvent Emissions Directive (Council Directive 1999/13/EC)

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.

Primed Surfaces

Interfine 1080 should always be applied over a recommended anti-corrosive coating scheme. The primer surface should be dry and free from all contamination and Interfine 1080 must be applied within the overcoating intervals specified (consult the Interfine 1080 Application Guidelines).

Areas of breakdown, damage etc., should be prepared to the specified standard (e.g. Sa2½ (ISO 8501-1:2007) or SSPC-SP6, Abrasive Blasting, or SSPC-SP11, Power Tool Cleaning) and a full coat of primer applied prior to overcoating with Interfine 1080.

Aged Coatings

Interfine 1080 is suitable for overcoating most tightly adherent aged coatings. Loose or flaking coatings should be removed back to a firm edge. Glossy finishes may require light abrasion to provide a physical 'key'. For suitable systems, please refer to Interfine 1080 Application Guidelines.

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 0.28-0.38 mm (11-15 thou) Total output fluid pressure at spray tip not less than 155 kg/cm ² (2204 p.s.i.) Refer to Interfine 1080 Application Guidelines for more details. | |
| Air Spray (Pressure Pot) | Suitable | Gun | DeVilbiss MBC or JGA |
| | | Air Cap | 704 or 765 |
| | | Fluid Tip | E |
| Air Spray (Conventional) | Suitable | Use suitable proprietary equipment | |
| Brush | Recommended | Typically 40-50 microns (1.6-2.0 mils) can be achieved | |
| Roller | Recommended | Typically 40-50 microns (1.6-2.0 mils) can be achieved Best results in terms of gloss and appearance will be achieved using a medium nap roller | |
| Thinner | International GTA007 (or GTA028 in North America Only) | Maximum recommended thinning 2.5% by volume 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. | | |

**PRODUCT
CHARACTERISTICS**

The detailed Interfine 1080 Application Guidelines should be consulted prior to use.

Interfine 1080 is specifically designed for on-site application via brush and roller techniques. Application via airless and air spray methods is suitable. However, care must be taken when spray applying Interfine 1080 to ensure that a continuous wet film thickness of 75 to 100 microns (3 - 4.0 mils) is achieved in order that satisfactory film coalescence can occur.

Level of sheen and surface finish are dependent on application method. Avoid using a mixture of application methods whenever possible.

For brush and roller application, and in some colours, two coats of Interfine 1080 may be required to give uniform coverage, especially when overcoating dark primers/intermediates.

This product must only be thinned using recommended International thinners. The use of alternative thinners, particularly those containing alcohols and ketones, can severely inhibit the curing mechanism of the coating.

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

It is recommended that relative humidity should not exceed 85% during application and cure.

When applying Interfine 1080 in confined spaces ensure adequate ventilation.

Condensation occurring during or immediately after application may result in a matt finish and/or colour change.

When overcoating after weathering or ageing, ensure the coating is fully cleaned to remove all surface contamination before application of a further coat of Interfine 1080.

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.

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**

Interfine 1080 is compatible with a range of primers and intermediates such as, but not limited to:-

| | |
|--|-----------------|
| Intercure 200 | Intercure 200HS |
| Intergard 269 | Intershield 300 |
| Intergard 345 | Interplus 356 |
| Intergard 475HS | |
| Interseal 1079 (Available in North America only) | |
| Interzone 954 (EAA964 Part B must be used) | |

Note: Absolute maximum overcoating interval of Interfine 1080 over approved primers and intermediates is very much product specific, and dependent upon local climate and environmental conditions.

Further information regarding additional compatible primers and intermediates and associated overcoating intervals can be found in the Interfine 1080 Application Guidelines. Always consult your local International Protective Coatings representative for specific recommendations.

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
- Interfine 1080 Application Guidelines

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 |
| | 5 US gal | 5 US gal | 5 US gal |
| | 1 US gal | 1 US gal | 1 US gal |
| For availability of other pack sizes, contact International Protective Coatings. | | | |
| SHIPPING WEIGHT (TYPICAL) | Unit Size | | |
| | 20 litre | 31.98 kg | |
| | 5 litre | 6.65 kg | |
| | 5 US gal | 67 lb | |
| STORAGE | Shelf Life | 12 months 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.

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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