Interfine® 691

Modified Acrylic

PRODUCT DESCRIPTION

A two pack, epoxy acrylic isocyanate free cosmetic finish providing good long term durability. Interfine 691 offers equivalent performance to typical recoatable polyurethane cosmetic finishes.

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.

PRACTICAL INFORMATION FOR INTERFINE 691

Colour	Wide range via the Chromascan system
Gloss Level	High Gloss
Volume Solids	53% ± 3% (depends on colour)
Typical Thickness	50 microns (2 mils) dry equivalent to 94 microns (3.8 mils) wet
Theoretical Coverage	10.60 m²/litre at 50 microns d.f.t and stated volume solids 425 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, Brush, Conventional Spray, Roller

Drying Time

			Overcoating interval with self	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
-5°C (23°F)	6 hours	26 hours	26 hours	Extended[1]
5°C (41°F)	4 hours	22 hours	22 hours	Extended[1]
25°C (77°F)	2 hours	8 hours	8 hours	Extended[1]
35°C (95°F)	1 hour	6 hours	6 hours	Extended[1]

[1] See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical)	Part A 29°C (84°F); Part B 28°C (82°F); Mixed 29°C (84°F)	
Product Weight	1.40 kg/l (11.7 lb/gal)	(depends on colour)
VOC	3.41 lb/gal (409 g/lt)	EPA Method 24
	286 g/kg	EU Solvent Emissions Directive (Council Directive 1999/13/EC)

See Product Characteristics section for further details

Modified Acrylic

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 691 should always be applied over a recommended anti-corrosive coating scheme. The primer surface should be dry and free from all contamination and Interfine 691 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 8501-1:2007) or SSPC-SP6, Abrasive Blasting, or SSPC-SP11, Power Tool Cleaning) and patch primed prior to the application of Interfine 691.

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

2 part(s) : 1 part(s) by volume

Working Pot Life

-5°C (23°F)	5°C (41°F)	25°C (77°F)	35°C (95°F)
8 hours	8 hours	7 hours	6 hours

Airless Spray	Recommended	Tip Range 0.33-0.45 mm (13-18 thou) Total output fluid pressure at spray tip not less than 155 kg/cm² (2204 p.s.i.)
Air Spray (Conventional)	Recommended	Use suitable proprietary equipment.
Brush	Suitable	Typically 30-50 microns (1.2-2.0 mils) can be achieved
Roller	Suitable	Typically 30-50 microns (1.2-2.0 mils) can be achieved
Thinner	Not recommended	Use International GTA007 only in exceptional circumstances (max 5% by volume). DO NOT USE ANY OTHER THINNER. 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. 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 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

Level of sheen and surface finish are 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 691 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 691.

When overcoating after weathering or ageing, ensure the coating is fully cleaned to remove all surface contamination such as oil, grease, salt crystals, traffic fumes and chalking before application of a further coat of Interfine 691.

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

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

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

When applying Interfine 691 in confined spaces ensure adequate ventilation.

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.

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

The following primers/intermediates are recommended for Interfine 691:

Intercure 200	Intercure 200HS
Intercure 384	Intercure 420
Intergard 233	Intergard 251
Intergard 269	Intergard 400
Intergard 410	Intergard 475HS
InterH2O 499	Interplus 356
Interseal 670HS	Intershield 300

Interfine 691 is designed only to be topcoated with itself.

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	Part A		Part B	
		Vol	Pack	Vol	Pack
	15 litre	10 litre	20 litre	5 litre	5 litre
	For availability of other pack sizes, contact International Protective Coatings.				
SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A		Part B	
	15 litre	17.28 kg		5.46 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. Do not store above 35°C (95°F).			

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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